

INVISTA U3501 PA66 Resin

Properties (dry)		Value	Units	Method
Viscosity	RV in formic acid, nominal	35	---	ASTM D789
	VN at 0.5% in sulfuric acid, nominal	126	mL/g	ISO 307
	RV at 1% in sulfuric acid, nominal	2.4	---	---
Physical	Density	1.14	g/cm ³	ISO 1183
	Mold Shrinkage, 2.0 mm, Parallel	1.1	%	ISO 294-4
	Mold Shrinkage, 2.0 mm, Transverse	1.1	%	ISO 294-4
	Water Absorption - 24 hours	1.7	%	ISO 62
	Water Absorption - Equilibrium @ 50% RH		%	ISO 62
Mechanical	Tensile Strength at Yield	82	MPa	ISO 527
	Elongation at Yield	3.9	%	ISO 527
	Elongation at Break	45	%	ISO 527
	Tensile Modulus	3000	MPa	ISO 527
	Flexural Modulus	2700	MPa	ISO 178
	Flexural Strength	91	MPa	ISO 178
	Notched Charpy at 23°C	4.7	kJ/m ²	ISO 179
	Notched Charpy at -30°C	4.5	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	4.8	kJ/m ²	ISO 180
Thermal	Melting Temperature, 10°C/min	264	°C	ISO 11357
	HDT at 0.45 MPa	199	°C	ISO 75
	HDT at 1.80 MPa	69	°C	ISO 75
	CLTE, 2.0 mm, Parallel, 23 - 55 °C	0.8	10 ⁻⁴ /°C	ISO 11359
	CLTE, 2.0 mm, Transverse, 23 - 55 °C	0.9	10 ⁻⁴ /°C	ISO 11359

Product Description

INVISTA U3501 NC01 is a low viscosity, natural PA66 resin suitable for compounding, injection molding, and extrusion applications where ease of processing, good color and physical property retention are desired.

General Information

Material Status

Commercial: Active

Availability

North America, South America, Europe, Asia

Features

High flow for ease of processing, stable low viscosity, good whiteness

RoHS

No intentional additives or ingredients used in U3501 are among those in the European directive 2011/65/EC (RoHS), as amended.

Process Guidelines for Molding

Drying Temperature	80 °C
Drying Time*	8 - 12 hours
Barrel Temperatures	
Rear	250 - 270 °C
Middle	270 - 290 °C
Front	270 - 290 °C
Nozzle	270 - 290 °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)	0.20 wt%
Suggested Moisture (min)	0.10 wt%
Screw Speed	75 - 180 rpm

* Initial moisture below 0.5 wt%. Use dehumidified air.

** Melt pressure

INVISTA Nylon Polymer

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