Technical information

preliminary

TEREZ® GT3 300 H G50 SF

PA66 Blend with partial aromatic share, 50% glass fiber content and heat stabilizer improved flow characteristics

TER Plastics POLYMER GROUP

TER® GROUP

[HongKong] +852-69575415 [China GuangDong] +135-3858-6433 [China ShangHai] +188-1699-6168

TECHNICAL DATA SHEET

Product text

For all kind of injection molding parts with high requirements on strength

Preliminary data

Properties	Value	Unit	Test method
Density	1,5600	g/cm³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	15	kJ/m²	ISO 179
Impact strength Charpy (Notched 23°), conditioned	15	kJ/m²	ISO 179
Impact strength Charpy 23°C, dry	94	kJ/m²	ISO 179
Impact strength Charpy (23°), conditioned	NB	kJ/m²	ISO 179
Tensile-modulus, dry	16500	MPa	ISO 527
Tensile-modulus, conditioned	15500	MPa	ISO 527
Tensile stress at break, dry	235	MPa	ISO 527
Tensile stress at break, conditioned	210	MPa	ISO 527
Elongation at break, dry	3,00	%	ISO 527
Elongation at break, conditioned	3,00	%	ISO 527
HDT 0,45 MPa	250	°C	ISO 75
HDT 1,80 MPa	240	°C	ISO 75
Melting point	260	°C	ISO 11357-3
CTI	600	V	IEC 60112
Electric strength	33,00	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	4,00	%	ISO 62
Moisture absorption	1,40	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ GT3 300 H G50 SF

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:

Temperatures

Processing temperatures

Hopper	60 - 80°C
Center	260 - 290°C
Nozzle	270 - 300°C

Mold temperature

Temp.	80 - 120°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. 275 °C / 8 min.

Instructions for cleaning

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