

Isocor™ HG20SC

Polyamide 612

Shakespeare Monofilaments and Specialty Polymers

Message:

ISOCOR™ HG20SC is a medium viscosity compounding grade PA-612 based nylon. This resin is specifically suited for applications requiring low-moisture regain and greater dimensional stability. Isocor™ HG20SC is used in applications requiring good electrical insulation properties. This resin can be processed using conventional techniques.

Typical applications for HG20SC include:

Injection Molding

Automotive

Lawn and Garden

Tubing

Films

General Information	
Features	Good dimensional stability Low hygroscopicity Insulation Medium viscosity
Uses	Films Lawn and Garden Equipment Pipe fittings Insulating material Application in Automobile Field
Forms	Particle
Processing Method	Extrusion Injection molding

Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.04	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.2	--	%	ASTM D955
Water Absorption (24 hr)	0.17	--	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2300	2230	MPa	ASTM D638
Tensile Strength	31.4	31.4	MPa	ASTM D638
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	37	39	J/m	ASTM D256
Dart Drop Impact	36.2	36.2	J	ASTM D3029
Thermal	Dry	Conditioned	Unit	Test Method
Melting Temperature	218	--	°C	DSC

Additional Information

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Color, ASTM D1003-97: 69.03 LColor, ASTM D1003-97: -2.17 aColor, ASTM D1003-97: -7.61 b

Injection	Dry	Unit
Dew Point	< -17.8	°C
Suggested Max Moisture	0.20	%
Hopper Temperature	79.4	°C
Rear Temperature	221 - 243	°C
Middle Temperature	227 - 260	°C
Front Temperature	238 - 271	°C
Nozzle Temperature	238 - 271	°C
Processing (Melt) Temp	238 - 271	°C
Mold Temperature	10.0 - 93.3	°C
Injection Pressure	3.45 - 13.8	MPa
Injection Rate	Fast	
Back Pressure	0.345	MPa

Extrusion	Dry	Unit
Suggested Max Moisture	0.10	%
Hopper Temperature	79.4	°C
Cylinder Zone 1 Temp.	254	°C
Cylinder Zone 2 Temp.	266	°C
Cylinder Zone 3 Temp.	271	°C
Cylinder Zone 4 Temp.	271	°C
Die Temperature	271	°C

Extrusion instructions

Flange: 500°F (260°C)Air Dew Point (max): 0°F (-18°C)Neck: 500°F (260°C)Head: 480°F (250°C)Pump: 480°F (250°C)L/D Ratio: 24 to 30:1Compression Ratio: 3.5:1Polymer @ Die: 430°F (220°C)Screw Pressure: 2000 psi

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