

TECHNICAL DATA SHEET

GRIVORY GVX-65H BLACK 9915

Product description

Grivory GVX-65H black 9915 is a 65% glass-fibre reinforced engineering thermoplastic material based on a combination of semi-crystalline polyamide with partially aromatic copolyamide.

Grivory GVX-65H black 9915 has an optimized flowability and is suitable for injection moulding technical parts, exhibiting exceptional characteristics even after moisture absorption:

- highest stiffness and strength
- high dimensional stability, very low warpage
- good chemical resistance
- good surface finish

Grivory GVX-65H black 9915 is the economical alternative to die-cast alloys.

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PROPERTIES

Mechanical Properties

| | | Standard | Unit | State | Grivory GVX-65H black 9915 |
|---------------------------|---------------|-------------|-------------------|--------------|-------------------------------|
| Tensile E-Modulus | 1 mm/min | ISO 527 | MPa | dry cond. | 25500 25000 |
| Tensile strength at break | 5 mm/min | ISO 527 | MPa | dry cond. | 300 280 |
| Elongation at break | 5 mm/min | ISO 527 | % | dry cond. | 1.9 1.9 |
| Impact strength | Charpy, 23°C | ISO 179/1eU | kJ/m ² | dry cond. | 75 70 |
| Impact strength | Charpy, -30°C | ISO 179/1eU | kJ/m ² | dry cond. | 70 70 |
| Notched impact strength | Charpy, 23°C | ISO 179/1eA | kJ/m ² | dry cond. | 15 15 |
| Notched impact strength | Charpy, -30°C | ISO 179/1eA | kJ/m ² | dry cond. | 15 15 |
| Ball indentation hardness | | ISO 2039-1 | MPa | dry cond. | 345 330 |

Thermal Properties

| | | | | | |
|--------------------------------------|------------|-----------|---------------------|-----|---------|
| Melting point | DSC | ISO 11357 | °C | dry | 260 |
| Heat deflection temperature HDT/A | 1.80 MPa | ISO 75 | °C | dry | 250 |
| Heat deflection temperature HDT/C | 8.00 MPa | ISO 75 | °C | dry | 215 |
| Thermal expansion coefficient long. | 23-55°C | ISO 11359 | 10 ⁻⁴ /K | dry | 0.15 |
| Thermal expansion coefficient trans. | 23-55°C | ISO 11359 | 10 ⁻⁴ /K | dry | 0.50 |
| Maximum usage temperature | long term | ISO 2578 | °C | dry | 100-120 |
| Maximum usage temperature | short term | ISO 2578 | °C | dry | 220 |

Electrical Properties

| | | | | | |
|------------------------------|-----|-------------|-------|--------------|--------------------------------------|
| Dielectric strength | | IEC 60243-1 | kV/mm | dry cond. | 33 33 |
| Comparative tracking index | CTI | IEC 60112 | - | cond. | 600 |
| Specific volume resistivity | | IEC 60093 | Ω · m | dry cond. | 10 ¹⁰ 10 ¹⁰ |
| Specific surface resistivity | | IEC 60093 | Ω | cond. | 10 ¹² |

General Properties

| | | | | | |
|------------------------|---------------|----------|-------------------|-----|------|
| Density | | ISO 1183 | g/cm ³ | dry | 1.77 |
| Flammability (UL94) | 0.8 mm | ISO 1210 | rating | - | HB |
| Water absorption | 23°C/sat. | ISO 62 | % | - | 3.2 |
| Moisture absorption | 23°C/50% r.h. | ISO 62 | % | - | 1.1 |
| Linear mould shrinkage | long. | ISO 294 | % | dry | 0.05 |
| Linear mould shrinkage | trans. | ISO 294 | % | dry | 0.25 |

Product-nomenclature acc. ISO 1874: PA66+PA6I/X, MH, 14-250, GF65

Processing information for the injection moulding of Grivory GVX-65H black 9915

This technical data sheet for Grivory GVX-65H black 9915 provides you with useful information on material preparation, machine requirements, tooling and processing.

MATERIAL PREPARATION

Grivory GVX-65H black 9915 is delivered dry and ready for processing in sealed, air tight packaging. Predrying is not necessary.

Storage

Sealed, undamaged bags can be kept over a long period of time in storage facilities which are 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

During its manufacturing process Grivory GVX-65H black 9915 is dried and packed with a moisture content of $\leq 0.10\%$. Should the packaging become damaged or the material is left open too long, then the material must be dried. A too high moisture content can be shown by a foaming melt and silver streaks on the moulded part.

Drying can be done as follows:

Desiccant dryer

| | |
|-------------------------|--------------|
| Temperature: | max. 80°C |
| Time: | 4 - 12 hours |
| Dew point of the dryer: | -25°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 minimal drying time will be sufficient. Material, which is stored open over days, which shows strong foaming, unusually easy flowing, streaks and rough surface on the moulding part, then the maximal drying time is required.



Silver streaks can also be caused by overheating of the material (over 350°C) or by too long melt residence time in the barrel.

Drying temperature

Polyamides are subjected to the affects of 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 colour only!) as a comparison sample.

At longer residence times (over 1 hour) hopper heating or a hopper dryer (80°C) is useful.

Use of regrind

Grivory GVX-65H black 9915 is a thermoplastic material. Hence, incomplete mouldings as well as sprues and runners can be reprocessed. The following points should be observed:

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

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

MACHINE REQUIREMENTS

Grivory GVX-65H black 9915 can be processed economically and without problems on all machines suitable for polyamides.

Screw

Wear protected, universal screws (3 zones) with non-return valves are recommended.

Screw

| | |
|--------------------|-------------|
| Length: | 18 D - 22 D |
| Compression ratio: | 2 - 2.5 |

Shot volume

The metering stroke must be longer than the length of the back flow valve (without decompression distance).

Selecting the injection unit

| |
|---------------------------|
| Shot volume = 0.5 - 0.8 x |
| (max. shot volume) |

Heating

At least three separately controllable heating zones, able of reaching cylinder temperatures up to 350°C. A 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 maybe 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

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

¹⁾ in cavity pressure of 750 bar

TOOLING

The design of the mould tool should follow the general rules for glass-fibre reinforced thermoplastics.

For the mould cavities common mould 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).

Demoulding / Draft angle

Parts moulded from Grivory showing excellent dimensional stability. Asymmetric demoulding and undercuts are to be avoided. It is favourable to foresee high numbers of large ejector pins or a stripper plate. Demoulding draft angles between 1 to 5° are acceptable.

Gate and runner

To achieve an optimal mould-fill and to avoid sink marks, a central gate at the thickest section of the moulding is recommended. Pin point gate (direct) or tunnel gates are more economical and more common with technical moulding.

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

Gate diameter

$$0.8 \times \text{thickest wall section of the injection moulding part}$$

Runner diameter

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

VENTING

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

PROCESSING

Mould filling, post pressure and dosing

The best surface finish and a high weld line strength is achieved with a high injection speed and when a sufficiently long post pressure is 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 machines for processing Grivory GVX-65H black 9915, following basic settings can be recommended:

Temperatures

| | |
|--------|-------------|
| Flange | 80°C |
| Zone 1 | 260°C |
| Zone 2 | 270°C |
| Zone 3 | 275°C |
| Nozzle | 270°C |
| Tool | 80 - 120°C |
| Melt | 270 - 300°C |

Pressures / Speeds

| | |
|--------------------------|----------------------------|
| Injection speed | medium - high |
| Hold-on pressure (spec.) | 300 - 800 bar |
| Dynamic pressure (hydr.) | 5 - 15 bar |
| Screw speed | 50 - 100 min ⁻¹ |

CUSTOMER SERVICES

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

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

We are happy to advice 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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This version replaces all previous product specific data sheets.

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