TORZEN® G3500HR BK34

Polyamide 66

INVISTA Engineering Polymers

Message:

TORZEN® G3500HR BK34 is a 35% glass reinforced, heat stabilized, black, PA66 resin suitable for hydrolysis resistant applications as well as many injection molding applications where high tensile strength and dimensional stability are needed.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 35% filler by weight		
Additive	heat stabilizer		
Features	Good dimensional stability High tensile strength Hydrolysis resistance Thermal Stability Good demoulding performance		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.42	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow: 2.00mm	0.90 - 1.1	%	ISO 294-4
Flow: 2.00mm	0.25 - 0.35	%	ISO 294-4
Water Absorption			ISO 62
23°C, 24 hr	1.1	%	ISO 62
Equilibrium, 23°C, 50% RH	1.7	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	11500	MPa	ISO 527-2
Tensile Stress (Break)	210	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	10500	MPa	ISO 178
Flexural Stress	300	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179
-40°C	10	kJ/m²	ISO 179
23°C	12	kJ/m²	ISO 179
Notched Izod Impact (23°C)	12	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**

Heat Deflection Temperature			
0.45 MPa, not annealed	260	°C	ISO 75-2/B
1.8 MPa, not annealed	250	°C	ISO 75-2/A
Melting Temperature	262	°C	ISO 11357-3

Injection	Nominal Value	Unit
Drying Temperature	80	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.080 - 0.18	%
Rear Temperature	250 - 270	°C
Middle Temperature	270 - 290	°C
Front Temperature	270 - 290	°C
Nozzle Temperature	270 - 290	°C
Processing (Melt) Temp	280 - 300	°C
Mold Temperature	50 - 90	°C
Back Pressure	0.200 - 1.00	MPa
Cushion	4.00 - 6.00	mm
Vent Depth	7.0E-3 - 0.040	mm
Screw Speed	Low rpm	

Recommended distributors for this material

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