

## DATA SHEET

### GRILAMID 2S 20 NATURAL

#### Product description

Grilamid 2S 20 natural is an unmodified medium viscosity polyamide 610 (PA610), designed for injection molding as well as extrusion. It is characterised by the following product profile:

- To 62% based on renewable raw material
- Good chemical resistance
- High strength
- Ductile, resilient in conditioned stage
- Moderate water absorption
- Low density

#### Application examples

Grilamid 2S 20 natural is suitable for applications at moderate continuous use temperature and without repeated direct exposure to UV radiation.

Preferred applications:

- Injection molded functional parts
- Bushes, gears
- Consumer goods
- Semi-fabricates such as tubes, film, sheet, profiles
- Sheathing and guides



**Grilamid<sup>®</sup>**  
**EMS**

# PROPERTIES

## Mechanical Properties

		Standard	Unit	State	Grilamid 2S 20 natural
Tensile E-Modulus	1 mm/min	ISO 527	MPa	dry cond.	2200 1300
Tensile strength at yield	50 mm/min	ISO 527	MPa	dry cond.	65 50
Elongation at yield	50 mm/min	ISO 527	%	dry cond.	5 20
Tensile strength at break	50 mm/min	ISO 527	MPa	dry cond.	* *
Elongation at break	50 mm/min	ISO 527	%	dry cond.	>50 >50
Impact strength	Charpy, 23°C	ISO 179/2-1eU	kJ/m <sup>2</sup>	dry cond.	no break no break
Impact strength	Charpy, -30°C	ISO 179/2-1eU	kJ/m <sup>2</sup>	dry cond.	no break no break
Notched impact strength	Charpy, 23°C	ISO 179/2-1eA	kJ/m <sup>2</sup>	dry cond.	7 13
Notched impact strength	Charpy, -30°C	ISO 179/2-1eA	kJ/m <sup>2</sup>	dry cond.	5 5
Ball indentation hardness		ISO 2039-1	MPa	dry cond.	128 82

\*not relevant according to ISO 10350-1

## Thermal Properties

Melting point	DSC	ISO 11357	°C	dry	223
Heat deflection temperature HDT/A	1.80 MPa	ISO 75	°C	dry	55
Heat deflection temperature HDT/B	0.45 MPa	ISO 75	°C	dry	140
Thermal expansion coefficient long.	23-55°C	ISO 11359	10 <sup>-4</sup> /K	dry	1.1
Thermal expansion coefficient trans.	23-55°C	ISO 11359	10 <sup>-4</sup> /K	dry	0.9
Maximum usage temperature	long term	ISO 2578	°C	dry	80
Maximum usage temperature	short term	ISO 2578	°C	dry	150

## Electrical Properties

Dielectric strength		IEC 60243-1	kV/mm	dry cond.	35 30
Comparative tracking index	CTI	IEC 60112	-	cond.	600
Specific volume resistivity		IEC 60093	Ω · m	dry cond.	10 <sup>8</sup> 10 <sup>9</sup>
Specific surface resistivity		IEC 60093	Ω	cond.	10 <sup>10</sup>

## General Properties

Density		ISO 1183	g/cm <sup>3</sup>	dry	1.08
Flammability (UL94)	0.8 mm	ISO 1210	rating	-	HB
Water absorption	23°C/sat.	ISO 62	%	-	3.9
Moisture absorption	23°C/50% r.h.	ISO 62	%	-	1.7
Linear mold shrinkage	long.	ISO 294	%	dry	1.3
Linear mold shrinkage	trans.	ISO 294	%	dry	1.4

Product-nomenclature acc. ISO 1874: PA 610, EM, 18-020

# Processing information for the injection moulding of Grilamid 2S 20 natural

This technical data sheet for Grilamid 2S 20 natural provides you with useful information on material preparation, machine requirements, tooling and processing.

## MATERIAL PREPARATION

Grilamid 2S 20 natural is delivered dry and ready for processing in sealed, air tight packaging. Pre-drying is not necessary provided the packaging is undamaged.

### Storage

Sealed, undamaged bags can be kept over a period of at least one year when stored in a facility which is dry, protected from the influence of weather and where the bags can be protected from damage.

### Handling and safety

Detailed information can be obtained from the "Material Safety Data Sheet" (MSDS) which can be requested with every material order.

### Drying

Grilamid 2S 20 natural is dried and packed with a moisture content of  $\leq 0.10\%$ . Should the packaging become damaged or be left open too long, then the material must be dried. A too high moisture content can be shown by a foaming melt, excessive nozzle drool and silver streaks on the molded part.

Drying can be done as follows:

Desiccant dryer	
Temperature	70 - 80°C
Time	4 - 12 hours
Dew point of the dryer	-30°C

Vacuum oven	
Temperature	max. 100°C
Time	4 - 12 hours

### Drying time

If there is only little evidence of foaming of the melt or just slight silver streaks on the part, then the above mentioned minimum drying time will be sufficient. If material is stored open for days, shows strong foaming, unusually easy flow, streaks or a rough surface on the molded part, then the maximum drying time is required.



Silver streaks can also be caused by overheating of the material (over 300°C) or by too long melt residence time in the barrel.

### Drying temperature

Polyamides are affected by oxidation at temperatures above 80°C in the presence of oxygen. Visible yellowing of the material is an indication of oxidation. Hence, temperatures above 80°C for desiccant dryers and temperatures above 100°C for vacuum ovens should be avoided. In order to detect oxidation it is advised to keep a small amount of granulate (light colours only!) as a comparison sample.

For longer air exposure times (over 1 hour) hopper heating or a hopper dryer (80°C) is advisable.

### Use of regrind

Grilamid 2S 20 natural is a thermoplastic material. Hence, incomplete moldings as well as sprues and runners can be reprocessed. The following points should be considered:

- Moisture absorption
- Grinding: Dust particles and particle size distribution
- Contamination through foreign material, dust, oil, etc.
- Level of addition to original material
- Colour variation
- Reduction of mechanical properties

When adding regrind, special care has to be taken by the molder.

## MACHINE REQUIREMENTS

Grilamid 2S 20 natural can be processed economically and without problems on all machines suitable for polyamides.

### Screw

Wear protected, universal screws with shut-off nozzles are recommended (3 zones).

Screw	
Length	18 D - 24 D
Compression ratio	2 - 2.5

### Shot volume

The metering stroke (less decompression distance) must be longer than the length of the non-return-valve.

### Selecting the injection unit

Shot volume = 0.5 - 0.8 x  
(max. shot volume of injection unit)

## Heating

At least three separately controllable heating zones, capable of reaching cylinder temperatures up to 350°C. Separate nozzle heating is necessary. The cylinder flange temperature must be controllable (cooling).

## Nozzle

Open nozzles are simple, allow an easy melt flow and are long lasting. There is however, the danger that during retraction of the screws following injection of the melt, air may be drawn into the barrel (decompression). For this reason, needle shut-off nozzles are often used.

## Clamping force

As a rule of thumb the clamping force can be estimated using the following formula:

### Clamping force

$$7.5 \text{ kN}^{1)} \times \text{projected area (cm}^2\text{)}$$

<sup>1)</sup> for a cavity pressure of 750 bar

## TOOLING

The design of the mold tool should follow the general rules for unreinforced thermoplastics.

For the mold cavities common mold tool steel quality (e.g. hardened steel) which has been hardened to level of 56 HRC is necessary. We recommend additional wear protection in areas of high flow rates in the tool (e.g. pin point gates, hot runner nozzles).

## Demolding / Draft angle

Asymmetric demolding and undercuts are to be avoided if possible. Generous provision should be made for ejection with many large pins or a stripper plate. Draft angles for the inner and outer wall between 0.5 and 3° is usually sufficient.

## Gate and runner

To achieve the best mold filling and avoid sink marks, a central gate at the thickest section of the molding is recommended. Pin point (direct) or tunnel gates are more economical and more common with technical molding.

To avoid premature solidification of the melt and difficult mold filling, the following points should be considered:

### Gate diameter

0.8 x thickest wall section of the injection molding part

### Runner diameter

1.4 x thickest wall section of the injection molding part (but minimum 4 mm)

## VENTING

In order to prevent burning marks and improve weld line strength, proper venting of the mold cavity should be provided (venting channels on the parting surface dimensions: Depth 0.02 mm, width 2 - 5 mm).

## PROCESSING

### Mold filling, post pressure and dosing

The best surface finish and a high weld line strength are achieved when a high injection speed and a sufficiently long post pressure time are employed.

The injection speed should be regulated so as to reduce towards the end of the filling cycle in order to avoid burning. For dosing at low screw revolutions and pressure the cooling time should be fully utilised.

### Basic machine settings

In order to start up the machine for processing Grilamid Grilamid 2S 20 natural, the following basic settings are recommended:

#### Temperatures

Flange	70 - 90°C
Zone 1	240 - 260°C
Zone 2	250 - 270°C
Zone 3	260 - 280°C
Nozzle	260 - 280°C
Tool	70 - 90°C
Melt	260 - 280°C

#### Pressures / Speeds

Injection speed	low - medium
Hold-on pressure (spec.)	300 - 800 bar
Dynamic pressure (hydr.)	5 - 15 bar
Screw speed	50 - 100 min <sup>-1</sup>

## CUSTOMER SERVICES

EMS-GRIVORY is a specialist in polyamide synthesis and the processing of these materials. Our customer services are not only concerned with the manufacturing and supply of engineering thermoplastics but also provide full technical support including:

- Rheological design calculation / FEA
- Prototype tooling
- Material selection
- Processing support
- Mold and component design

We are happy to advise you. Simply call one of our sales offices.

The recommendations and data given are based on our experience to date, however, no liability can be assumed in connection with their usage and processing.

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