

Technical information

TEREZ[®] PA 6.6 7750 TD

Dry impact modified Polyamide 6.6 with good flowability and good demouldability.



TECHNICAL DATA SHEET

Product text

For all kind of moulding parts with increased demand of impact resistance.

Properties	Value	Unit	Test method
Density	1,1200	g/cm ³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	12	kJ/m ²	ISO 179
Impact strength Charpy (Notched 23°), conditioned	20	kJ/m ²	ISO 179
Impact strength Charpy (Notched -30°C), dry	5	kJ/m ²	ISO 179
Impact strength Charpy 23°C, dry	NB	kJ/m ²	ISO 179
Elongation at yield, conditioned	20,00	%	ISO 527
Elongation at yield, dry	3,50	%	ISO 527
Tensile stress at yield, dry	65	MPa	ISO 527
Tensile stress at yield, conditioned	40	MPa	ISO 527
Tensile-modulus, dry	2500	MPa	ISO 527
Tensile-modulus, conditioned	850	MPa	ISO 527
Elongation at break, dry	28,00	%	ISO 527
HDT 0,45 MPa	170	°C	ISO 75
HDT 1,80 MPa	65	°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	7,30	%	ISO 62
Moisture absorption	2,00	%	ISO 62

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PA 6.6 7750 TD

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)	

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<= 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.	40 - 80°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. 280 °C / 8 min.	

Instructions for cleaning

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