

TECHNICAL DATA SHEET

GRILON BM 20 SBG

General product description

Grilon BM 20 SBG is a lactam free multi-polyamide.

Grilon BM 20 SBG has the following features:

- Lactam free
- Good transparency and gloss
- Good flexibility and toughness
- Very good thermoforming and shrink properties

Application

Grilon BM 20 SBG is suitable for the production of coextruded blown and cast films.

Grilon BM 20 SBG is suitable for the following applications:

Flexible packaging for foodstuffs and especially suitable for medical packaging applications such as intravenous bags.

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PROPERTIES

Thermal Properties

		Standard	Unit	Grilon BM 20 SBG
Melting point	DSC	ISO 11357	°C	200
Melt volume rate (MVR)	275°C / 5 kg	ISO 1133	cm ³ /10 min	40

General Properties

Density		ISO 1183	g/cm ³	1.09
Water absorption	23°C/sat.	ISO 62	%	6
Moisture absorption	23°C/50 % RH	ISO 62	%	2.5
Shrink ¹⁾		EMS	%	30
Gloss	60°	ISO 2813	-	130
Haze		ISO 14782	%	--

Barrier Properties (50 µm films)

O ₂ -Transmission rate	23°C/ 0 % RH	DIS/ISO 15105-1	cm ³ /m ² 24h bar	25
	23°C/85 % RH		cm ³ /m ² 24h bar	70
CO ₂ -Transmission rate	23°C/ 0 % RH	DIS/ISO 15105-2	cm ³ /m ² 24h bar	80
	23°C/85 % RH		cm ³ /m ² 24h bar	250
Moisture vapour transmission rate	23°C/85 % RH	DIS/ISO 15106-1	g/m ² 24h	20

Mechanical Properties

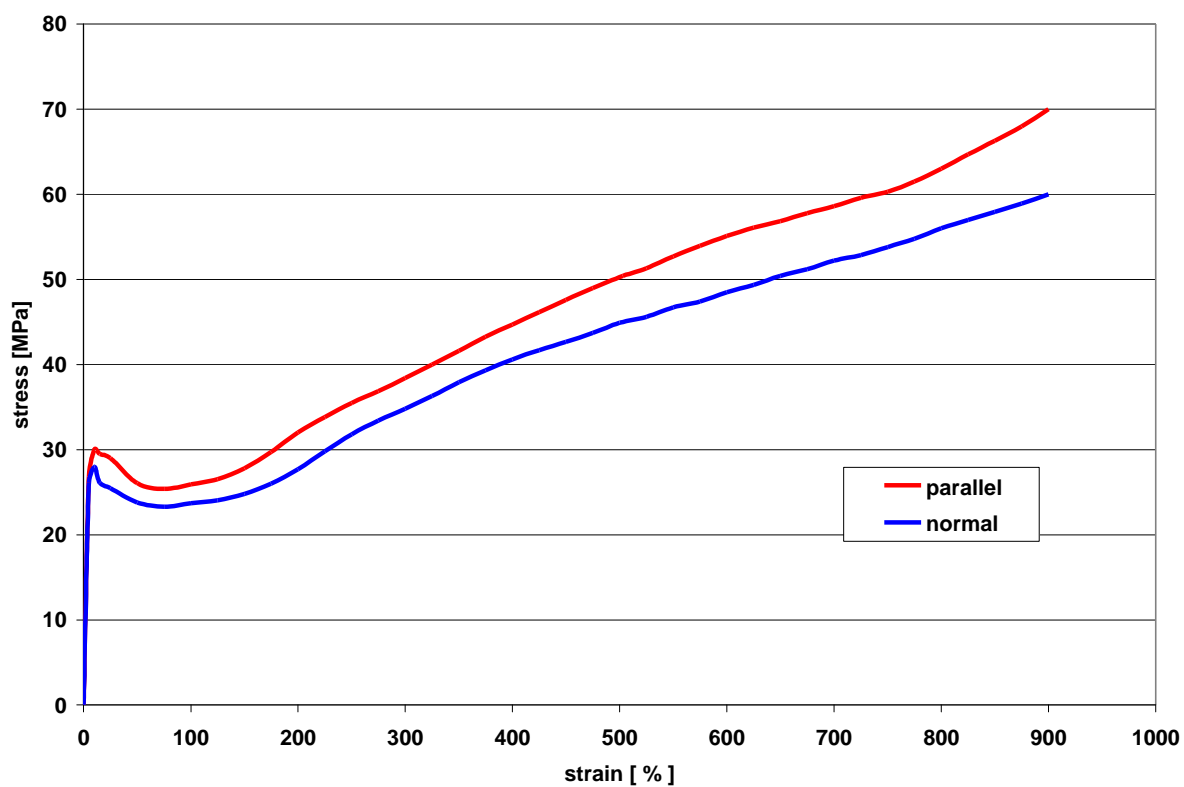
Tensile E-Modulus		ISO 527-2	MPa	650
Stress at yield	parallel	ISO 527-3	MPa	30
	normal			28
Strain at yield	parallel	ISO 527-3	%	10
	normal			10
Stress at break	parallel	ISO 527-3	MPa	70
	normal			60
Strain at break	parallel	ISO 527-3	%	900
	normal			900
Tear resistance	parallel	ISO 6383-1	N/mm	50
	normal			75
Elmendorf tear resistance	parallel	ISO 6383-2	N	20
	normal			20
Dart drop impact	A	ISO 7765-1	g	--
	B			--
Gelboflex test	900 cycles	EMS	holes/ m ²	200

Product nomenclature acc. ISO 1874: PA 66/610, FT, 18-030

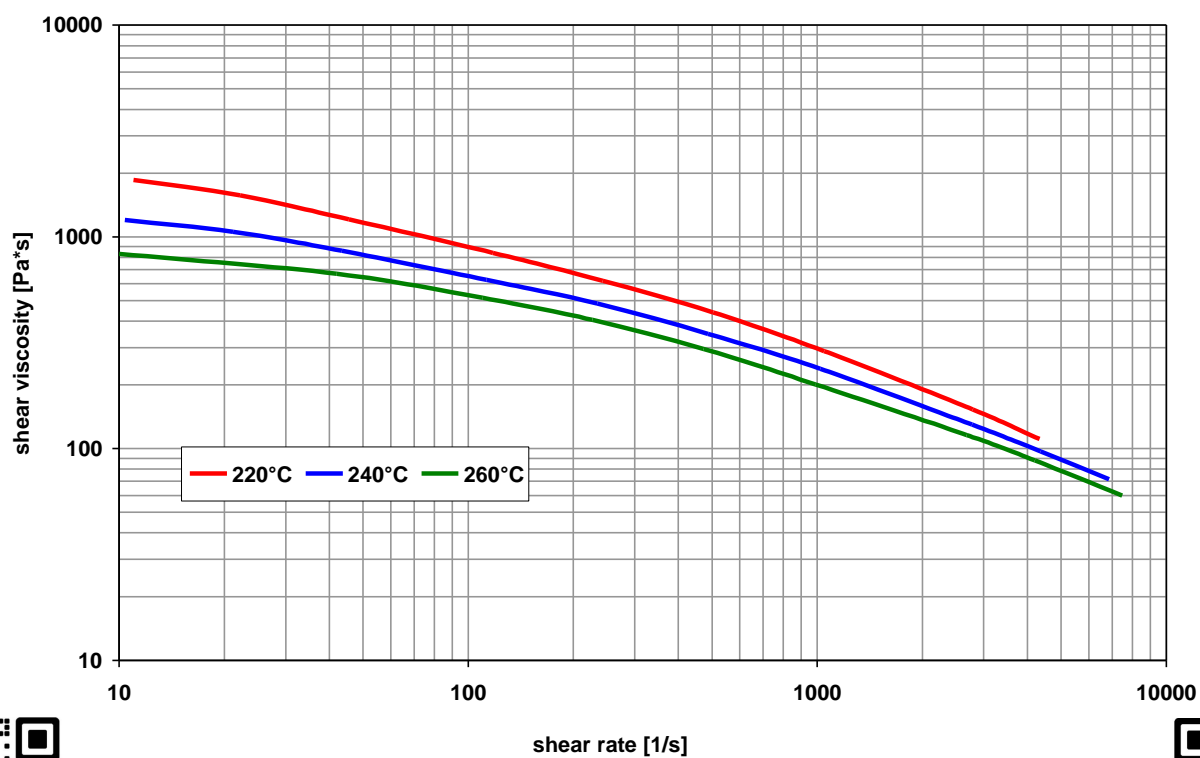
¹⁾ 80 µm film applied on 160 µm Ionomer, biaxially oriented at 70°C (draw ratio 2:1), afterwards shrinkage in water at 85°C



Stress & Strain Grilon BM 20 SBG



Viscosity function Grilon BM 20 SBG



Processing information for the extrusion of Grilon BM 20 SBG

This technical data sheet for Grilon BM 20 SBG provides you with useful information on material preparation, machine requirements and processing.

MATERIAL PREPARATION

Grilon BM 20 SBG 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

Grilon BM 20 SBG is dried and packed with a moisture content of less than 0.10 %. The processing of moist material reduces the optical and mechanical quality of the application. A too high moisture content can result in fish eyes, streaks and brittleness.

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 time

If there is only slight evidence of foaming of the melt or just traces of silver streaks on the part, then the above mentioned minimal drying time will be sufficient. Material, which is stored in open over days, which shows strong foaming, is unusually easy flowing melt or streaks on the article, then the maximal drying time is required.

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 or desiccant dryers and temperatures above 100°C or vacuum ovens should be avoided.

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

MACHINE REQUIREMENTS

Grilon BM 20 SBG can be processed economically and without problems on all extrusion lines suitable for polyamides.

Screw

Wear protected, Universal 3 zone screws are recommended.

Screw

Length:	24 D - 30 D
Compression ration:	2.5 - 3.5

Heating

At least three separately controllable heating zones, capable of reaching cylinder temperatures of up to 270°C are recommended. The cylinder flange and adapter must be able to be heated.

PROCESSING

Temperatures

For the start up of processing Grilon BM 20 SBG the following parameters can be recommended:

Temperatures

Hopper	15 - 60°C
Zone 1	220 - 240°C
Zone 2	230 - 250°C
Zone 3	240 - 260°C
Adapter	240 - 260°C
Mould	240 - 260°C
Die	240 - 260°C
Melt	240 - 260°C

In cases where the use of grooved feed zones is employed it is recommended to temper this zone between 60 and 80°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

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

