

TECHNICAL DATA SHEET

GRILON BRZ 247 W

General product description

Grilon BRZ 247 W is a heat stabilised, high viscosity, impact modified and plasticized PA6 extrusion grade.

Grilon BRZ 247 W has the following important properties:

- High flexibility
- Good impact strength even at low temperatures

Grilon BRZ 247 W is used typically for co-extruded fuel lines, coolant pipes in deep freezer units, vulcanization mandrels, and vacuum lines.

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PROPERTIES

Mechanical Properties

		Standard	Unit	State	Grilon BRZ 247 W
Tensile E-Modulus	1 mm/min	ISO 527	MPa	dry cond.	650 380
Tensile strength at yield	50 mm/min	ISO 527	MPa	dry cond.	*
Elongation at yield	50 mm/min	ISO 527	%	dry cond.	*
Tensile strength at break	50 mm/min	ISO 527	MPa	dry cond.	30 25
Elongation at break	50 mm/min	ISO 527	%	dry cond.	> 50 > 50
Impact strength	Charpy, 23°C	ISO 179/2-1eU	kJ/m ²	dry cond.	no break no break
Impact strength	Charpy, -30°C	ISO 179/2-1eU	kJ/m ²	dry cond.	no break no break
Notched impact strength	Charpy, 23°C	ISO 179/2-1eA	kJ/m ²	dry cond.	120 no break
Notched impact strength	Charpy, -30°C	ISO 179/2-1eA	kJ/m ²	dry cond.	7 10
Ball indentation hardness		ISO 2039-1	MPa	dry cond.	35 25

Thermal Properties

Melting point	DSC	ISO 11357	°C	dry	215
Heat deflection temperature HDT/A	1.80 MPa	ISO 75	°C	dry	40
Heat deflection temperature HDT/B	0.45 MPa	ISO 75	°C	dry	75
Thermal expansion coefficient long.	23-55°C	ISO 11359	10 ⁻⁴ /K	dry	1.4
Thermal expansion coefficient trans.	23-55°C	ISO 11359	10 ⁻⁴ /K	dry	1.5
Maximum usage temperature	long term	ISO 2578	°C	dry	80 - 110
Maximum usage temperature	short term	ISO 2578	°C	dry	150

Electrical Properties

Dielectric strength		IEC 60243-1	kV/mm	dry cond.	31 29
Comparative tracking index	CTI	IEC 60112	-	cond.	500
Specific volume resistivity		IEC 60093	Ω · m	dry cond.	10 ¹² 10 ¹¹
Specific surface resistivity		IEC 60093	Ω	cond.	10 ¹²

General Properties

Density		ISO 1183	g/cm ³	dry	1.12
Flammability (UL94)	0.8 mm	ISO 1210	rating	-	HB
Water absorption	23°C/sat.	ISO 62	%	-	8
Moisture absorption	23°C/50% r.h.	ISO 62	%	-	2.5
Linear mould shrinkage	long.	ISO 294	%	dry	-
Linear mould shrinkage	trans.	ISO 294	%	dry	-

Product-nomenclature acc. ISO 1874: PA6-HIP, GH, 32-007

* Stress at 50% strain

Processing information for the extrusion of Grilon BRZ 247 W

This technical data sheet for Grilon BRZ 247 W provides you with useful information on material preparation, machine requirements, and processing.

MATERIAL PREPARATION

Grilon BRZ 247 W is delivered dry and ready for processing in sealed, air tight packaging. Predrying is not necessary provided the packaging is undamaged.

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

Grilon BRZ 247 W 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 lead to a reduction of optical and mechanical properties

Drying can be done as follows:

Desiccant dryer

Temperature:	max. 80°C
Time:	4 - 12 hours
Dew point of the dryer:	-30°C

Vacuum oven

Temperature:	max. 100°C
Time:	4 - 12 hours

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.

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

MACHINE REQUIREMENTS

Grilon BRZ 247 W can be processed economically and without problems on all machines suitable for polyamides.

Screw

Wear protected, universal screws are recommended (3 zones).

Screw

Length:	24 D - 25 D
Compression ratio:	2.8:1 - 3.5:1

Grooved Feeding Zone

A grooved bush is usually not recommended for the extrusion of polyamides grades. Anyhow, in order to obtain a higher through-put by using a grooved bush its depth should not exceed 0.5 mm.

PROCESSING

Basic machine settings

In order to start up the machine for processing Grilon BRZ 247 W, the following basic settings can be recommended:

Temperatures

Hopper zone	60 - 90°C
Feeding zone	210°C
Compression zone	220°C
Metering zone	220°C
Head	220°C
Nozzle	210°C
Melt	220 - 240°C

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
- Mould and component design

For further details concerning extrusion please refer to our Technical Information Booklet "Tube Extrusion" available from your EMS-GRIVORY specialist.

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.