



**Product Data Sheet &
General Processing Conditions**

**PermaStat® 205
Nylon 6/6 (PA)
Permanently Anti-static
ESD Protection
Glass Fiber**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.32	1.32	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0030 - 0.0060 in/in	0.30 - 0.60 %	D 955
MECHANICAL			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	1.2 ft-lbs/in	64 J/m	D 256
unnotched 1/8 in (3.2 mm) section	6.0 ft-lbs/in	320 J/m	D 4812
Tensile Strength	11000 psi	76 MPa	D 638
Tensile Elongation	3.0 - 5.0 %	3.0 - 5.0 %	D 638
Tensile Modulus	0.90 x 10 ⁶ psi	6206 MPa	D 638
Flexural Strength	15000 psi	103 MPa	D 790
Flexural Modulus	0.75 x 10 ⁶ psi	5171 MPa	D 790
ELECTRICAL			
Volume Resistivity	1E8 - 1E10 ohm.cm	1E8 - 1E10 ohm.cm	D 257
Surface Resistivity	1E10 - 1E12 ohm/sq	1E10 - 1E12 ohm/sq	D 257
Static Decay MIL-PRF-81705D, 5kV to 50 V, 12% RH	< 2.00 s	< 2.00 s	FTMS101C 4046.1

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	465 - 520 °F	241 - 271 °C
Mold Temperature	150 - 225 °F	66 - 107 °C
Drying	2 hrs @ 175 °F	2 hrs @ 79 °C
Moisture Content	0.20 %	0.20 %
Dew Point	-20 °F	-29 °C

PROCESSING NOTES

Do not exceed 520 °F (270 °C) melt temperature.

Desiccant Type Dryer Required.