



## Product Information

# TORZEN™ M1500HS GR01 PA66 Resin

### Product Description

TORZEN™ M1500HS GR01 is a 15% mineral reinforced, heat stabilized, grey, PA66 resin suitable for many injection molding applications where stiffness, dimensional stability, and good surface appearance are needed.

Properties (dry)		Value	Units	Method
Physical	Density	1.23	g/cm <sup>3</sup>	ISO 1183
	Mold Shrinkage, 2.0 mm, Normal	1.5 – 2.0	%	ISO 294-4
	Mold Shrinkage, 2.0 mm, Parallel	1.5 – 2.0	%	ISO 294-4
Mechanical	Tensile Strength at Break	65	MPa	ISO 527
	Elongation at Break	14	%	ISO 527
	Tensile Modulus	3,300	MPa	ISO 527
	Flexural Modulus	3,200	MPa	ISO 178
	Flexural Strength	93	MPa	ISO 178
	Notched Charpy at 23°C	5.5	kJ/m <sup>2</sup>	ISO 179
	Unnotched Charpy at 23°C	180	kJ/m <sup>2</sup>	ISO 179
Thermal	Melting Temperature, 10°C/min	262	°C	ISO 11357
	HDT at 0.45 MPa	212	°C	ISO 75
	HDT at 1.82 MPa	77	°C	ISO 75

### General Information

#### Material Status

Commercial: Active

#### Availability

North America, South America, Asia

#### Features

Glass reinforced, heat stabilized, good machine feed and mold release

#### RoHS

*No intentional additives or ingredients used in TORZEN™ M1500HS GR01 PA66 resin are among those in the European directive 2002/95/EC, (RoHS) as amended.*

### Process Guidelines for Molding

Drying Temperature	80 °C
Drying Time*	3 - 4 hours
Barrel Temperatures	
Rear	250 - 270 °C
Middle	270 - 290 °C
Front	270 - 290 °C
Nozzle	270 - 290 °C
Processing Temperature (melt)	280 - 300 °C
Mold Temperature	50 - 90 °C
Back Pressure**	2 - 10 bar
Vent Depth	0.007 - 0.04 mm
Cushion (range)	4 - 6 mm
Suggested Moisture (max)	0.18 wt%
Suggested Moisture (min)	0.08 wt%
Screw Speed	Low rpm

\* Initial moisture below 0.25 wt%. Use dehumidified air.

\*\* Melt pressure

### INVISTA Engineering Polymers

#### Additional Information:

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