Technical information

TEREZ® PA 4.6 7115 TF 15

Polyamid 4.6, 15 % PTFE chemically bonded.

TER Plastics POLYMER GROUP

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TECHNICAL DATA SHEET

Product text

For injection moulding parts with improved wear resistance and friction properties.

Properties	Value	Unit	Test method
Density	1,2700	g/cm³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	7	kJ/m²	ISO 179
Impact strength Charpy (23°), dry	NB	kJ/m²	ISO 179
Elongation at yield stress, dry	5	%	ISO 527
Tensile stress at yield, dry	88	MPa	ISO 527
Tensile-modulus, dry	2800	MPa	ISO 527
Tensile stress at break, dry	87	MPa	ISO 527
Elongation at break, dry	17,00	%	ISO 527
Tensile strength, dry	88	MPa	ISO 527
HDT 1,80 MPa	195	°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	12,00	%	ISO 62
Moisture absorption	3,00	%	ISO 62

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PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ PA 4.6 7115 TF 15

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

0,03 - 0,08% (recommended)
max. 0.1% (standard)

MACHINE REQUIREMENTS

PROCESSING

Basic settings

The following basic settings are generally to be selected:

Temperatures

Processing temperatures

Hopper	80 - 100°C
Center	300 - 315°C
Nozzle	295 - 315°C

Mold temperature

Temp.	80 - 140°C

Residence time

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

Instructions for cleaning

The unit can be cleaned with standard cleaning granules.