

TORZEN® T3000HSL BK20

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® T3000HSL BK20 is a highly toughened, heat stabilized, black PA66 resin with good impact strength, stiffness, weld line strength, surface appearance and flow.

General Information			
Additive	Heat Stabilizer		
	Impact Modifier		
Features	Good Flow		
	Good Impact Resistance		
	Good Stiffness		
	Good Surface Finish		
	Good Toughness		
	Heat Stabilized		
	Impact Modified		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	1.6 to 1.9	%	
Flow : 2.00 mm	1.7 to 2.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	47.0	MPa	ISO 527-2
Tensile Strain			ISO 527-2
Yield	4.5	%	
Break	50	%	
Flexural Modulus	1900	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-40°C	19	kJ/m²	
23°C	82	kJ/m²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		

23°C	No Break		
Notched Izod Impact Strength (-30°C)	17	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	148	°C	ISO 75-2/B
1.8 MPa, Unannealed	61.0	°C	ISO 75-2/A
Melting Temperature	262	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow : 23 to 55°C, 2.00 mm	1.4E-4	cm/cm/°C	
Transverse : 23 to 55°C, 2.00 mm	1.2E-4	cm/cm/°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	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	
Cushion	4.00 to 6.00	mm	
Vent Depth	7.0E-3 to 0.040	mm	
Screw Speed	Low rpm		

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