

GRIVORY HT

GRIVORY XE 4221 RED 7325

Product description

Grivory XE 4221 red 7325 is a 30% glass-fibre reinforced engineering thermoplastic material based on a semi-crystalline, partially aromatic copolyamide.

This Grivory HT product is partially based on renewable raw materials.

ISO polymer designation: PA 10T/X

ASTM designation: PPA, polyphthalamide

Grivory XE 4221 red 7325 (black appearance) exhibits low moisture absorption, high stiffness and high heat distortion temperature.

Grivory XE 4221 red 7325 is laser weldable with Grivory XE 4202 (PPA Extrusion grade).

It is suitable for the production of laser weldable quick-connectors for tube-systems made of Grivory HT extrusion grades (e.g Grivory XE 4202).



PROPERTIES

Mechanical Properties		Standard	Unit	State	Grivory XE 4221 red
Tensile E-modulus	1 mm/min	ISO 527	MPa	dry cond.	9500 9500
Tensile strength at break	5 mm/min	ISO 527	MPa	dry cond.	175 170
Elongation at break	5 mm/min	ISO 527	%	dry cond.	2.5 2.5
Impact strength	Charpy, 23°C	ISO 179/2-1eU	kJ/m ²	dry cond.	50 40
Impact strength	Charpy, -30°C	ISO 179/2-1eU	kJ/m ²	dry cond.	40 40
Notched impact strength	Charpy, 23°C	ISO 1792-/1eA	kJ/m ²	dry cond.	11 10
Notched impact strength	Charpy, -30°C	ISO 179/2-1eA	kJ/m ²	dry cond.	10 9
Ball indentation hardness		ISO 2039-1	MPa	dry cond.	220 220

Thermal Properties

Melting point	DSC	ISO 11357	°C	dry	265
Heat deflection temperature HDT/A	1.80 MPa	ISO 75	°C	dry	220
Heat deflection temperature HDT/C	8.00 MPa	ISO 75	°C	dry	110
Thermal expansion coefficient long.	23-55°C	ISO 11359	10 ⁻⁴ /K	dry	23
Thermal expansion coefficient trans.	23-55°C	ISO 11359	10 ⁻⁴ /K	dry	98
Maximum usage temperature	long term	ISO 2578	°C	dry	150
Maximum usage temperature	short term	EMS	°C	dry	210

Electrical Properties

Dielectric strength		IEC 60243-1	kV/m	dry cond.	40 39
Comparative tracking index	CTI	IEC 60112	-	cond.	600
Specific volume resistivity		IEC 60093	Ω · m	dry cond.	10 ⁹ 10 ⁹
Specific surface resistivity		IEC 60093	Ω	cond.	10 ¹¹

General Properties

Density		ISO 1183	g/cm ³	dry	1.34
Flammability (UL 94)	0.4 - 3.2 mm	ISO 1210	rating	-	HB
Water absorption	23°C/saturated	ISO 62	%	-	2.0
Moisture absorption	23°C/50% r.h.	ISO 62	%	-	0.9
Linear mould shrinkage	long.	ISO 294	%	dry	0.5
Linear mould shrinkage	trans.	ISO 294	%	dry	0.8

Product nomenclature acc. ISO 1874: PA 10T/X, MH, 14-100, GF30

Information on Injection Moulding of Grivory XE 4221 red 7325

This technical data sheet for Grivory XE 4221 red 7325 provides you with useful information on material preparation, machine requirements, tooling and processing.

MATERIAL PREPARATION

Grivory XE 4221 red 7325 is delivered dry and ready for processing in sealed packaging. Pre-drying 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 XE 4221 red 7325 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.

The drying can be done as follows:

Desiccant dryer

Temperature	max. 80°C
Time	4 - 12 hours
Dew point	-40°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 shows strong foaming, unusually easy flowing, streaks and rough surface on the moulded 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 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 colour only!) as a comparison sample.

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

Use of Regrind

Grivory XE 4221 red 7325 is a thermoplastic material. This allows recycling of sprues, runners and rejected components

It is recommended to add a maximum of 25% regrind as long as the requirements on the final part allow the addition of regrind.

To ensure a trouble free processing, special precaution has to be taken by the moulder. Following points have to be kept in mind:

- Avoid moisture absorption of the regrind (otherwise drying is necessary)
- Contamination by foreign material such as other polymers, dust, oil has to be avoided

Property and colour changes of the part can be controlled by proper handling measures.

MACHINE REQUIREMENTS

Grivory XE 4221 red 7325 can be processed economically on all injection moulding machines suitable for polyamides.

Screw

Wear and corrosion protected, 3-zone universal screws with check 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 check valve (without decompression distance).

Selecting the injection unit

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

Heating

At least three separately controllable heating zones, able of reaching cylinder temperatures up to 350°C are required. 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 screw after injection, 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 - 65 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 HT are setting very quickly 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. The following values can be considered:

(VDI 3400)	12	15	18	21	24	27
Depth of roughness (µm)	0.4	0.6	0.8	1.1	1.6	2.2
Demoulding angle (%)	1	1	1.1	1.2	1.3	1.5

(VDI 3400)	30	33	36	39	42	45
Depth of roughness (µm)	3.2	4.5	6.3	9	13	18
Demoulding angle (%)	1.8	2	2.5	3	4	5

Venting

In order to prevent burn marks and to improve the weld line strength, proper venting of the mould cavity should be provided. Venting channels on the parting surface with dimensions of depth 0.02 mm and width 2 - 5 mm are recommended.

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 x 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)

PROCESSING

Mould Filling, Post Pressure and Dosing

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

The injection speed should be chosen to be reduced towards the end of the filling process in order to avoid overheating and burning. For dosing at low screw speeds and pressure the cooling time should be fully utilised.

Basic Machine Settings

In order to start up the machines for processing Grivory XE 4221 red 7325, following basic settings can be recommended:

Temperatures

Flange	60 - 80°C
Zone 1	280 - 310°C
Zone 2	280 - 310°C
Zone 3	280 - 310°C
Nozzle	280 - 310°C
Tool	100 - 140°C
Melt	280 - 320°C

Speeds / Pressures

Injection speed	medium - high
Hold-on pressure (spec.)	500 - 800 bar
Dynamic pressure (hydr.)	5 - 15 bar
Peripheral screw speed	0.1 - 0.3 m/s

Start-up and Purging

Foreign materials in the cylinder should be removed with suitable purging materials. Hot-runner systems should be purged likewise. Glass fibre reinforced polyamide 66 is a suitable “bridging material”.

Cylinder heating should start with a clean, product-free screw, starting from the temperature level of the “bridging material” of 300°C up to the required temperature level of 300-330°C (see processing data).

After at least three full dosings (free-shots) - applying the shortest possible residence time - the start up procedure can be implemented.

After completion of production with Grivory HT the screw, cylinder and melt distribution system should be cleaned out thoroughly.

Conditioning

The dimensions and the mechanical properties of Grivory HT products are only marginally influenced by moisture absorption. For testing purposes, parts can be stored in a climatic chamber until an increase in weight of 1 % has been achieved. In order to avoid stress through swelling, conditioning in hot water is to be avoided.

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 advise you. Simply call one of our sales offices.

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Generated / updated: FPA / 08.2016

This version replaces all previous product specific data sheets.

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