

TORZEN® G3300HR BK34

Polyamide 66

INVISTA Engineering Polymers

Message:

TORZEN® G3300HR BK34 is a 33% 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,33% Filler by Weight		
Additive	Heat Stabilizer		
Features	Good Dimensional Stability		
	Good Mold Release		
	Heat Stabilized		
	High Tensile Strength		
	Hydrolysis Resistant		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.41	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.90 to 1.1	%	
Flow : 2.00 mm	0.30 to 0.40	%	
Water Absorption			ISO 62
23°C, 24 hr	1.2	%	
Equilibrium, 23°C, 50% RH	1.8	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10500	MPa	ISO 527-2
Tensile Stress (Break)	205	MPa	ISO 527-2
Tensile Strain (Break)	3.1	%	ISO 527-2
Flexural Modulus	9500	MPa	ISO 178
Flexural Stress	285	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-40°C	10	kJ/m ²	
23°C	12	kJ/m ²	
Notched Izod Impact Strength (23°C)	12	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature			
0.45 MPa, Unannealed	255	°C	ISO 75-2/B
1.8 MPa, Unannealed	248	°C	ISO 75-2/A
Melting Temperature	262	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.080 to 0.18	%	
Rear Temperature	250 to 270	°C	
Middle Temperature	270 to 290	°C	
Front Temperature	270 to 290	°C	
Nozzle Temperature	270 to 290	°C	
Processing (Melt) Temp	280 to 300	°C	
Mold Temperature	50.0 to 90.0	°C	
Back Pressure	0.200 to 1.00	MPa	
Cushion	4.00 to 6.00	mm	
Vent Depth	7.0E-3 to 0.040	mm	
Screw Speed	Low rpm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

