

SCHULAMID® 612 GF 33 H2

Polyamide 612
A. Schulman Europe

Message:
33% glass fiber reinforced, Polyamide 612 Compound, electrically neutral heat stabilized

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 33% filler by weight		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (245°C/5.0 kg)	32.1	--	cm ³ /10min	ISO 1133
Water Absorption (Saturation, 23°C)	1.3	--	%	ISO 62
Viscosity Number (H2SO4 (Sulphuric Acid))	105	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	9500	8300	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	170	130	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	3.6	%	ISO 527-2/1A/5
Flexural Modulus ¹ (23°C)	9000	--	MPa	ISO 178
Flexural Stress ²				ISO 178
3.5% strain	250	--	MPa	ISO 178
3.7% strain ³	250	--	MPa	ISO 178
3.7% strain, 23°C	255	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	8.0	--	kJ/m ²	ISO 179/1eA
23°C	9.0	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	65	--	kJ/m ²	ISO 179/1eU
23°C	75	65	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	214	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	195	--	°C	ISO 75-2/Af
Injection	Dry	Unit		
Drying Temperature	80		°C	

Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.040 - 0.10	%
Suggested Max Regrind	20	%
Processing (Melt) Temp	240 - 280	°C
Mold Temperature	50 - 90	°C

NOTE

1. 2.0 mm/min
2. 2.0 mm/min
3. at Break

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