



TECHNICAL DATA AND PROCESS SHEET

20% GLASS FIBER REINFORCED NYLON 6/12

INSTRUC PA612GF20

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.21	-	ASTM D792
WATER ABSORPTION	0.2	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.3 – 0.5	%	
MECHANICAL			
TENSILE STRENGTH, BRK	18,000	psi	ASTM D638
TENSILE ELONGATION	3-4	%	ASTM D638
FLEXURAL MODULUS	900,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	1.5	ft-lb/in	ASTM D256
THERMAL			
HDTUL @ 264 PSI	390	°F	ASTM D648
ELECTRICAL			
SURFACE RESISTIVITY	>10EXP17	Ohm/Sq	ASTM D257
PROCESSING			
DRYING TEMPERATURE	175	°F	
DRYING TIME	4	hrs	
MELT TEMPERATURE	510-530	°F	
MOLD TEMPERATURE	200	°F	
BACK PRESSURE	50-100	psi	
SCREW SPEED	40-70	rpm	
VENT DEPTH	0.0005-0.001	in	

DJV 1/15/10

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