RADICI GROUP

TORZEN

PRODUCT INFORMATION

TORZEN GM3800HSL   BK20

Material Code   *Colour Code*

DESCRIPTION

PA66 38% glass fiber and mineral filler reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts requiring improved stiffness and mechanical strength, reduced shrinkage, low warpage.

ISO 1043 : PA66-T (GF+MX)38

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

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PROPERTY		STANDARD	UNIT	VALUE	
				DAM*	Cond**
Physical Properties					
Density		ISO 1183	Kg/m^3	1460	
Moulding shrinkage – Parallel / Normal		ISO 294-4	%	0,20-0,35 / 0,85-1,0	
Mechanical Properties					
Tensile Modulus	1mm/min	ISO 527-2/1A	MPa	10900	
Stress at Break	5mm/min	ISO 527-2/1A	MPa	135	
Strain at Break	5mm/min	ISO 527-2/1A	%	2,1	
Flexural Modulus	2mm/min	ISO 178	MPa	9800	
Flexural Strength	2mm/min	ISO 178	MPa	205	
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	kJ/m^2	5	
Charpy Notched Impact Strength	-40°C	ISO 179/1 eA	kJ/m^2	4	
Thermal Properties					
Melting Temperature	10°C/min	ISO 11357-1-3	°C	254	
Heat Deflection Temperature	1.8 MPa	ISO 75/2 A f	°C	213	
Heat Deflection Temperature	0.45 MPa	ISO 75/2 B f	°C	250	
Flammability Properties					
Automotive interior flammability	3mm thk	ISO 3795	mm/min	0	

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