

# Technical information

## TEREZ<sup>®</sup> PA 6 7510 GF 30

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Medium viscosity polyamide 6 with 30% glass fibre reinforcement.



## TECHNICAL DATA SHEET

### Product text

For moulding parts with high rigidity and good impact strength.

| Properties                                 | Value  | Unit              | Test method |
|--|--------|-------------------|-------------|
| Density                                    | 1,3500 | g/cm <sup>3</sup> | ISO 1183    |
| Impact strength Charpy (Notched 23°C), dry | 13     | kJ/m <sup>2</sup> | ISO 179     |
| Impact strength Charpy 23°C, dry           | 85     | kJ/m <sup>2</sup> | ISO 179     |
| Tensile-modulus, dry                       | 9300   | MPa               | ISO 527     |
| Tensile stress at break, dry               | 175    | MPa               | ISO 527     |
| Elongation at break, dry                   | 2,90   | %                 | ISO 527     |
| HDT 0,45 MPa                               | 220    | °C                | ISO 75      |
| HDT 1,80 MPa                               | 210    | °C                | ISO 75      |
| Burning Behav. at thickness h              | HB     | class             | UL 94       |
| Thickness tested                           | 1,6    | mm                | UL 94       |
| UL recognition                             | -      |                   | UL 94       |
| Water absorption                           | 6,50   | %                 | ISO 62      |
| Moisture absorption                        | 2,10   | %                 | ISO 62      |

## PROCESSING DATA SHEET

### Processing guidelines for injection molding of TEREZ PA 6 7510 GF 30

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 | 80°C        |
| Time        | 4 - 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:

##### Processing temperatures

|        |             |
|--------|-------------|
| Hopper | 60 - 80°C   |
| Center | 240 - 260°C |
| Nozzle | 250 - 270°C |

##### Mold temperature

|       |           |
|-------|-----------|
| Temp. | 40 - 80°C |
|-------|-----------|

#### Temperatures

##### 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 / 10 min.

##### Instructions for cleaning

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