

TORZEN® U4820L NC01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® U4820L NC01 is a general purpose PA66 resin suitable for injection molding and extrusion applications where fast cycles are required. It is lubricated internally and externally for excellent machine feed and mold release. Available in natural and black.

General Information	
UL YellowCard	E333734-100640052
Additive	Lubricant
Features	Fast Molding Cycle
	General Purpose
	Good Color Stability
	Good Mold Release
	Good Processability
	Lubricated
Uses	General Purpose
Agency Ratings	EC 1907/2006 (REACH)
RoHS Compliance	RoHS Compliant
Appearance	Black
	Natural Color
Processing Method	Extrusion
	Injection Molding

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	1.8	%	
Flow : 2.00 mm	1.9	%	
Water Absorption			ISO 62
23°C, 24 hr	1.4	%	
Equilibrium, 23°C, 50% RH	2.7	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3200	MPa	ISO 527-2/1
Tensile Stress (Yield)	82.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2
Yield	4.2	%	
Break	50	%	

Flexural Modulus	2900	MPa	ISO 178
Flexural Stress	95.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	4.3	kJ/m ²	
23°C	5.5	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	310	kJ/m ²	
23°C	No Break		
Notched Izod Impact Strength (23°C)	5.4	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	204	°C	ISO 75-2/B
1.8 MPa, Unannealed	66.0	°C	ISO 75-2/A
Melting Temperature	261	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow : 23 to 55°C, 2.00 mm	8.0E-5	cm/cm/°C	
Transverse : 23 to 55°C, 2.00 mm	8.0E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	3.0E+14	ohms	IEC 60093
Volume Resistivity (2.00 mm)	4.0E+14	ohms·cm	IEC 60093
Electric Strength (1.00 mm)	32	kV/mm	IEC 60243-1
Comparative Tracking Index (3.00 mm)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.400 mm)	V-2		UL 94
Glow Wire Flammability Index			IEC 60695-2-12
0.710 mm	960	°C	
1.50 mm	960	°C	
3.00 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.710 mm	960	°C	
1.50 mm	900	°C	
3.00 mm	750	°C	
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
Screw Speed	75 to 180	rpm
Cushion	4.00 to 6.00	mm
Vent Depth	7.0E-3 to 0.040	mm

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