

TORZEN® HV125AHSL NC01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® HV125AHSL NC01 is a 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	1.13	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow: 2.00mm	2.0	%	ISO 294-4
Flow: 2.00mm	2.1	%	ISO 294-4
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	3000	MPa	ISO 527-2/1
Tensile Stress (Yield)	84.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2
Yield	4.3	%	ISO 527-2
Fracture	30	%	ISO 527-2
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	2.5	kJ/m ²	ISO 179
23°C	4.8	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
-30°C	100	kJ/m ²	ISO 179
23°C	No Break		ISO 179
Notched Izod Impact (23°C)	5.1	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	263	°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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