

# Technical information

preliminary

## TEREZ<sup>®</sup> PA 6.6 7750 TD SF

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



## TECHNICAL DATA SHEET

### Product text

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

### Preliminary data

Properties	Value	Unit	Test method
Density	1,1200	g/cm <sup>3</sup>	ISO 1183
Melt flow index (MFI)	140,00	g/10 min	ISO 1133
MFI Temperature	275	°C	ISO 1133
MFI Load	5,00	kg	ISO 1133
Impact strength Charpy (Notched 23°C), dry	11	kJ/m <sup>2</sup>	ISO 179
Impact strength Charpy (Notched 23°), conditioned	20	kJ/m <sup>2</sup>	ISO 179
Impact strength Charpy (Notched -30°C), dry	5	kJ/m <sup>2</sup>	ISO 179
Impact strength Charpy 23°C, dry	NB	kJ/m <sup>2</sup>	ISO 179
Elongation at yield, conditioned	20,00	%	ISO 527
Elongation at yield, dry	4,00	%	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	1150	MPa	ISO 527
Elongation at break, dry	24,00	%	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 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)	

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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.