

SCHULAMID® 612 GF 65 H IS

Polyamide 612
A. Schulman Europe

Message:
65% glass fiber reinforced, Polyamide 612 compound, heat stabilized, improved surface

General Information				
Filler / Reinforcement	Glass fiber reinforced material, 65% filler by weight			
Processing Method	Gas-Assisted Injection Molding			
	Water-Assisted Injection Molding			
	Water temperature mold injection molding			
	Injection molding			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.74	--	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	21.0	--	cm ³ /10min	ISO 1133
Viscosity Number (H2SO4 (Sulphuric Acid))	90.0	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	24000	20000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	210	180	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.5	1.6	%	ISO 527-2/1A/5
Flexural Modulus ¹ (23°C)	21200	--	MPa	ISO 178
Flexural Stress ² (4.0% strain, 23°C)	330	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	9.0	--	kJ/m ²	ISO 179/1eA
23°C	9.5	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	65	--	kJ/m ²	ISO 179/1eU
23°C	65	70	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	210	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	200	--	°C	ISO 75-2/ Af
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate (2.00 mm)	< 100	--	mm/min	ISO 3795

Additional Information

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1.)

Not for use in food contact applications2.)

Not for use in medical or pharmaceutical applications

Injection	Dry	Unit
Drying Temperature	80	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.040 - 0.10	%
Suggested Max Regrind	20	%
Processing (Melt) Temp	240 - 280	°C
Mold Temperature	50 - 90	°C

NOTE

1. 2.0 mm/min

2. 2.0 mm/min

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