

Technical information

TEREZ[®] PA 6.6 7500 TF 15 GF 40

Medium viscosity PA66 standard quality with 40% GF reinforced and 15% PTFE.



TECHNICAL DATA SHEET

Product text

For all kind of moulding parts with high stiffness and very good anti friction properties.

Properties	Value	Unit	Test method
Density	1,5800	g/cm ³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	13,5	kJ/m ²	ISO 179
Impact strength Charpy 23°C, dry	83	kJ/m ²	ISO 179
Elongation at tear, dry	1,6	%	ISO 527
Tensile-modulus, dry	13000	MPa	ISO 527
Tensile stress at break, dry	195	MPa	ISO 527
Elongation at break, dry	1,60	%	ISO 527
Tensile strength, dry	190	MPa	ISO 527
HDT 0,45 MPa	235	°C	ISO 75
HDT 1,80 MPa	225	°C	ISO 75
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
Water absorption	4,40	%	ISO 62
Moisture absorption	1,40	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PA 6.6 7500 TF 15 GF 40

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	250 - 280°C
Nozzle	270 - 290°C

Mold temperature	
Temp.	40 - 80°C

Residence time

You should try to keep the residence time short, especially at high temperatures to avoid material degradation.

Instructions for cleaning

Machine parts / units / nozzles, etc., which are still contaminated with larger amounts of PTFE-containing material may not be burned out. It is recommended that machines and aggregates should be purged after processing with pure polyamide or with suitable cleaning granules. An alternative would be a mechanical cleaning of the metal parts.