

Properties (dry)		Value	Units	Method
Viscosity	VN at 0.5% in formic acid, nominal	225	mL/g	ISO 307
	VN at 0.5% in sulfuric acid, nominal	235	mL/g	ISO 307
	RV at 1% in sulfuric acid, nominal	3.7	---	---
	RV in formic acid, nominal	125	---	ASTM D789
Physical	Density	1.14	g/cm <sup>3</sup>	ISO 1183
	Mold Shrinkage, 2.0 mm, Parallel	2.0	%	ISO 294-4
	Mold Shrinkage, 2.0 mm, Transverse	1.8	%	ISO 294-4
	Water Absorption - 24 hours	1.9	%	ISO 62
	Water Absorption - Equilibrium @ 50% RH	2.7	%	ISO 62
Mechanical	Tensile Strength at Yield	90	MPa	ISO 527
	Elongation at Yield	4.4	%	ISO 527
	Elongation at Break	25	%	ISO 527
	Tensile Modulus	3000	MPa	ISO 527
	Flexural Modulus	2850	MPa	ISO 178
	Flexural Strength	96	MPa	ISO 178
	Notched Charpy at 23°C	5.4	kJ/m <sup>2</sup>	ISO 179
	Notched Charpy at -30°C	6.6	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	4.3	kJ/m <sup>2</sup>	ISO 180
Thermal	Melting Temperature, 10°C/min	262	°C	ISO 11357
	HDT at 0.45 MPa	181	°C	ISO 75
	HDT at 1.80 MPa	58	°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

### Product Description

INVISTA HV125AHSL is a high viscosity PA66 resin for extrusion and injection molding applications. It is heat stabilized and lubricated.

### 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 HV125AHSL are among those in the European directive 2011/65/EC (RoHS), as amended.

### Process Guidelines for Molding

Drying Temperature	90 °C
Drying Time*	3 - 4 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)	0.08 wt%
Suggested Moisture (min)	0.02 wt%
Screw Speed	75 - 180 rpm

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

\*\* Melt pressure

### INVISTA Nylon Polymer

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#### Product Data Sheet Disclaimer

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