

TORZEN T2000HSL BK20

*Material Code**Colour Code*

DESCRIPTION

PA66 injection moulding grade. Toughened, heat stabilized. Black colour.

Suitable for parts requiring good impact resistance and improved surface appearance.
Good properties retention after ageing.

ISO 1043 : PA66-IT

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:
270 ÷ 290 °C	70 ÷ 90 °C	Medium

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 ³	1090	
Moulding shrinkage – Parallel / Normal	ISO 294-4	%	1,6-1,9 / 1,6-1,9	
Mechanical Properties				
Stress at Yield	50mm/min	ISO 527-2/1A	MPa	60
Yield Strain	50mm/min	ISO 527-2/1A	%	4
Nominal Strain at Break	50mm/min	ISO 527-2/1A	%	30
Flexural Modulus	2mm/min	ISO 178	MPa	2400
Charpy Impact Strength	+23°C	ISO 179/1 eU	kJ/m ²	NB
Charpy Impact Strength	-30°C	ISO 179/1 eU	kJ/m ²	NB
Charpy Notched Impact Strength	+23°C	ISO 179/1 eA	kJ/m ²	18
Charpy Notched Impact Strength	-40°C	ISO 179/1 eA	kJ/m ²	12
Izod Impact Strength	+23°C	ISO 180/1 eU	kJ/m ²	17
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	65
Heat Deflection Temperature	0.45 MPa	ISO 75/2 B f	°C	187

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

