

**HiDura™ D1MG33H BK0814**

 Ascend Performance Materials Operations LLC - *Polyamide 612*
**General Information**
**Product Description**

HiDura D1MG33H BK0814 is a heat stabilized, 33% glass filled PA612 material designed for injection molding applications.

**General**

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Heat Stabilizer
Features	• Chemical Resistant • Hydrolysis Resistant • Heat Stabilized • Medium-high Viscosity
Automotive Specifications	• GM GMW17599P-PA612-GF35
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID	• PA612-GF33

**Properties <sup>1</sup>**

Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow : 73°F, 0.0787 in	1.2	--	%	
Flow : 73°F, 0.0787 in	0.50	--	%	
Water Absorption (Equilibrium, 73°F, 50% RH)	0.84	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (73°F)	1.39E+6	1.15E+6	psi	ISO 527-1
Tensile Stress (Break, 73°F)	23600	18100	psi	ISO 527-2
Tensile Strain (Break, 73°F)	3.7	5.8	%	ISO 527-2
Flexural Modulus (73°F)	1.32E+6	1.10E+6	psi	ISO 178
Flexural Stress (73°F)	34100	26500	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-40°F	4.8	4.8	ft·lb/in <sup>2</sup>	
-22°F	5.2	4.8	ft·lb/in <sup>2</sup>	
73°F	6.7	6.2	ft·lb/in <sup>2</sup>	
Charpy Unnotched Impact Strength				ISO 179/1eU
-40°F	38	34	ft·lb/in <sup>2</sup>	
-22°F	39	34	ft·lb/in <sup>2</sup>	
73°F	42	38	ft·lb/in <sup>2</sup>	
Notched Izod Impact Strength				ISO 180/1A
-40°F	5.2	4.6	ft·lb/in <sup>2</sup>	
-22°F	5.2	4.8	ft·lb/in <sup>2</sup>	
73°F	6.2	6.2	ft·lb/in <sup>2</sup>	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	403	--	°F	ISO 75-2/B
Deflection Temperature Under Load (264 psi, Unannealed)	378	374	°F	ISO 75-2/A
Melting Temperature	424	--	°F	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Electric Strength (0.0394 in)	890	910	V/mil	IEC 60243-1



## Processing Information

Injection	Dry Unit
Drying Temperature	176 °F
Drying Time	4.0 to 6.0 hr
Suggested Max Moisture	0.15 %
Processing (Melt) Temp	455 to 554 °F
Mold Temperature	122 to 194 °F

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

