

TORZEN® HV240AHSL NC01

Polyamide 66
INVISTA Engineering Polymers

Message:

TORZEN® HV240AHSL NC01 is a high viscosity PA66 resin for extrusion and injection molding applications. It is heat stabilized and lubricated. Available in natural and black.

General Information			
Additive	heat stabilizer		
	Lubricant		
Features	Thermal Stability		
	Lubrication		
	Viscosity, High		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Appearance	Black		
	Natural color		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow: 2.00mm	1.8	%	ISO 294-4
Flow: 2.00mm	1.7	%	ISO 294-4
Water Absorption (23°C, 24 hr)	2.0	%	ISO 62
Viscosity Number (H2SO4 (Sulphuric Acid))	290	cm ³ /g	ISO 307
Relative Viscosity			
at 1% in sulfuric acid, nominal	5		
in formic acid, nominal	240		ASTM D789
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3200	MPa	ISO 527-2/1
Tensile Stress (Yield)	84.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2
Yield	4.2	%	ISO 527-2
Fracture	35	%	ISO 527-2
Flexural Modulus	3200	MPa	ISO 178

Flexural Stress	102	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	5.2	kJ/m ²	ISO 179
23°C	4.4	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		ISO 179
23°C	No Break		ISO 179
Notched Izod Impact (23°C)	5.3	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	209	°C	ISO 75-2/B
1.8 MPa, not annealed	69.0	°C	ISO 75-2/A
Melting Temperature	262	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	90	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.010 - 0.080	%	
Rear Temperature	250 - 270	°C	
Middle Temperature	270 - 290	°C	
Front Temperature	270 - 290	°C	
Nozzle Temperature	270 - 290	°C	
Processing (Melt) Temp	280 - 300	°C	
Mold Temperature	50 - 90	°C	
Back Pressure	0.200 - 1.00	MPa	
Screw Speed	75 - 180	rpm	
Cushion	4.00 - 6.00	mm	
Vent Depth	7.0E-3 - 0.040	mm	

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Recommended distributors for this material

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



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