

Material Data Sheet

TEPEX[®] *dynalite* 102-RG600(x)/47% Roving Glass – PA 6 Consolidated Composite Laminate

Property		Method ISO	Units	Longitudinal	Transverse	
Material	Reinforcement	Fibres Fabric Area weight Yarn Weight rate	g/m ² tex %	roving glass twill 600 1200 50	1200 50	
	Polymer	Polymer		PA 6		
	Laminate	Density Fibre content Thickness per layer	g/cm ³ % vol. mm	1,8 47 0,5		
Mechanical	Tensile	Modulus Strength Elongation Poisson's ratio	527-4/5 527-4/5 527-4/5 527-4/5	GPa MPa %	22,4 404 2,2 0,17	21,5 390 2,2 0,17
	Flexural	Modulus Ultimate stress*	178 178	GPa MPa	19,2 620	18,7 585
	Charpy impact strength unnotched	23°C -30°C	179/1eU	kJ/m ² kJ/m ²	145 -	- -
Thermal	Melting Temperature	per DSC	3146	°C	220	
	Glass transition temperature	per DSC	3146	°C	60	
	Heat deflection temperature	1,80 MPa	75-1/2	°C	215	
	Coefficient of thermal expansion	-30°C to 23°C 23°C to 80°C	ASTM E831	E-6 1/K	19 15	19 15
	Relative temperature index	20.000 h	IEC 216/1	°C	120	

* 3-Point loading, span-to-depth ratio 16 to 1

These values are for this specific composition only, the characteristics of composites depend on the reinforcement level and the fibre orientation. Non-standard thickness may also alter some or all of these properties. The data listed here fall within the normal range of product properties, but they should not be used to establish specification limits nor used alone as basis of design.

This information corresponds to our current knowledge on subject. It is offered solely to provide possible suggestions for your own experimentations. It is not intended, however, to substitute for any testing you may need to conduct to determine for yourself the suitability of our products for your particular purposes. This information may be subject to revision as new knowledge and experience becomes available. Since we cannot anticipate all variations in actual end-use conditions. Bond-Laminates makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a licence to operate under or a recommendation to infringe any patent right.

Caution: Do not use this product in medical applications involving permanent implantation in human body.

Processing guidelines for TEPEX® Roving Glass – Polyamide 6

1. Storage/handling

Storage time: unlimited

Moisture content needs to be limited to prevent delamination due to vaporisation during heating. The material is provided in sealed packages. In order to prevent moisture condensation on the cold sheet surface the sealed packages should be stored in the working area until a temperature equilibrium is reached. The material should be processed within 1 hour after opening of the sealing or the material should be dried prior to processing (overnight, 80°C). The use of dust masks and ventilation whilst cutting, milling, drilling etc. is advised.

2. Heating

Forming temperature: between 240°C and 260°C

Forming temperature depends on the polymer to be used. In general the TEPEX® sheet should be heated ca. 20°C - 40°C above the melting temperature of the polymer. Heating cycles should be short to avoid polymer oxidation (surface colour browning). The preferred heating method is middle wavelength IR-heating. Best results are obtained when heating power is controlled as a function of the sheet temperature. Two sided heating should be applied starting from a material thickness of 1,0 mm. Contact heating is feasible but a release film should be applied. This release film will have to be moulded with the material to prevent distortion of the fabric during peeling of the release film in molten laminate status. Heating in a convection oven leads to excessive oxidation of the surface due to the length of the heat cycle and is therefore not recommended.

3. Sheet transfer

Sheet transportation: max. 2-3 sec.

The sheet should be transferred within seconds.

Circulation of cool air in the processing environment reduces the sheet temperature considerably and will lead to a reduction of fabric formability and wrinkles. Manual transfer is not recommended as it causes fabric distortion and polymer distribution caused by the sticky resin to gloves. For obtaining maximum processing stability an automatic transport of the sheet is recommended.

4. Press forming

Press speed: > 50 mm/s (1st step)

Closing speed: 5 mm/s (2nd step)

The recommended closing speed of the press is at least 50 mm/s and should be reduced to approx. 5 mm/s during the last part (10 mm) of the forming. Local clamping forces should be applied to prevent fabric wrinkling during moulding. The clamping forces and arrangements depend on the fabric type, the material thickness and the complexity of the part.

5. Cooling

Consolidation pressure: 5 bar - 100 bar

Extraction temperature: ≤ 110°C

The consolidation pressure varies over the surface of a formed part, depending on part geometry and tool material. The tool temperature should both guarantee good formability/flow and stable product extraction. Aluminium and steel can be used from 90°C up to 110°C; product extraction is then possible without any additional cooling cycle. The consolidation time depends on the material thickness, the tool temperature and the tool materials. Recommended for a laminate thickness of 2,0 mm and the aforementioned conditions is a cooling time of about 30 seconds.

When and where to apply TEPEX® Roving Glass – Polyamide 6

1. General description

Within the TEPEX® composite laminate, Polyamide 6 is a resin which can be used at temperatures from -30°C up to 120°C constantly. PA 6 is known for its toughness, stiffness, abrasion resistance, heat and chemical resistances. Roving E-Glass fibres have an excellent impact performance. This makes the composite material tough and fatigue resistant while offering excellent mechanical properties.

2. Application Areas

Typical application environments are within automotive applications, large structural parts, bumper systems, structural sporting goods applications, helmet shells.