

PRELIMINARY TECHNICAL DATA SHEET

Grilon XE 16106 (TSGL-50/4 V0) NATURAL

General product description

Grilon XE 16106 (TSGL-50/4 V0) NATURAL is based on a heat stabilised semi-crystalline Polyamide PA66+PA6 and 50% long glass fibres.

Grilon XE 16106 (TSGL-50/4 V0) NATURAL is characterised by the following key-properties:

- flame retardancy of V-0 at 1.6 mm
- Glow wire ignition 825°C (GWIT), 960°C (GWFI)
- high stiffness and strength even after conditioning and over a wide temperature range
- excellent notched impact resistance also at low temperatures
- low creep
- high heat distortion temperatures
- good dimensional stability and little warpage
- good surface appearance and ease of processing

Grilon XE 16106 is halogen free and does not contain red phosphorus. It complies with the regulations acc. RoHS (2002/95/EC) and is not affected by the guideline 2002/96/EC (WEEE) for Electro-Appliances.

The product has been designed for injection moulding of technical parts especially in the area of die-cast metal replacement.

Grilon XE 16106 (TSGL-50/4 V0) NATURAL is used in the following market segments:

- electro and electronics
- mechanical engineering
- household and appliances

The glass-fibres are aligned in parallel and are just as long as the pellets (usually 10 mm).

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PROPERTIES

Mechanical Properties

		Standard	Unit	State	Grilon XE 16106 NATURAL
Tensile E-Modulus	1 mm/min	ISO 527	MPa	dry cond.	16.500 11.500
Tensile strength at break	5 mm/min	ISO 527	MPa	dry cond.	190 155
Elongation at break	5 mm/min	ISO 527	%	dry cond.	1.9 2.1
Impact strength	Charpy, 23°C	ISO 179/1eU	kJ/m ²	dry cond.	70 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.	30 30
Notched impact strength	Charpy, -30°C	ISO 179/1eA	kJ/m ²	dry cond.	30 30
Ball indentation hardness		ISO 2039-1	MPa	dry cond.	305 230

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	230
Thermal expansion coefficient long.	23 - 55°C	ISO 11359	10 ⁻⁴ /K	dry	0.20
Thermal expansion coefficient trans..	23 - 55°C	ISO 11359	10 ⁻⁴ /K	dry	0.45
Maximum usage temperature	long term	ISO 2578	°C	dry	120 -140
Maximum usage temperature	short term	ISO 2578	°C	dry	220

Electrical Properties

Dielectric strength		IEC 60243-1	kV/mm	dry cond.	25 20
Comparative tracking index	CTI	IEC 60112	-	cond.	600
Specific volume resistivity		IEC 60093	Ω m	dry cond.	10 ¹¹ 10 ¹⁰
Specific surface resistivity		IEC 60093	Ω	cond.	10 ¹²

General Properties

Density		ISO 1183	g/cm ³	dry	1.63
Flammability (UL 94)	1.6 mm	ISO 1210	grade		V0
Glow Wire Ignition Temperature	1.6 mm	IEC60695-2-13	°C	dry	> 775
Glow Wire Flammability Index	1.6 mm	IEC60695-2-12	°C	dry	960
Water absorption	23°C/sat.	ISO 62	%		4.0
Moisture absorption	23°C/50% r.h.	ISO 62	%		1.1
Linear mould shrinkage	long.	ISO 294	%	dry	0.15
Linear mould shrinkage	trans.	ISO 294	%	dry	0.35

Product Designation	ISO 16396-PA66+6, GF50 FR,M1G,C14-160N
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Processing information for the injection moulding of Grilon XE 16106 (TSGL-50/4 V0) NATURAL

In order to get the best properties out of Grilon XE 16106 (TSGL-50/4 V0) NATURAL, fibre damage should be avoided as much as possible.

The most important parameters for fibre length preservation are:

- screw speed and back-pressure
- injection speed
- runner and gate geometry

The following processing recommendations will give you some useful hints. For any further questions, please contact our application development experts.

MATERIAL PREPARATION

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.

Handling with a vacuum pneumatic conveying system in general is possible, low transportation speeds are recommended.

Drying

During its manufacturing process Grilon XE 16106 (TSGL-50/4 V0) NATURAL is packed with a moisture content of $\leq 0.10\%$. Should the packaging be damaged or the material is left open too long, the material must be dried. A too high moisture content can show by a foaming melt and silver streaks on the moulded part.

Drying recommendations:

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

The moisture content for processing Grilon XE 16106 NATURAL must be lower than 0,1% .

In case of long residual times in the machine hopper (more than 1 hour), a hopper heating or hopper dryer is useful.

MACHINE REQUIREMENTS

Grilon XE 16106 NATURAL can be processed on standard injection moulding machines. However, excessive fibre damage has to be avoided to preserve the characteristics of long fibre reinforced materials.

Screw

Standard polyamide screw	
Diameter:	> 30 mm
Length:	18 D - 22 D
Feed zone length:	60 %
Compression ratio:	2 - 2.5
Flight depth metering zone:	> 2 mm

Processing the material on smaller screws is possible, however a higher fibre damage may occur.

Shot volume

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

Selecting the barrel size

$$\text{Shot volume} = 0.5 - 0.8 \times (\text{max. shot volume})$$

Heating

At least three separately controllable heating zones are required for cylinder temperatures up to 350°C. A separate nozzle heating is necessary. The feed opening temperature must be controllable (cooling).

Nozzle

Shut off nozzle may damage the fibres, it is recommended to use open nozzles with an appropriate diameter.

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⁾ average cavity pressure of 750 bar

TOOLING

To avoid fibre damage in the tool, large flow cross-sections are recommended. Furthermore, sharp edges and corners should be avoided. The tool steel should be wear and corrosion protected as for any other reinforced polyamide. In areas of high flow speeds (tunnel gate, hot runner) we recommend additional care for wear protection. Special precautions due to the long fibres are not necessary.

Gate and runner

To avoid damage of the fibres it is strictly recommended to use sufficient gate diameters. Sharp edges and corners should be avoided in the runner.

The gating itself should not be located in areas of high stresses, as the fibres will show a random orientation around the injection gate.

Gate diameter

0.8 x thickest wall section of the injection moulding part

Runner diameter

1.4 x thickest wall section of the injection moulding part (min. 4 mm)

Hot runner systems are well suited for processing of Grilon XE 16106 NATURAL as long as they do not have sharp corners or very small diameters. Shut-off hot runners must provide sufficient free section for the melt.

Venting

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

PROCESSING

Basic machine settings

For the processing Grilon XE 16106 (TSGL-40/4 V0) BLACK 9465, following machine settings are recommended:

Temperatures

Feed	80°C
Zone 1	285°C
Zone 2	290°C
Zone 3	295°C
Nozzle	290°C
Tool	80 - 120°C
Melt	290 - 300°C

Pressures / Speeds

Injection speed	low to medium
Hold-on pressure (spec.)	300 - 800 bar
Dynamic pressure (spec.)	20-80 bar
Screw speed	4 - 20 m/min

Experience has shown, that especially the injection speed has a strong influence on the final part properties. In many cases, slow injection speeds showed better results.

In order to reduce fibre damage, the material should be plasticised as gentle as possible. The available cooling time should fully be used as dosing time.

The above recommendations are used for various parts, however, in some cases, deviating process parameters can be applied. Our Technical Service will support you in optimizing your machine settings

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:

- Computer simulations
- Prototype tooling
- Material selection
- Processing support
- Specific part tests
- Mould and component design

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

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