

Hiprolon® 90 MNNHL G30

Polyamide 612

Arkema

Message:

Hiprolon® 90 MNNHL G30 is a polyamide 6.12 reinforced with 30% glass fiber. This natural grade is designed for injection molding.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Appearance	Natural Color		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Molding Shrinkage			
Across Flow	1.0	%	ISO 2577, ISO 294-4
Flow	0.40	%	ISO 294-4, ISO 2577
Water Absorption (Equilibrium, 23°C, 50% RH)	0.80	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7800	MPa	ISO 527-2
Tensile Stress (Yield)	137	MPa	ISO 527-2
Tensile Strain (Break)	5.0	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	13	kJ/m ²	
23°C	20	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	90	kJ/m ²	
23°C	90	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	213	°C	ISO 75-2/B
1.8 MPa, Unannealed	185	°C	ISO 75-2/A
Vicat Softening Temperature	210	°C	ISO 306
Melting Temperature	215	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	IEC 60093
Comparative Tracking Index	> 600	V	IEC 60112
Additional Information	Nominal Value	Test Method	
ISO Shortname	PA 612, MHLR, 27-080, GF 30	ISO 1874	
Injection	Nominal Value	Unit	

Drying Temperature	80.0 to 90.0	°C
Drying Time	4.0	hr
Processing (Melt) Temp	250 to 290	°C
Mold Temperature	60.0 to 110	°C

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