

Technical information

preliminary

TEREZ[®] GT3X 300 H G60

Partially aromatic PA66 blend with 60% 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.

Preliminary data

Properties	Value	Unit	Test method
Density	1,6800	g/cm ³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	18	kJ/m ²	ISO 179
Impact strength Charpy (Notched 23°), conditioned	18	kJ/m ²	ISO 179
Impact strength Charpy 23°C, dry	85	kJ/m ²	ISO 179
Impact strength Charpy (23°), conditioned	85	kJ/m ²	ISO 179
Tensile-modulus, dry	21500	MPa	ISO 527
Tensile-modulus, conditioned	20500	MPa	ISO 527
Tensile stress at break, dry	260	MPa	ISO 527
Tensile stress at break, conditioned	250	MPa	ISO 527
Elongation at break, dry	2,00	%	ISO 527
Elongation at break, conditioned	2,00	%	ISO 527
HDT 0,45 MPa	255	°C	ISO 75
HDT 1,80 MPa	244	°C	ISO 75
Melting point	260	°C	ISO 11357-3
CTI	600	V	IEC 60112
Surface resistivity, dry	1E13	Ohm	IEC 60093
Volume resistivity, dry	1E12	Ohm * m	IEC 60093
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	3,50	%	ISO 62
Moisture absorption	1,20	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ GT3X 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	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.