



HiDura™ D3XI3J BK0808

polyamide 612

HiDura D3XI3J BK0808 is a high viscosity, low impact modified, and heat stabilized PA612 grade. It is suitable for profile and pipe extrusions. It exhibits low moisture absorption, good chemical resistance, dimensional stability, and high impact resistance. This grade offers high burst pressures for extruded tubing systems. PA612 offers a unique balance of thermal, mechanical, and physical properties.

General

Regional Availability	• North America • South and Central America	• Europe • Near East/Africa	• Asia Pacific
Additive	• Heat Stabilizer		
Features	• Good Surface Finish • High Viscosity	• Halogen Content, None • Organic Heat Stabilized	• High Melt Strength
Agency Rating	• ASTM, D4066 PA0621	• ASTM, D6779 PA0521	• ISO, 1043 PA612 I
Appearance	• Black		
Forms	• Pellets		
Processing Method	• Other Extrusion	• Profile Extrusion	• Sheet Extrusion

Physical

	dry	cond.	Unit	Test Standard
Density	1.05	-	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 23°C, 2.00 mm	1.7	*	%	
Flow : 23°C, 2.00 mm	1.7	*	%	
Water Absorption				ISO 62
23°C, 24 hr	0.4	*	%	
Equilibrium, 23°C, 50% RH	1.2	*	%	

Mechanical

	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	2000	1300	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	54	43	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	40	50	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	4.7	14	%	ISO 527-2
Tensile Strain (Break, 23°C)	>50	>50	%	ISO 527-2
Flexural Modulus (23°C)	2000	1300	MPa	ISO 178
Flexural Strength (23°C)	59	33	MPa	ISO 178
Poisson's Ratio (23°C)	0.4		-	ISO 527-2

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Impact	dry	cond.	Unit	Test Standard
Charpy Notched Impact Strength				ISO 179/1eA
+23°C	18	56	kJ/m²	
-30°C	13	15	kJ/m²	
-40°C	13	14	kJ/m²	
Charpy Unnotched Impact Strength				ISO 179/1eU
+23°C	N	N	kJ/m²	
-30°C	N	N	kJ/m²	
-40°C	N	N	kJ/m²	
Notched Izod Impact Strength				ISO 180/1A
+23°C	14	51	kJ/m²	
-30°C	13	16	kJ/m²	
-40°C	13	13	kJ/m²	

Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	57	-	°C	
0.45 MPa, Unannealed	145	-	°C	
Melting Temperature	218	*	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow : 23 to 55°C, 2.00 mm	95	*	E-6/K	
Transverse : 23 to 55°C, 2.00 mm	110	*	E-6/K	

Electrical	dry	cond.	Unit	Test Standard
Dielectric Strength (1.00 mm)	32	30	kV/mm	IEC 60243

Extrusion	Value	Unit
Cylinder Zone 1 Temp	216 - 249	°C
Cylinder Zone 3 Temp	232 - 249	°C
Cylinder Zone 5 Temp	232 - 249	°C
Melt temperature	232 - 246	°C
Die temperature	232 - 246	°C