

HiDura™ D1MG33H BK0814

polyamide 612



HiDura D1MG33H BK0814 is a heat stabilized, 33% glass filled PA612 material designed for injection molding applications.

General

Regional Availability	• North America	• Europe	• Asia Pacific
Additive	• Heat Stabilizer		
Features	• Chemical Resistant	• Medium-High Viscosity	
Automotive Specifications	• GM GMW17599P-PA612-GF35		
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Injection Molding		

Physical

	dry	cond.	Unit	Test Standard
Density	1.32	-	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 23°C, 2.00 mm	1.2	*	%	
Flow : 23°C, 2.00 mm	0.5	*	%	
Water Absorption				ISO 62
Equilibrium, 23°C, 50% RH	0.84	*	%	

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	9600	7900	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	163	125	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	3.7	5.8	%	ISO 527-2
Flexural Modulus (23°C)	9100	7600	MPa	ISO 178
Flexural Strength (23°C)	235	183	MPa	ISO 178

Impact

	dry	cond.	Unit	Test Standard
Charpy Notched Impact Strength				ISO 179/1eA
+23°C	14	13	kJ/m ²	
-30°C	11	10	kJ/m ²	
-40°C	10	10	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179/1eU
+23°C	89	79	kJ/m ²	
-30°C	82	71	kJ/m ²	
-40°C	80	72	kJ/m ²	
Notched Izod Impact Strength				ISO 180/1A

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+23°C	13	13	kJ/m²
-30°C	11	10	kJ/m²
-40°C	11	9.6	kJ/m²

Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	192	190	°C	
0.45 MPa, Unannealed	206	-	°C	
Melting Temperature	218	*	°C	ISO 11357-3

Electrical	dry	cond.	Unit	Test Standard
Dielectric Strength (1.00 mm)	35	36	kV/mm	IEC 60243

Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4 - 6	h
Suggested Max Moisture	0.15	%
Processing (Melt) Temperature	235 - 290	°C
Mold Temperature	50 - 90	°C

HiDURA™