



TECHNICAL DATA AND PROCESS SHEET

10% GLASS FIBER REINFORCED NYLON 612

INSTRUC PA612GF10

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.14	-	ASTM D792
MOLD SHRINKAGE, FLOW 0.125"	1.0	%	
MECHANICAL			
TENSILE STRENGTH, BRK	11,000	psi	ASTM D638
TENSILE ELONGATION	2 - 3	%	ASTM D638
FLEXURAL MODULUS	500,000	psi	ASTM D790
IZOD IMPACT, NOTHCED	1.0	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	370	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	$>10^{17}$	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	180	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	460 - 520	°F	
MOLD TEMPERATURE	160 - 200	°F	
BACK PRESSURE	50 - 100	psi	
SCREW SPEED	40 - 70	rpm	
VENT DEPTH	0.0005-0.001	in	

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