

TORZEN® M1500HS GR01

Polyamide 66

INVISTA Engineering Polymers

Message:

TORZEN® M1500HS GR01 is a 15% mineral reinforced, heat stabilized, grey, PA66 resin suitable for many injection molding applications where stiffness, dimensional stability, and good surface appearance are needed.

General Information			
Filler / Reinforcement	Mineral,15% Filler by Weight		
Additive	Heat Stabilizer		
Features	Good Dimensional Stability		
	Good Mold Release		
	Good Stiffness		
	Good Surface Finish		
	Heat Stabilized		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Appearance	Grey		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.23	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	1.5 to 2.0	%	
Flow : 2.00 mm	1.5 to 2.0	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3300	MPa	ISO 527-2
Tensile Stress (Break)	65.0	MPa	ISO 527-2
Tensile Strain (Break)	14	%	ISO 527-2
Flexural Modulus	3200	MPa	ISO 178
Flexural Stress	93.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.5	kJ/m²	ISO 179
Charpy Unnotched Impact Strength (23°C)	180	kJ/m²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	212	°C	ISO 75-2/B
1.8 MPa, Unannealed	77.0	°C	ISO 75-2/A
Melting Temperature	262	°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
Cushion	4.00 to 6.00	mm
Vent Depth	7.0E-3 to 0.040	mm
Screw Speed	Low rpm	

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