

# TORZEN® G3300HS1L NC01

Polyamide 66  
INVISTA Engineering Polymers

Message:

TORZEN® G3300HS1L NC01 is a 33% glass reinforced, heat stabilized, natural, PA66 resin suitable for many injection molding applications where high tensile strength and dimensional stability are needed.

| General Information            |                                                       |       |             |
|--------------------------------|-------------------------------------------------------|-------|-------------|
| Filler / Reinforcement         | Glass fiber reinforced material, 33% filler by weight |       |             |
| Additive                       | heat stabilizer                                       |       |             |
| Features                       | Good dimensional stability                            |       |             |
|                                | High tensile strength                                 |       |             |
|                                | Thermal Stability                                     |       |             |
|                                | Good demoulding performance                           |       |             |
|                                |                                                       |       |             |
| Agency Ratings                 | EC 1907/2006 (REACH)                                  |       |             |
| RoHS Compliance                | RoHS compliance                                       |       |             |
| Appearance                     | Natural color                                         |       |             |
| Processing Method              | Injection molding                                     |       |             |
| Physical                       | Nominal Value                                         | Unit  | Test Method |
| Density                        | 1.41                                                  | g/cm³ | ISO 1183    |
| Molding Shrinkage              |                                                       |       | ISO 294-4   |
| Transverse flow: 2.00mm        | 0.90 - 1.1                                            | %     | ISO 294-4   |
| Flow: 2.00mm                   | 0.30 - 0.40                                           | %     | ISO 294-4   |
| Water Absorption               |                                                       |       | ISO 62      |
| 23°C, 24 hr                    | 1.2                                                   | %     | ISO 62      |
| Equilibrium, 23°C, 50% RH      | 1.8                                                   | %     | ISO 62      |
| 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/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 | 255            | °C   | ISO 75-2/B  |
|------------------------|----------------|------|-------------|
| 1.8 MPa, not annealed  | 248            | °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        |      |             |

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#### Recommended distributors for this material

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