

Technical Data Sheet

Schulamid 612 HV H 5003

Polyamide 612
LyondellBasell Industries
Engineering Plastics

Product Description

Impact modified Polyamide 612, heatstabilized for injection molding

General

Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA612

Physical	Dry	Conditioned	Unit	Test Method
Density	1.05	--	g/cm ³	ISO 1183/A

Melt Volume-Flow Rate (MVR) (245°C/5.0 Kg)	8.5	--	cm ³ /10min	ISO 1133
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Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	290000 (2000)	133000 (920)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Yield)	7250 (50.0)	5370 (37.0)	psi (MPa)	ISO 527-2/1A/50
Tensile Strain (Yield)	4.8	18	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	50	220	%	ISO 527-2/1A/50
Flexural Modulus ¹	218000 (1500)	--	psi (MPa)	ISO 178
Flexural Stress ¹				ISO 178
6.7% Strain	8700 (60.0)	--	psi (MPa)	
3.5% Strain	6820 (47.0)	--	psi (MPa)	

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-40°F (-40°C)	7.1 (15)	--	ft·lb/in ² (kJ/m ²)	
-22°F (-30°C)	8.1 (17)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	36 (75)	50 (110)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-40°F (-40°C)	No Break	--		
-22°F (-30°C)	No Break	--		
73°F (23°C)	No Break	No Break		

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Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	246 (119)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	127 (53.0)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	311 (155)	--	°F (°C)	ISO 306/B50
--	401 (205)	--	°F (°C)	ISO 306/A50
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 In (2.00 Mm)	< 3.9 (< 100)	--	in/min (mm/min)	ISO 3795
0.0787 In (2.00 Mm)	< 3.9 (< 100)	--	in/min (mm/min)	FMVSS 302

Additional Information

- 1.) Not for use in food contact applications
- 2.) Not for use in medical or pharmaceutical applications

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Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	122 to 194 °F	50 to 90 °C

Notes

¹ 0.079 in/min (2.0 mm/min)

Notes

These are typical property values not to be construed as specification limits.