Technical information

preliminary

TEREZ® A 301 G50

Medium viscosity polyamide 6.6 with 50% glass fiber reinforcement.

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TECHNICAL DATA SHEET

Product text

For molded parts with high stiffness.

Preliminary data

Properties	Value	Unit	Test method
Density	1,5600	g/cm³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	16	kJ/m²	ISO 179
Impact strength Charpy 23°C, dry	85	kJ/m²	ISO 179
Tensile-modulus, dry	16000	MPa	ISO 527
Tensile stress at break, dry	177	MPa	ISO 527
Elongation at break, dry	2,00	%	ISO 527
HDT 0,45 MPa	260	°C	ISO 75
HDT 1,80 MPa	250	°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	4,20	%	ISO 62
Moisture absorption	1,20	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ A 301 G50

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	260 - 290°C
Nozzle	270 - 300°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. 280 °C / 8 min.

Instructions for cleaning

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