

1. Description

Greemas® Greemas® 60622 is a 30% glass fibre reinforced Polyamide 1010 with excellent impact and notched impact strength, good stiffness and strength profile, high dimensional stability and heat resistance. The resin based on renewable resources over 95% according to ASTM D6866.

2. Properties

● General Properties

Item		Test Method	Unit	State	Data
Density	-	ISO 1183	g/cm ³	dry	1.26
Mass flow rate	(210°C, 2.16kg)	ISO 1133	g/10min	dry	15
Linear mould shrinkage	long.	ISO 294	%	dry	0.10
Linear mould shrinkage	trans	ISO 294	%	dry	0.50

● Mechanical Properties

Item		Test Method	Unit	State	Data
Tensile strength at break	(10mm/min)	ISO 527 -1,-2	MPa	cond.	125
Elongation at break	(10mm/min)	ISO 527 -1,-2	%	cond.	10
Flexural strength at break	(2mm/min)	ISO 178	MPa	cond.	180
Flexural modulus	(2mm/min)	ISO 178	MPa	cond.	5800
Notched impact strength	(4mm, 23°C)	ISO 179/1eA	KJ/m ²	cond.	18.0

● Thermal Properties

Item		Test Method	Unit	State	Data
Melting point	(DSC)	ISO 11357	°C	dry	200
Heat deflection temperature HDT/B	(0.45 MPa)	ISO 75	°C	dry	175
Heat deflection temperature HDT/A	(1.80 MPa)	ISO 75	°C	dry	165

* These property data are believed to be representative under specific test conditions and are not intended to serve as product specifications.

3. Applications

- ✓ Stationery
- ✓ Cars
- ✓ Toys
- ✓ Electrical equipment

4. Drying Conditions

The drying temperature at 90 – 110 °C with a duration 3 – 5 hrs is recommended. To obtain better product performance, a desiccant dryer is also recommended.

5. Recommended Processing Conditions

The following is the recommended injection molding conditions for the first trial:

Condition	Barrel Temp.	Nozzle Temp.	Mold Temp.	Screw Speed	Injection Pressure	Injection Rate	Holding Pressure
Value	250 – 270	240– 260	< 40	50– 100	120 – 150	50– 70	85 – 100
Unit	°C	°C	°C	rpm	kg/cm ²	%	kg/cm ²

6. Recommended Storage Conditions

Store Greemas® 60622 in cool and dry place. Protect from direct sunlight, rain and violent temperature fluctuation. Fire is inhibited around storage area. No special restrictions on storage with other products. The recommended storage duration is five years.

7. Appearance and Packaging

Greemas® 60622 is in pellet form with a package of 25 Kg net weight per paper bag.