

TORZEN Marathon™ FRU4800XHL BK01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN Marathon™ FRU4800XHL BK01 is a flame retardant, heat stabilized black Polyamide 66 resin suitable for injection molding. It does not contain elemental bromine, phosphorus or heavy metals.

General Information			
UL YellowCard	E333734-101430494		
Additive	Heat Stabilizer		
Features	Bromine Free		
	Flame Retardant		
	Good Processability		
	Heat Stabilized		
	Low (to None) Phosphorus Content		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	1.3 to 1.6	%	
Flow : 2.00 mm	1.3 to 1.6	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3900	MPa	ISO 527-2/1
Tensile Stress (Break)	73.0	MPa	ISO 527-2
Tensile Strain (Break)	13	%	ISO 527-2
Flexural Stress	105	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	2.8	kJ/m²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	85.0	°C	ISO 75-2/A
Melting Temperature	263	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI) (3.00 mm)	600	V	UL 746
Comparative Tracking Index (CTI) (3.00 mm)	PLC 0		ASTM D3638

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94, IEC 60695-11-10, -20
0.400 mm	V-0		
0.800 mm	V-0		
1.50 mm	V-0		
3.00 mm	V-0		
Glow Wire Flammability Index			IEC 60695-2-12
0.400 mm	960	°C	
0.800 mm	960	°C	
1.50 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.400 mm	990	°C	
0.800 mm	990	°C	
1.50 mm	990	°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	260 to 280	°C	
Front Temperature	270 to 280	°C	
Nozzle Temperature	270 to 280	°C	
Processing (Melt) Temp	270 to 290	°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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