

InStruc® PA612L

Americhem - Polyamide 6/12 Copolymer

General Information

Product Description			
LUBRICATED NYLON 612			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Mold Release		
Features	• Good Dimensional Stability	• Good Mold Release	• Lubricated
Uses	• Closures • Consumer Applications • Electrical/Electronic Applications • Engineering Parts	• Household Goods • Housings • Industrial Applications • Industrial Parts	• Office Automation Equipment • Outdoor Applications • Window & Door Components
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.06		ASTM D792
Molding Shrinkage - Flow (0.125 in)	0.018 to 0.025	in/in	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	350000	psi	ASTM D638
Tensile Strength (Yield)	9000	psi	ASTM D638
Tensile Elongation (Yield)	> 10	%	ASTM D638
Flexural Modulus	350000	psi	ASTM D790
Flexural Strength	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	1.0	ft-lb/in	ASTM D256
Unnotched Izod Impact	No Break		ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	131	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	4.0	hr
Processing (Melt) Temp	450 to 520	°F
Mold Temperature	150 to 180	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm
Vent Depth	5.0E-4 to 1.0E-3	in

Notes

¹ Typical properties: these are not to be construed as specifications.

