

# Isocor™ HW29TL

Polyamide 610

Shakespeare Monofilaments and Specialty Polymers

## Message:

Isocor™ HW29TL is a ultra low viscosity PA-610 with excellent melt flow characteristics. Isocor™ HW29TL is specifically formulated for thin wall or high speed injection molding applications. This resin is suitable for applications requiring low moisture absorption and greater dimensional stability. This resin can be processed using conventional techniques.

Typical applications for Isocor™ HW29TL include:

thin-wall injection molding

electrical connectors

small parts-high output

General Information				
Features		Good Dimensional Stability		
		Low Moisture Absorption		
		Low Viscosity		
Uses		Connectors		
		Electrical/Electronic Applications		
		Thin-walled Parts		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.07	--	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.1	--	%	ASTM D955
Water Absorption (24 hr)	--	1.4	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength	60.0	51.7	MPa	ASTM D638
Tensile Elongation (Break)	100	300	%	ASTM D638
Flexural Modulus	2000	1300	MPa	ASTM D790
Taber Abrasion Resistance (1000 Cycles)	6.00	--	mg	ASTM D1044
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	48	200	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed	175	160	°C	
1.8 MPa, Unannealed	66.1	60.0	°C	
Melting Temperature	215	--	°C	DSC
Injection	Dry	Unit		

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

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#### Recommended distributors for this material

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