

TORZEN® HV125A NC01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® HV125A NC01 is a high viscosity PA66 resin for extrusion and injection molding applications. It is non-lubricated. Available in natural and black.

General Information	
Features	Workability, good
	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	1.13	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow: 2.00mm	1.7	%	ISO 294-4
Flow: 2.00mm	1.7	%	ISO 294-4
Water Absorption (23°C, 24 hr)	1.8	%	ISO 62
Viscosity Number (H2SO4 (Sulphuric Acid))	230	cm ³ /g	ISO 307
Relative Viscosity			
at 1% in sulfuric acid, nominal	4		
in formic acid, nominal	125		ASTM D789
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3100	MPa	ISO 527-2/1
Tensile Stress (Yield)	80.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2
Yield	4.3	%	ISO 527-2
Fracture	50	%	ISO 527-2
Flexural Modulus	2900	MPa	ISO 178
Flexural Stress	93.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	2.3	kJ/m ²	ISO 179

23°C	5.2	kJ/m ²	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)	4.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	202	°C	ISO 75-2/B
1.8 MPa, not annealed	68.0	°C	ISO 75-2/A
Melting Temperature	263	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (2.00 mm)	1.0E+10	ohms·cm	IEC 60093
Dielectric Strength (1.00 mm)	10	kV/mm	IEC 60243-1
Comparative Tracking Index (3.00 mm)	> 600	V	ASTM D3638
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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