

# Technical information

## TEREZ<sup>®</sup> GT3X 300 H G30

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Partially aromatic PA66 blend with 30% glass fiber proportions and heat stabilized. The product tends to reduced warpage and has improved flow characteristics.



## TECHNICAL DATA SHEET

### Product text

For injection-moulded components with high requirements to isotropic strength properties.

Properties	Value	Unit	Test method
Density	1,3400	g/cm <sup>3</sup>	ISO 1183
Impact strength Charpy (Notched 23°C), dry	8	kJ/m <sup>2</sup>	ISO 179
Impact strength Charpy (Notched 23°), conditioned	9	kJ/m <sup>2</sup>	ISO 179
Impact strength Charpy 23°C, dry	50	kJ/m <sup>2</sup>	ISO 179
Impact strength Charpy (23°), conditioned	NB	kJ/m <sup>2</sup>	ISO 179
Tensile-modulus, dry	10800	MPa	ISO 527
Tensile-modulus, conditioned	11000	MPa	ISO 527
Tensile stress at break, dry	215	MPa	ISO 527
Tensile stress at break, conditioned	200	MPa	ISO 527
Elongation at break, dry	3,00	%	ISO 527
Elongation at break, conditioned	4,00	%	ISO 527
HDT 0,45 MPa	245	°C	ISO 75
HDT 1,80 MPa	235	°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	4,80	%	ISO 62
Moisture absorption	1,80	%	ISO 62

## PROCESSING DATA SHEET

### Processing guidelines for injection molding of TEREZ GT3X 300 H G30

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
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##### 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.