

TORZEN G3000HR 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



Underwriters Laboratories Inc. certified material. www.ul.com

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	1370	
Moulding shrinkage – Parallel / Normal	ISO 294-4	%	0,30-0,40 / 0,95-1,05	
Moisture absorption 23°C – 50%RH	ISO 62	%	2mm thk	1,8
Water absorption, 24h immersion at 23°C	ISO 62	%	2mm thk	1,2
Mechanical Properties				
Tensile Modulus	ISO 527-2/1A	MPa	1mm/min	9800
Stress at Break	ISO 527-2/1A	MPa	5mm/min	195
Strain at Break	ISO 527-2/1A	%	5mm/min	3.1
Flexural Modulus	ISO 178	MPa	2mm/min	9100
Flexural Strength	ISO 178	MPa	2mm/min	270
Charpy Notched Impact Strength	ISO 179/1 eA	kJ/m ²	+23°C	10
Charpy Notched Impact Strength	ISO 179/1 eA	kJ/m ²	-40°C	9
Izod Notched Impact Strength	ISO 180/1 eA	kJ/m ²	+23°C	10
Thermal Properties				
Melting Temperature	ISO 11357-1-3	°C	10°C/min	262
Heat Deflection Temperature	ISO 75/2 A f	°C	1.8 MPa	248
Heat Deflection Temperature	ISO 75/2 B f	°C	0.45 MPa	255
Flammability Properties				
Flammability	UL 94	class	0.4mm	HB

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