**Technical Data Sheet**

# *Schulamid* 612 HV H 5003

Polyamide 612
LyondellBasell Industries
Engineering Plastics

| Product Description |
|---|
| Impact modified Polyamide 612, heatstabilized for injection molding |

| General | |
|---|---|
| Processing Method | • Injection Molding |
| Resin ID (ISO 1043) | • PA612 |

| Physical | Dry | Conditioned | Unit | Test Method |
|---|---|---|---|---|
| Density | 1.05 | -- | g/cm³ | ISO 1183/A |
| Melt Volume-Flow Rate (MVR) (245°c/5.0 Kg) | 8.5 | -- | cm³/10min | ISO 1133 |
| **Mechanical** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Tensile Modulus | 290000 (2000) | 133000 (920) | psi (MPa) | ISO 527-1/1A/1 |
| Tensile Stress (Yield) | 7250 (50.0) | 5370 (37.0) | psi (MPa) | ISO 527-2/1A/50 |
| Tensile Strain (Yield) | 4.8 | 18 | % | ISO 527-2/1A/50 |
| Nominal Tensile Strain at Break | 50 | 220 | % | ISO 527-2/1A/50 |
| Flexural Modulus [1] | 218000 (1500) | -- | psi (MPa) | ISO 178 |
| Flexural Stress [1] | | | | ISO 178 |
| 6.7% Strain | 8700 (60.0) | -- | psi (MPa) | |
| 3.5% Strain | 6820 (47.0) | -- | psi (MPa) | |
| **Impact** | **Dry** | **Conditioned** | **Unit** | **Test Method** |
| Charpy Notched Impact Strength | | | | ISO 179/1eA |
| -40°f (-40°c) | 7.1 (15) | -- | ft·lb/in² (kJ/m²) | |
| -22°f (-30°c) | 8.1 (17) | -- | ft·lb/in² (kJ/m²) | |
| 73°f (23°c) | 36 (75) | 50 (110) | ft·lb/in² (kJ/m²) | |
| Charpy Unnotched Impact Strength | | | | ISO 179/1eU |
| -40°f (-40°c) | No Break | -- | | |
| -22°f (-30°c) | No Break | -- | | |
| 73°f (23°c) | No Break | No Break | | |

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| Thermal | Dry | Conditioned | Unit | Test Method |
|---|---|---|---|---|
| Deflection Temperature Under Load | | | | |
| 66 Psi (0.45 Mpa), Unannealed | 246 (119) | -- | °F (°C) | ISO 75-2/Bf |
| 264 Psi (1.8 Mpa), Unannealed | 127 (53.0) | -- | °F (°C) | ISO 75-2/Af |
| Vicat Softening Temperature | | | | |
| -- | 311 (155) | -- | °F (°C) | ISO 306/B50 |
| -- | 401 (205) | -- | °F (°C) | ISO 306/A50 |
| **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 |

**Additional Information**

1.) Not for use in food contact applications
2.) Not for use in medical or pharmaceutical applications

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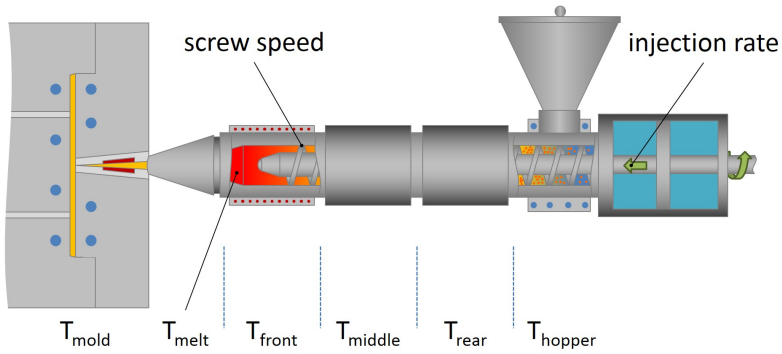


| Injection | Dry (English) | Dry (SI) |
|---|---|---|
| Drying Temperature | 176 °F | 80 °C |
| Drying Time | 3.0 to 4.0 hr | 3.0 to 4.0 hr |
| Suggested Max Moisture | 0.04 to 0.10 % | 0.04 to 0.10 % |
| Processing (Melt) Temp | 446 to 518 °F | 230 to 270 °C |
| Mold Temperature | 122 to 194 °F | 50 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.