

TORZEN® U4630HSL BKB01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® U4630HSL BKB01 is a heat-stabilized, lubricated molding grade PA66 in black color. The heat stabilizer system has been designed to provide excellent property retention in high temperature applications. U4630HSL is also available in natural color.

General Information			
Additive	Heat Stabilizer		
	Lubricant		
Features	Good Flow		
	Good Processability		
	Heat Stabilized		
	Lubricated		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
	Natural Color		
Processing Method	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	2.3	%	
Flow : 2.00 mm	2.4	%	
Water Absorption (23°C, 24 hr)	1.7	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3200	MPa	ISO 527-2/1
Tensile Stress (Yield)	85.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2
Yield	4.2	%	
Break	30	%	
Flexural Modulus	3100	MPa	ISO 178
Flexural Stress	98.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	4.6	kJ/m ²	
23°C	5.3	kJ/m ²	

Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength (23°C)	5.7	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	195	°C	ISO 75-2/B
1.8 MPa, Unannealed	66.0	°C	ISO 75-2/A
Melting Temperature	265	°C	ISO 11357-3
CLTE			ASTM E831
Flow : 23 to 55°C, 2.00 mm	8.7E-5	cm/cm/°C	
Transverse : 23 to 55°C, 2.00 mm	8.8E-5	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (2.00 mm)	10	ohms·cm	IEC 60093
Electric Strength (1.00 mm)	18	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	960	°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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