

FORMPOLY® NYLON12

GENERAL

FPL offers a wide range of Nylon12 grades from unfilled to glass fibre reinforced, including **FORMPOLY® N12GF30** which is glass filled Nylon 12 with good modulus and moderate mechanical properties.

FORMPOLY® N12GF30

Higher Impact resistance
Reduced sensitivity to notch
Good finish and Gloss
Easy flow and fast solidification
High elongation
Low density
Excellent abrasion resistance
Good fatigue behaviour
High resistance to stress cracking

PACKING

FORMPOLY® N12GF30 is supplied in 25 Kgs. dry, ready to mould, in sealed bags to prevent the uptake of moisture.

APPLICATION

OFC Sheathing
Pneumatic tubing
Air break tubing
Cable sheathing
Noiseless Gear/clips
Heater Wire insulation

Property	Method	Unit	N12GF30
Tensile Strength	ISO 527	MPa	120
Elongation at Break	ISO 527	%	6
Tensile Modulus	ISO 527	MPa	6500
Flexural Strength	ISO 178	MPa	160
Flexural Modulus	ISO 178	MPa	6000
Izod Impact Strength-Notched	ISO 180	kg.cm/cm	23
Density	ISO 1183	g/cc	1.24
Moisture absorption	ISO 62	%	0.6
Water Absorption	ISO 62	%	1.1
Mould Shrinkage-Flow	FPL	%	0.3-0.5
Mould Shrinkage-Across Flow	FPL	%	0.8-1.0
Flammability @ 3mm	UL94	-	HB

Conditioned test specimen. All results are measured under Dry-as-moulded natural test specimen Coloured grades would record slightly lower mechanical properties as permitted by ASTM D-4066

The information present here is for general guidance. It is given in good faith but no warrant is attached

FORMULATED POLYMERS LIMITED

Manufacturers of Engineering Plastics Compounds

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ISO 9001:2015, IATF 16949: 2009 & ISO 14001: 2015 Certified Firm



PROCESSING OF FORMPOLY NYLON 12

FORMPOLY® grades can be processed in extruders with min L/D of 24 with compression ratio of 3.0 to 3.5. Material can be processed with zone temperature from 210 °C to 230 °C.

PRE-DRYING

FPL grades can normally be taken for direct processing. However, in case the material is exposed to atmosphere, it is advisable to pre-dry the material at 80°C for 2 to 3 hours for good surface finish.

PROCESS PARAMETERS SUGGESTED

PROCESSING PARAMETERS	
ZONE1	190 -200°c
ZONE2	190-200°c
ZONE3	190 -200°c
ZONE4	200-215°c
Flange 1	200-215°c
Flange 2	200-215°c
Die	215-230°c
Vacuum	0.1 -0.2 bar
Water Temperature	15° c- 25°c

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