

TORZEN® U3501 NC01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® U3501 NC01 is a high-flow, natural PA66 resin suitable for compounding, injection molding, and extrusion applications where ease of processing, good color and physical property retention are desired.

General Information			
Features	Good Color Stability		
	Good Processability		
	High Flow		
Uses	Compounding		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Appearance	Natural Color		
Processing Method	Compounding		
	Extrusion		
	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	1.1	%	
Flow : 2.00 mm	1.1	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3000	MPa	ISO 527-2/1
Tensile Stress (Yield)	82.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2
Yield	3.9	%	
Break	45	%	
Flexural Modulus	2700	MPa	ISO 178
Flexural Stress	91.0	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	4.5	kJ/m ²	
23°C	4.7	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		
23°C	No Break		

Notched Izod Impact Strength (23°C)	4.8	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	199	°C	ISO 75-2/B
1.8 MPa, Unannealed	69.0	°C	ISO 75-2/A
Melting Temperature	264	°C	ISO 11357-3
CLTE			DIN 53752
Flow : 23 to 55°C, 2.00 mm	8.0E-5	cm/cm/°C	
Transverse : 23 to 55°C, 2.00 mm	9.0E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	16 to 20	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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