

**Technical Data Sheet**

**Material Information:** Partially Aromatic copolyamide with a combination of semi-crystalline polyamide reinforced with 30% Glass fiber, heat stabilized and lubricated for injection molding process.

**Notes:** Halogen and red phosphorus free flame retardant grades, compliance with RoHS derivatives, with rating UL94 V0 and glow-wire at 960°C. Eplamid HT00 grades offer the following unique properties in general conditions, and even after moisture absorption: Good Surface Finish, Good Dimensional Stability, Good High Temperature Properties, Good Chemical Resistance to Glycols and Oils and Excellent Creep Resistance. Eplamid HT02 grades are used for molding technical parts where higher operating temperatures and higher stiffness in moist environments are required.

Properties	Test Method	Unit	Value	
			Dry	Cond
<b>Physical properties</b>				
Density (23°C)	ISO 1183	g/cm <sup>3</sup>	1,45	
Ash content	ISO 3451-4	%	30	
Determination of water content	ISO 15512	%	0,1	
Mold shrinkage- parallel/normal (3mm)	ISO 294-4	%	0,3/1,1	
<b>Mechanical properties</b>				
Tensile modulus (1mm/min) (23°C)	ISO 527-2	MPa	12000	10800
Tensile stress at break (5mm/min) (23°C)	ISO 527-2	MPa	185	160
Tensile strain at break (5mm/min) (23°C)	ISO 527-2	%	2,5	2,5
Notched izod impact (23°C)	ISO 180/1A	kJ/m <sup>2</sup>		
Unnotched izod impact (23°C)	ISO 180/1U	kJ/m <sup>2</sup>		
Notched charpy impact (23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	11	11
Unnotched charpy impact (23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	60	60
Notched charpy impact (-30°C)	ISO 179/1eA	kJ/m <sup>2</sup>	11	11
Ball indentation hardness	ISO 2039-1	Mpa	280	270
<b>Thermal properties</b>				
Melting point	ISO 3146	°C	315	
Temp. of deflection under load (0,45 MPa)	ISO 75-2/B	°C	295	
Temp. of deflection under load (1,80 MPa)	ISO 75-2/A	°C	290	
Maximum working temp. long term	ISO 2578	°C	140	
Maximum working temp. short term	ISO 2578	°C	250	
<b>Flammability &amp; electrical properties</b>				
Flammability classification (0,8mm) - UL 94	EN 60695-11-10	-	V0	
Glow Wire - GWFI (0,8 mm)	EN 60695-2-12	°C	960	
Glow Wire - GWIT (0,8 mm)	EN 60695-2-13	°C	800	
Comparative tracking index - CTI (Solution A)	EN 60112	V	230	
Surface resistivity	ASTM D257	Ω/sq		
Dielectric strength	IEC 60243-1	kV/mm	30	25

**Test conditions**

Laboratory conditions are 23 ±2°C and 45-55 % RH.

*The information in this data sheet is given in good faith but without warranty. These datas do not release you from the obligation to test our products as to their suitability for the intended processes and uses. The application use and processing of our products and the products manufactured by you are beyond our control. Therefore, entirely your own responsibility. Eplamid, Eplon, Epoplen and Epimix are registered trademarks of Epsan Plastik San. Ve Tic. A.Ş.*

**EPLAMID HT GRADES PROCESSING CONDITIONS**

**Handling EPLAMID HT Polymer**

For optimum properties the polymer must be kept below 0.1 % moisture level. Flow in thin sections will be reduced at high moisture levels. Dried resin, resin from opened bags, or regrind that is not going to be used immediately should be stored in a way that prevents moisture pickup.

**Drying**

For best properties Eplamid HT polymer must be dried to less than 0.1% moisture. This low level of moisture must be maintained throughout the molding run by the use of dehumidified dryers.

Typical times to dry the Eplamid HT polymer approximately 7 to 9 hours. It is normally recommended to dry the resin in a dehumidified hopper dryer that has air flow rates of 3.0 to 3.7 m<sup>3</sup> /hr per kg/hr of resin being processed. The air velocity should be

**Regrind**

For optimum physical properties, the amount of regrind must be kept below 25%. The use of up to 25% regrind reduces the elongation, tensile strength, and Izod impact properties of the Eplamid HT polymer.

- \* Either feed the regrind straight back into the machine, or pre-dry the regrind before usage.
- \* Store regrind in a dry, clean place to avoid contamination and excess moisture.
- \* Ensure sharp cutting blades to keep dust generation to a minimum; cut glass fibre reinforced material when it is still hot.
- \* Clean the grinder regularly to avoid build up of dust.
- \* Do not use splayed, discoloured or degraded parts and runners.

**Machine and Operating Conditions**

Material	HT00	HT01	HT02	HT03
Pref. Melt Temp.	300-330°C	300-325°C	300-320°C	265-300°C
Rear	310-325°C	305-325°C	305-320°C	280-290°C
Center	305-325°C	315-325°C	310-320°C	280-290°C
Front	320-325°C	320-330°C	320-325°C	285-290°C
Nozzle	320-330°C	320-330°C	320-330°C	285-300°C

If the shot size is small compared to the machine rated shot size and/or if long cycles are used, then the rear zone temperatures should be reduced. The recommended melt temperatures are also given above. To limit the thermal degradation of the Eplamid HT polymer, the residence time of the polymer in the cylinder should be less than 8 min. The preferred residence time is 4 to 6 min.

**Nozzle Temperature**

The nozzle temperature should be adjusted so that the resin does not drool or prematurely freeze off. Above table also gives more details on temperature profiles.

**Mould Temperature**

Below table lists the preferred mold surface temperatures for maximum polymer crystallinity as a function of part thickness. To mold the HT00 series resins, oil heaters with high temperature rated hoses or electric mold heating will be needed.

**Tool Surface Temperature ≥ 140°C**

Polymers in the HT01, HT02 and HT03 series can be molded in waterheated molds. At the temperatures listed below, the mold shrinkage will be maximized and the post-mold shrinkage or annealing shrinkage will be minimized.

**Screw Speed and Back Pressure**

To minimize glass fiber breakage in the reinforced Eplamid HT polymer, the screw speed should be selected so that the screw retraction time is at least 90% of the mold closed time. Maximum tangential screw speeds should be 9.0 m/min. The minimum amount of hydraulic back pressure should be used consistent with uniform screw recovery times, typically no higher than 3 bar.

**Packaging**

- \* Pre-drying is not necessary in Eplamid HT grades.
- \* Upon request, materials can be packed into 1.000 kg to 1.250 kg octabins and big bags with PE in-liner bags.
- \* For other packing options, please contact your sales representatives.

*The information in this data sheet is given in good faith but without warranty. These datas do not release you from the obligation to test our products as to their suitability for the intended processes and uses. The application use and processing of our products and the products manufactured by you are beyond our control. Therefore, entirely your own responsibility. Eplamid, Eplon, Epopen and Epimix are registered trademarks of Epsan Plastik San. Ve Tic. A.Ş.*