



TECHNICAL DATA AND PROCESS SHEET

30% GLASS FIBER REINFORCED NYLON 6/12

INSTRUC PA612GF30

TYPICAL PROPERTIES

PROPERTY	VALUE	UNIT	METHOD
PHYSICAL			
SPECIFIC GRAVITY	1.30	-	ASTM D792
WATER ABSORPTION	0.2	%	ASTM D570
MOLD SHRINKAGE, FLOW 0.125"	0.3 - 0.5	%	ASTM D955
MECHANICAL			
TENSILE STRENGTH, BRK	27,000	psi	ASTM D638
TENSILE ELONGATION	2-4	%	ASTM D638
TENSILE MODULUS	1,300,000	psi	ASTM D638
FLEXURAL STRENGTH	35,000	psi	ASTM D790
FLEXURAL MODULUS	1,200,000	psi	ASTM D790
IZOD IMPACT, NOTCHED	2.5	ft-lb/in	ASTM D256
IZOD IMPACT, UNNOTCHED	22	ft-lb/in	ASTM D4812
THERMAL			
HDTUL @ 264 PSI	425	°F	ASTM D648
FLAMMABILITY	HB @ 1.5 mm		
ELECTRICAL			
SURFACE RESISTIVITY	>10 ¹⁷	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	

Revised: 12/8/10 DJV

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