

TORZEN® U4640NL NC01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® U4640NL NC01 is a highly nucleated, lubricated PA66 resin suitable for injection molding, where fast crystallization and fast cycle times are required. It is lubricated internally and externally for excellent machine feed and mold release. U4640NL is also available in black.

General Information			
Additive	Lubricant		
	Nucleating Agent		
Features	Fast Molding Cycle		
	Good Color Stability		
	Good Flow		
	Good Mold Release		
	Good Processability		
	Lubricated		
	Nucleated		
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	1.0	%	
Flow : 2.00 mm	1.0	%	
Water Absorption (23°C, 24 hr)	1.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3400	MPa	ISO 527-2/1
Tensile Stress (Yield)	92.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2
Yield	4.2	%	
Break	16	%	
Flexural Modulus	3300	MPa	ISO 178
Flexural Stress	105	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength			ISO 179
-30°C	2.3	kJ/m ²	
23°C	3.0	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength (23°C)	3.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Melting Temperature	263	°C	ISO 11357-3
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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