

# TORZEN® HV360AHSL NC01

Polyamide 66  
INVISTA Engineering Polymers

Message:

TORZEN® HV360AHSL NC01 is a very high viscosity PA66 resin for extrusion and injection molding applications. It is heat stabilized and lubricated. Available in natural and black.

| General Information                       |                      |                    |              |
|-------------------------------------------|----------------------|--------------------|--------------|
| Additive                                  | heat stabilizer      |                    |              |
|                                           | Lubricant            |                    |              |
| Features                                  | Thermal Stability    |                    |              |
|                                           | Lubrication          |                    |              |
|                                           | Viscosity, High      |                    |              |
| Agency Ratings                            | EC 1907/2006 (REACH) |                    |              |
| RoHS Compliance                           | RoHS compliance      |                    |              |
| Appearance                                | Black                |                    |              |
|                                           | Natural color        |                    |              |
| Processing Method                         | Extrusion            |                    |              |
|                                           | Injection molding    |                    |              |
| Physical                                  | Nominal Value        | Unit               | Test Method  |
| Density                                   | 1.14                 | g/cm <sup>3</sup>  | ISO 1183     |
| Molding Shrinkage                         |                      |                    | ISO 294-4    |
| Transverse flow: 2.00mm                   | 1.9                  | %                  | ISO 294-4    |
| Flow: 2.00mm                              | 2.0                  | %                  | ISO 294-4    |
| Water Absorption (23°C, 24 hr)            | 2.1                  | %                  | ISO 62       |
| Viscosity Number (H2SO4 (Sulphuric Acid)) | 330                  | cm <sup>3</sup> /g | ISO 307      |
| Relative Viscosity                        |                      |                    |              |
| at 1% in sulfuric acid, nominal           | 5                    |                    |              |
| in formic acid, nominal                   | 360                  |                    | ASTM D789    |
| Mechanical                                | Nominal Value        | Unit               | Test Method  |
| Tensile Modulus                           | 3050                 | MPa                | ISO 527-2/1  |
| Tensile Stress (Yield)                    | 84.0                 | MPa                | ISO 527-2/50 |
| Tensile Strain                            |                      |                    | ISO 527-2    |
| Yield                                     | 4.1                  | %                  | ISO 527-2    |
| Fracture                                  | 25                   | %                  | ISO 527-2    |
| Flexural Modulus                          | 2900                 | MPa                | ISO 178      |

| Flexural Stress                  | 96.0           | MPa               | ISO 178     |
|----------------------------------|----------------|-------------------|-------------|
| Impact                           | Nominal Value  | Unit              | Test Method |
| Charpy Notched Impact Strength   |                |                   | ISO 179     |
| -30°C                            | 5.0            | kJ/m <sup>2</sup> | ISO 179     |
| 23°C                             | 5.6            | kJ/m <sup>2</sup> | ISO 179     |
| Charpy Unnotched Impact Strength |                |                   | ISO 179     |
| -30°C                            | No Break       |                   | ISO 179     |
| 23°C                             | No Break       |                   | ISO 179     |
| Notched Izod Impact (23°C)       | 5.0            | kJ/m <sup>2</sup> | ISO 180     |
| Thermal                          | Nominal Value  | Unit              | Test Method |
| Heat Deflection Temperature      |                |                   |             |
| 0.45 MPa, not annealed           | 186            | °C                | ISO 75-2/B  |
| 1.8 MPa, not annealed            | 63.0           | °C                | ISO 75-2/A  |
| Melting Temperature              | 261            | °C                | ISO 11357-3 |
| Injection                        | Nominal Value  | Unit              |             |
| Drying Temperature               | 90             | °C                |             |
| Drying Time                      | 3.0 - 4.0      | hr                |             |
| Suggested Max Moisture           | 0.010 - 0.080  | %                 |             |
| 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               |             |
| Screw Speed                      | 75 - 180       | rpm               |             |
| Cushion                          | 4.00 - 6.00    | mm                |             |
| Vent Depth                       | 7.0E-3 - 0.040 | mm                |             |

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