Technical Data Sheet

Schulamid 612 HV H3

Polyamide 612
LyondellBasell Industries
Engineering Plastics

Product Description
Polyamide 612, high viscosity, heat stabilized for extrusion molding

General	
Processing Method	• Extrusion
Resin ID (ISO 1043)	• PA612

Physical	Dry	Conditioned	Unit	Test Method
Density	1.05	--	g/cm³	ISO 1183/A
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	319000 (2200)	203000 (1400)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Yield)	9140 (63.0)	7110 (49.0)	psi (MPa)	ISO 527-2/1A/50
Tensile Strain (Yield)	4.5	20	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	--	> 50	%	ISO 527-2
Flexural Modulus [1] (73°f (23°c))	392000 (2700)	--	psi (MPa)	ISO 178
Flexural Strength				
73°f (23°c)	13800 (95.0)	--	psi (MPa)	ASTM D790
3.5% Strain [1]	12300 (85.0)	--	psi (MPa)	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°f (23°c))	2.4 (5.0)	4.8 (10)	ft·lb/in² (kJ/m²)	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°f (-30°c)	No Break	--		
73°f (23°c)	No Break	No Break		
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	284 (140)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	140 (60.0)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	356 (180)	--	°F (°C)	ISO 306/B50
--	410 (210)	--	°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

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Additional Information

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

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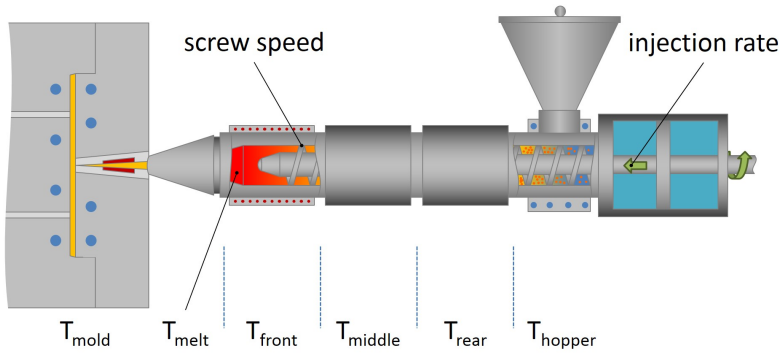

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	446 to 518 °F	230 to 270 °C
Mold Temperature	122 to 194 °F	50 to 90 °C

Notes

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

Notes

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