

# TORZEN G3001HR BK34

Material Code

Colour Code

## DESCRIPTION

PA66 30% glass fiber reinforced injection moulding grade. Heat stabilized, hydrolysis resistance. Black colour.

Suitable for parts requiring high stiffness and good mechanical resistance.

ISO 1043 : PA66-T GF30

## MATERIAL HANDLING AND PROCESSING

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more.

Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

### Processing Parameters

|                   |                   |                  |
|-------------------|-------------------|------------------|
| Melt Temperature: | Mold Temperature: | Injection Speed: |
| 280 ÷ 300 °C      | 80 ÷ 100 °C       | Medium-high      |

## PRODUCT SAFETY AND APPROVALS

For safety instruction please refer to Material Safety Data Sheet

RoHS compliant 2011/65/UE and following amendments



# TECHNICAL DATA SHEET

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| PROPERTY                                |          | STANDARD      | UNIT              | VALUE                 |        |
|-----------------------------------------|----------|---------------|-------------------|-----------------------|--------|
|                                         |          |               |                   | DAM*                  | Cond** |
| Physical Properties                     |          |               |                   |                       |        |
| Density                                 |          | ISO 1183      | Kg/m <sup>3</sup> | 1370                  |        |
| Moulding shrinkage – Parallel / Normal  |          | ISO 294-4     | %                 | 0,30-0,40 / 0,95-1,05 |        |
| Moisture absorption 23°C – 50%RH        | 2mm thk  | ISO 62        | %                 | 1,8                   |        |
| Water absorption, 24h immersion at 23°C | 2mm thk  | ISO 62        | %                 | 1,2                   |        |
| Mechanical Properties                   |          |               |                   |                       |        |
| Tensile Modulus                         | 1mm/min  | ISO 527-2/1A  | MPa               | 9800                  |        |
| Stress at Break                         | 5mm/min  | ISO 527-2/1A  | MPa               | 175                   |        |
| Strain at Break                         | 5mm/min  | ISO 527-2/1A  | %                 | 2,9                   |        |
| Flexural Modulus                        | 2mm/min  | ISO 178       | MPa               | 9100                  |        |
| Flexural Strength                       | 2mm/min  | ISO 178       | MPa               | 255                   |        |
| Charpy Notched Impact Strength          | +23°C    | ISO 179/1 eA  | kJ/m <sup>2</sup> | 7,5                   |        |
| Charpy Notched Impact Strength          | -40°C    | ISO 179/1 eA  | kJ/m <sup>2</sup> | 7                     |        |
| Izod Notched Impact Strength            | +23°C    | ISO 180/1 eA  | kJ/m <sup>2</sup> | 7,5                   |        |
| Thermal Properties                      |          |               |                   |                       |        |
| Melting Temperature                     | 10°C/min | ISO 11357-1-3 | °C                | 262                   |        |
| Heat Deflection Temperature             | 1.8 MPa  | ISO 75/2 A f  | °C                | 248                   |        |
| Heat Deflection Temperature             | 0.45 MPa | ISO 75/2 B f  | °C                | 255                   |        |

\*DAM = Dry As Moulded state \*\*Cond = Conditioned state similar to ISO 1110 \*\*\*Melt Temp [°C] / Mold Temp [°C] / Cavity press [MPa]

