

TORZEN® G3500HS1L NC01

Polyamide 66

INVISTA Engineering Polymers

Message:

TORZEN® G3500HS1L NC01 is a 35% glass reinforced, heat stabilized, natural, PA66 resin suitable for many injection molding applications where high tensile strength and dimensional stability are needed.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 35% filler by weight		
Additive	heat stabilizer		
Features	Good dimensional stability		
	High tensile strength		
	Thermal Stability		
	Good demoulding performance		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Appearance	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.42	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow: 2.00mm	0.90 - 1.1	%	ISO 294-4
Flow: 2.00mm	0.25 - 0.35	%	ISO 294-4
Water Absorption			ISO 62
23°C, 24 hr	1.1	%	ISO 62
Equilibrium, 23°C, 50% RH	1.7	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11500	MPa	ISO 527-2
Tensile Stress (Break)	210	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	10500	MPa	ISO 178
Flexural Stress	300	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-40°C	10	kJ/m²	ISO 179
23°C	12	kJ/m²	ISO 179
Notched Izod Impact (23°C)	12	kJ/m²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			

0.45 MPa, not annealed	260	°C	ISO 75-2/B
1.8 MPa, not annealed	250	°C	ISO 75-2/A
Melting Temperature	262	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	80	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.080 - 0.18	%	
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	
Cushion	4.00 - 6.00	mm	
Vent Depth	7.0E-3 - 0.040	mm	
Screw Speed	Low rpm		

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