



InStruc® PA612L

PRODUCT DESCRIPTION LUBRICATED NYLON 612

MATERIAL STATUS Commercial: Active

AVAILABILITY Africa & Middle East, Asia Pacific, Europe, Latin America, North America

ADDITIVE Mold Release

FEATURES Good Dimensional Stability, Good Mold Release, Lubricated

USES Closures, Consumer Applications, Electrical/Electronic Applications, Engineering Parts, Household Goods, Housings, Industrial Applications, Industrial Parts, Office Automation Equipment, Outdoor Applications, Window & Door Components

FORMS Pellets

PROCESSING METHOD Injection Molding

PHYSICAL	NOMINAL VALUE	UNIT	TEST METHOD
Density / Specific Gravity	1.06	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.8 to 2.5	%	ASTM D955
Water Absorption (24 hr)	0.25	%	ASTM D570
MECHANICAL	NOMINAL VALUE	UNIT	TEST METHOD
Tensile Modulus	2410	MPa	ASTM D638
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Tensile Elongation (Yield)	> 10	%	ASTM D638
Flexural Modulus	2410	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
IMPACT	NOMINAL VALUE	UNIT	TEST METHOD
Notched Izod Impact	53	J/m	ASTM D256
Unnotched Izod Impact	No Break		ASTM D4812
THERMAL	NOMINAL VALUE	UNIT	TEST METHOD
Deflection Temperature Under Load 1.8 MPa, Unannealed	55.0	°C	ASTM D648



INJECTION	NOMINAL VALUE	UNIT
Drying Temperature	82	°C
Drying Time	4.0	hr
Processing (Melt) Temp	232 to 271	°C
Mold Temperature	66 to 82	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.013 to 0.025	mm

NOTES

¹ Typical properties: these are not to be construed as specifications.

