



InStruc® PA612IM

PRODUCT DESCRIPTION IMPACT MODIFIED NYLON 612

MATERIAL STATUS Commercial: Active

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

ADDITIVE Impact Modifier

FEATURES Good Dimensional Stability, High Impact Resistance, Impact Modified, Low Temperature Toughness

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	1.03	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	1380	MPa	ASTM D638
Tensile Strength (Yield)	33.1	MPa	ASTM D638
Tensile Elongation (Yield)	> 50	%	ASTM D638
Flexural Modulus	1240	MPa	ASTM D790
Flexural Strength	52.4	MPa	ASTM D790

IMPACT	NOMINAL VALUE	UNIT	TEST METHOD
Notched Izod Impact	160	J/m	ASTM D256
Unnotched Izod Impact	No Break		ASTM D4812

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

NOTES

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

