

TORZEN® U4632HSL BKB01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® U4632HSL BKB01 is a heat-stabilized, lubricated molding grade PA66 in black color. The heat stabilizer system has been designed to provide excellent property retention in high temperature applications. U4632HSL is also available in natural color.

General Information			
Additive	Heat Stabilizer		
	Lubricant		
Features	Good Flow		
	Good Processability		
	Heat Stabilized		
	Lubricated		
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	2.3	%	
Flow : 2.00 mm	2.4	%	
Water Absorption (23°C, 24 hr)	1.9	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3100	MPa	ISO 527-2/1
Tensile Stress (Yield)	85.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2
Yield	4.3	%	
Break	30	%	
Flexural Modulus	3000	MPa	ISO 178
Flexural Stress	97.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	4.2	kJ/m ²	
23°C	5.0	kJ/m ²	

Charpy Unnotched Impact Strength			ISO 179
-30°C	260	kJ/m ²	
23°C	No Break		
Notched Izod Impact Strength (23°C)	5.0	kJ/m ²	
Thermal		Nominal Value	Test Method
Melting Temperature	261	°C	ISO 11357-3
CLTE			ISO 11359-2
Flow : 23 to 55°C, 2.00 mm	9.0E-5	cm/cm/°C	
Transverse : 23 to 55°C, 2.00 mm	9.2E-5	cm/cm/°C	
Flammability		Unit	Test Method
Flame Rating (0.400 mm)	V-2		UL 94
Glow Wire Flammability Index			IEC 60695-2-12
0.710 mm	960	°C	
1.50 mm	960	°C	
3.00 mm	960	°C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.710 mm	960	°C	
1.50 mm	960	°C	
3.00 mm	750	°C	
Injection		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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

