

# INVISTA HV240AHSL PA66 Resin

## Product Description

INVISTA HV240AHSL is a high viscosity PA66 resin for extrusion and injection molding applications. It is heat stabilized and lubricated.

	Properties (dry)	Value	Units	Method
VISCOSITY	VN at 0.5% in formic acid, nominal	295	mL/g	ISO 307
	VN at 0.5% in sulfuric acid, nominal	300	mL/g	ISO 307
	RV at 1% in sulfuric acid, nominal	4.6	—	—
	RV in formic acid, nominal	240	—	ASTM D789
PHYSICAL	Density	1.14	g/cm <sup>3</sup>	ISO 1183
	Mold Shrinkage, 2.0 mm, Parallel	1.7	%	ISO 294-4
	Mold Shrinkage, 2.0 mm, Transverse	1.8	%	ISO 294-4
	Water Absorption - 24 hours	1.8	%	ISO 62
	Water Absorption - Equilibrium @ 50% RH	2.7	%	ISO 62
MECHANICAL	Tensile Strength at Yield	89	MPa	ISO 527
	Elongation at Yield	4.4	%	ISO 527
	Elongation at Break	25	%	ISO 527
	Tensile Modulus	2950	MPa	ISO 527
	Flexural Modulus	2900	MPa	ISO 178
	Flexural Strength	97	MPa	ISO 178
	Notched Charpy at 23°C	5.6	kJ/m <sup>2</sup>	ISO 179
	Notched Charpy at -30°C	6.1	kJ/m <sup>2</sup>	ISO 179
	Unnotched Charpy at 23°C	NB	kJ/m <sup>2</sup>	ISO 179
	Unnotched Charpy at -30°C	NB	kJ/m <sup>2</sup>	ISO 179
Notched Izod at 23°C	4.4	kJ/m <sup>2</sup>	ISO 180	

	Properties (dry)	Value	Units	Method
THERMAL	Melting Temperature, 10°C/min	262	°C	ISO 11357
	HDT at 0.45 MPa	176	°C	ISO 75
	HDT at 1.80 MPa	63	°C	ISO 75
FLAMMABILITY	Flammability Classification at 0.40 mm	HB	—	UL 94
	Flammability Classification at 0.71 mm	HB	—	UL 94
	Flammability Classification at 1.5 mm	HB	—	UL 94
	Flammability Classification at 3.0 mm	HB	—	UL 94

## General Information

### Material Status

Commercial: Active

### Availability

- North America
- South America
- Europe
- Asia

### Features

- High viscosity
- Heat stabilized
- Lubricated for injection molding
- Fast and consistent crystallization

### RoHS

No intentional additives or ingredients used in HV240AHS are among those in the European directive 2011/65/EC (RoHS), as amended.

## Process Guidelines for Molding

Drying temperature	90 °C
Drying time*	4 - 6 hours
Barrel temperatures	
Rear	250 - 280 °C
Middle	275 - 290 °C
Front	275 - 290 °C
Nozzle	275 - 295 °C
Processing temperature (melt)	280 - 295 °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)	0.03 wt%
Suggested moisture (min)	0.01 wt%
Screw speed	50 - 150 rpm

\* Initial moisture below 0.10 wt%. Use dehumidified air.

\*\* Melt pressure

#### Product Data Sheet Disclaimer

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