Technical information

preliminary

TEREZ® GT2 300 H G60

Polyarylamide with 60% glass fiber reinforcement and heat stabilization

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TECHNICAL DATA SHEET

Product text

For all kind of injection molding parts

Preliminary data

Properties	Value	Unit	Test method
Density	1,7700	g/cm³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	16	kJ/m²	ISO 179
Impact strength Charpy (Notched 23°), conditioned	17	kJ/m²	ISO 179
Impact strength Charpy 23°C, dry	75	kJ/m²	ISO 179
Impact strength Charpy (23°), conditioned	80	kJ/m²	ISO 179
Tensile-modulus, dry	24000	MPa	ISO 527
Tensile-modulus, conditioned	23000	MPa	ISO 527
Tensile stress at break, dry	280	MPa	ISO 527
Tensile stress at break, conditioned	250	MPa	ISO 527
Elongation at break, dry	1,80	%	ISO 527
Elongation at break, conditioned	2,00	%	ISO 527
HDT 0,45 MPa	245	°C	ISO 75
HDT 1,80 MPa	230	°C	ISO 75
Melting point	237	°C	ISO 11357-3
CTI	600	V	IEC 60112
Electric strength	24,00	kV/mm	IEC 60243-1
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Water absorption	1,30	%	ISO 62
Moisture absorption	0,13	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ GT2 300 H G60

The processing data sheet provides guidelines about processing as well as pre-drying.

MATERIAL PREPARATION

Storage

Store in a dry place protected from direct sunlight. Avoid all sources of ignition like extreme heat, sparks, or open flame.

Drying

For the manufacturing of mechanically and optically optimal injection molding parts, we recommend following pre-drying conditions according to the table below. If the container is open (wet granules), the drying time can be extended accordingly.

Dry air dryer

Temperature	110°C
Time	6 - 8 hours
Due point	-40°C

Residual moisture

<= 0.05% (recommended)
max. 0.1% (standard)

MACHINE REQUIREMENTS

PROCESSING

Basic settings

The following basic settings are generally to be selected:

Temperatures

Processing temperatures

Hopper 60 - 80 ° C
Center 250 - 280 ° C
Nozzle 260 - 290 ° C

Mold temperature

Temp.	120 - 140°C

Residence time

You should try to keep the residence time short, especially at high temperatures to avoid material degradation.

Residence times in the cylinder

max. 265 °C / 8 min.

Instructions for cleaning

The aggregate can be cleaned by using low MFI polypropylene. You can also use standard cleaning granulate.