TECHNICAL DATASHEET

Grilamid LV-65H SST natural

PA12-GF65

EMS-GRIVORY
Material Database

Processing
Injection molding

Delivery form
Granules

Special Characteristics
Light stabilized or stable to light

Regional Availability
North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Product Information

Product-nomenclature: ISO 16396-PA12,GF65,M1HR,C18-190

Mechanical Properties	dry/cond	Unit	Standard
Tensile modulus	19000 / 18000	MPa	ISO 527
Stress at break	190 / 180	MPa	ISO 527
Strain at break	3 / 3.5	%	ISO 527
Charpy impact strength, +23°C	- / 75	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	- / 75	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	- / 15	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	- / 13	kJ/m²	ISO 179/1eA
Ball indentation hardness	- / 200	MPa	ISO 2039-1
Shore A hardness (15s)	- / 88	-	ISO 868

Thermal Properties	dry/cond	Unit	Standard
Melting temperature, 10°C/min	178 / -	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	165 / -	°C	ISO 75-1/-2
Temp. of deflection under load, 8.00 MPa	150 / -	°C	ISO 75-1/-2
Max. usage temperature (long term)	90 - 120	°C	ISO 2578
Max. usage temperature (short term)	150	°C	EMS

Electrical Properties	dry/cond	Unit	Standard
Electric strength	- / 35	kV/mm	IEC 60243-1
Comparative tracking index	- / 600		IEC 60112
Volume resistivity	- / 1E12	Ohm*m	IEC 62631-3-1
Surface resistivity	- / 1E12	Ohm	IEC 62631-3-2

General Properties	dry/cond	Unit	Standard
Density	1700 / -	kg/m³	ISO 1183
Burning behav. at thickness h	HB / -	class	IEC 60695-11-10
Thickness tested	0.8 / -	mm	

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General Properties	dry/cond	Unit	Standard
Water absorption	0.7 / -	%	Sim. to ISO 62
Humidity absorption	0.3 / -	%	Sim. to ISO 62
Molding shrinkage, parallel	0.1 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	0.45 / -	%	ISO 294-4, 2577

Processing Injection Molding	Value	Unit	Standard
Hopper zone	≤80	°C	
Feeding zone	≤260	°C	
Compression zone	≤265	°C	
Metering zone	≤270	°C	
Nozzle (IM)	≤265	°C	
Melt	260 - 280	°C	
Mold surface temperature	80 - 100	°C	
Injection speed	Medium - High	-	
Pressure	300 - 800	bar	
Dynamic pressure (hydraulic)	5 - 15	bar	
Circumferencial screw speed	0.8 - 1.7	m/s	

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