Technical Data Sheet

Schulamid 612 GF 33 HE

Polyamide 612
LyondellBasell Industries
Engineering Plastics

Product Description
33% glass fiber reinforced, Polyamide 612 Compound, electrically neutral heat stabilized

General			
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Features	• Chemical Resistant	• Halogen Free	• Heat Aging Resistant
Processing Method	• Injection Molding		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.33	--	g/cm³	ISO 1183
Viscosity Number (H2so4 (sulphuric Acid))	125	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	1.52E+6 (10500)	1.26E+6 (8700)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	25400 (175)	20300 (140)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.2	4.5	%	ISO 527-2/1A/5
Flexural Modulus [1]	1.45E+6 (10000)	--	psi (MPa)	ISO 178
Flexural Stress [1]				
3.7% Strain	40600 (280)	--	psi (MPa)	ISO 178
3.5% Strain	40600 (280)	--	psi (MPa)	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°f (-30°c)	3.8 (8.0)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	5.2 (11)	5.9 (13)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°f (-30°c)	31 (65)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	38 (80)	40 (85)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	419 (215)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	383 (195)	--	°F (°C)	ISO 75-2/Af
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Burning Rate				
0.0787 In (2.00 Mm)	< 3.9 (< 100)	--	in/min (mm/min)	ISO 3795
0.0787 In (2.00 Mm)	< 3.9 (< 100)	--	in/min (mm/min)	FMVSS 302

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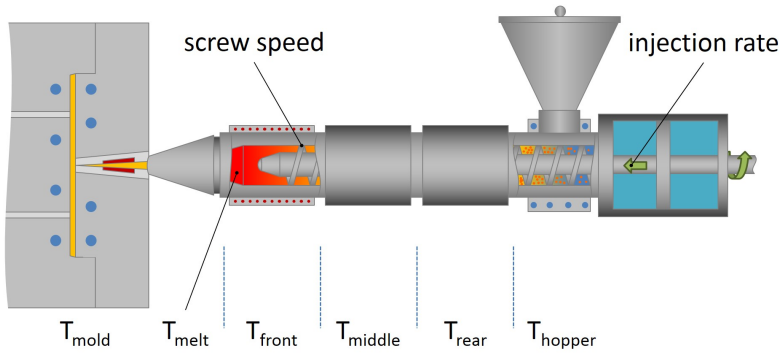

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 6.0 hr	3.0 to 6.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	464 to 536 °F	240 to 280 °C
Mold Temperature	122 to 194 °F	50 to 90 °C

Notes

[1] 0.079 in/min (2.0 mm/min)

Notes

These are typical property values not to be construed as specification limits.