



Product Information

TORZEN™ T2000HSL BK20 PA66 Resin

Product Description

TORZEN™ T2000HSL BK20 is a toughened, heat stabilized, black, PA66 resin with good impact strength, stiffness, weld line strength, surface appearance and flow.

Properties (dry)		Value	Units	Method
Physical	Specific Gravity	1.09	g/cm ³	ISO 1183
	Mold Shrinkage, 2.0 mm, Normal	1.6 – 1.9	%	ISO 294-4
	Mold Shrinkage, 2.0 mm, Parallel	1.6 – 1.9	%	ISO 294-4
Mechanical	Tensile Strength at Yield	60	MPa	ISO 527
	Elongation at Yield	4.0	%	ISO 527
	Elongation at Break	30	MPa	ISO 527
	Flexural Modulus	2400	MPa	ISO 178
	Notched Charpy at 23°C	18	kJ/m ²	ISO 179
	Notched Charpy at -40°C	12	kJ/m ²	ISO 179
	Unnotched Charpy at 23°C	NB	kJ/m ²	ISO 179
	Unnotched Charpy at -30°C	NB	kJ/m ²	ISO 179
	Notched Izod at 23°C	17	kJ/m ²	ISO 180
Thermal	Melting Temperature, 10°C/min	262	°C	ISO 11357
	HDT at 0.45 MPa	187	°C	ISO 75
	HDT at 1.82 MPa	65	°C	ISO 75
	CLTE, 2.0 mm, Parallel, 23 - 55 °C	1.0	10 ⁻⁴ /°C	ISO 11359
	CLTE, 2.0 mm, Normal, 23 - 55 °C	1.0	10 ⁻⁴ /°C	ISO 11359

General Information

Material Status

Commercial: Active

Availability

North America, Europe, South America, Asia

Features

Impact modified, heat stabilized, high flow

RoHS

No intentional additives or ingredients used in TORZEN™ T2000HSL BK20 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:

epinfo@INVISTA.com

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