

Technical information

preliminary

TEREZ[®] AB 301 H G50

Medium viscosity polyamide 6.6+6 blend with 50% glass fiber reinforcement and heat stabilisation.



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TECHNICAL DATA SHEET

Product text

For molded parts with very high stiffness and good surfaces.

Preliminary data

	Value	Unit	Test method
Density	1,5600	g/cm ³	ISO 1183
Impact strength Charpy (Notched 23°C), dry	18	kJ/m ²	ISO 179
Impact strength Charpy (Notched 23°), conditioned	25	kJ/m ²	ISO 179
Impact strength Charpy (Notched -30°C), dry	13	kJ/m ²	ISO 179
Impact strength Charpy 23°C, dry	85	kJ/m ²	ISO 179
Impact strength Charpy (23°), conditioned	95	kJ/m ²	ISO 179
Flexural modulus, dry	15000	MPa	ISO 178
Flexural strength, dry	340	MPa	ISO 178
Tensile-modulus, dry	16000	MPa	ISO 527
Tensile-modulus, conditioned	11500	MPa	ISO 527
Tensile stress at break, dry	230	MPa	ISO 527
Tensile stress at break, conditioned	170	MPa	ISO 527
Elongation at break, dry	2,80	%	ISO 527
Elongation at break, conditioned	4,00	%	ISO 527
HDT 0,45 MPa	255	°C	ISO 75
HDT 1,80 MPa	245	°C	ISO 75
Melting temperature	260	°C	similar ISO 11357-3
CTI	500	V	IEC 60112
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	1,6	mm	UL 94
UL recognition	-		UL 94
Water absorption	4,80	%	similar ISO 62
Moisture absorption	1,40	%	similar ISO 1110

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All specified data are for reference only. Typical values for uncolored product at 23°C. The data were usually generated from specimen tests and do not exempt the user from own measurements according to usage. The specified data do not represent guaranteed properties. The preliminary Technical Information is valid through 16.12.2019 Beyond this date the user is welcome to request a new valid data sheet.

PROCESSING DATA SHEET

Processing guidelines for injection molding of TEREZ AB 301 H G50

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 temperature settings are to be selected:

Processing temperatures

Hopper	60 - 80°C
Center	250 - 280°C
Nozzle	260 - 290°C

Mold temperature

Temp.	40 - 80°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. 270 °C / 8 min.

Instructions for cleaning

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

PROCESSING DATA SHEET

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