

DynaStat® 2247-X

Polyamide 12

Polymer Dynamix

Message:

Antistatic Polyamide 12 Compound

Features:

Permanently Antistatic

Good Dimensional Stability

Excellent Processability

Applications:

Automotive

Industrial

Electrical/Electronic Applications

General Information			
Additive	Antistatic property		
Features	Good dimensional stability		
	Antistatic property		
	Workability, good		
Uses	Electrical/Electronic Applications		
	Industrial application		
	Application in Automobile Field		
Processing Method	Extrusion		
	Injection molding		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	434	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	26.2	MPa	ASTM D638
Fracture	31.7	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	30	%	ASTM D638
Fracture	> 200	%	ASTM D638
Flexural Modulus	552	MPa	ASTM D790
Flexural Strength	23.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.18 mm)	No Break		ASTM D256
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+6 - 1.0E+8	ohms	ASTM D257
Static Decay		sec	NFPA 99
Injection	Nominal Value	Unit	

Drying Temperature	71.1 - 82.2	°C
Drying Time	3.0 - 5.0	hr
Rear Temperature	193 - 204	°C
Middle Temperature	199 - 210	°C
Front Temperature	204 - 216	°C
Nozzle Temperature	210 - 221	°C
Processing (Melt) Temp	210 - 221	°C
Mold Temperature	10.0 - 65.6	°C
Injection Pressure	68.9 - 138	MPa
Injection Rate	Moderate	
Back Pressure	0.345 - 0.689	MPa
Screw Speed	40 - 70	rpm
Clamp Tonnage	5.5 - 8.3	kN/cm ²
Extrusion	Nominal Value	Unit
Drying Temperature	71.1 - 82.2	°C
Drying Time	3.0 - 5.0	hr
Cylinder Zone 1 Temp.	193 - 204	°C
Cylinder Zone 3 Temp.	199 - 210	°C
Cylinder Zone 5 Temp.	204 - 216	°C
Melt Temperature	210 - 221	°C
Die Temperature	210 - 221	°C
Extrusion instructions		

Screw Speed: 25 to 100 RPM

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