INVISTA™ HV360A

PA66 Invista

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**1.4**	%	ISO 294-4, 2577
Molding shrinkage, normal	**1.3**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**3100**	MPa	ISO 527
Yield stress	**85**	MPa	ISO 527
Yield strain	**4.3**	%	ISO 527
Strain at break	**40**	%	ISO 527
Flexural modulus, 23°C	**2900**	MPa	ISO 178
Flexural strength	**100**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy impact strength, -30°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**6.2**	kJ/m²	ISO 179/1eA
Charpy notched impact strength, -30°C	**6.6**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**4.7**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**262**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**63**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**176**	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**0.4**	mm	-

Other properties	Value	Unit	Test Standard
Humidity absorption	**2.7**	%	Sim. to ISO 62
Density	**1140**	kg/m³	ISO 1183

Material specific properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	**340**[1]	cm³/g	ISO 307, 1157, 1628

1: VN at 0.5% in sulfuric acid, nominal

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**90**	°C	-
Pre-drying - Time	**6 - 8**	h	-
Processing humidity	**≤0.02**	%	-
Melt temperature	**280 - 290**	°C	-
Mold temperature	**50 - 90**	°C	-
Zone 1	**250 - 280**	°C	-
Zone 2	**275 - 290**	°C	-
Zone 3	**275 - 290**	°C	-
Nozzle temperature	**275 - 295**	°C	-
Screw speed	**50 - 120**	rpm	-
Back pressure	**0.5 - 3**	MPa	-

Characteristics

Processing

Injection Molding, Other Extrusion

Certifications

RoHS compliant

Delivery form
White

Regional Availability
North America, Europe, Asia Pacific, South and Central America