



Designation: D5989 – 14a

Standard Specification for Extruded and Monomer Cast Shapes Made from Nylon (PA)¹

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INTRODUCTION

This specification is intended to be a means of calling out plastic products used in the fabrication of end items or parts.

1. Scope*

1.1 This specification covers requirements and test methods for the material, dimensions, and workmanship, and the properties of extruded and cast sheet, plate, rod and tubular bar, excluding pipe and fittings, manufactured from nylon or monomers.

1.2 The properties included in this specification are those required for the compositions covered. Requirements necessary to identify particular characteristics important to specialized applications are described by using the classification system given in Section 4.

1.3 This specification allows for the use of recycled plastics (as defined in Guide D7209).

1.4 The values stated in English units are regarded as standard. The values in parentheses are for information only.

1.5 The following precautionary caveat pertains only to the test method portions of this specification. *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

NOTE 1—There is no known ISO equivalent to this standard.

NOTE 2—This specification is intended to replace Federal Standard LP-410A and PS 50.

2. Referenced Documents

2.1 ASTM Standards:²

¹ This specification is under the jurisdiction of ASTM Committee D20 on Plastics and is the direct responsibility of Subcommittee D20.15 on Thermoplastic Materials.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

D256 Test Methods for Determining the Izod Pendulum Impact Resistance of Plastics

D638 Test Method for Tensile Properties of Plastics

D790 Test Methods for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials

D883 Terminology Relating to Plastics

D3892 Practice for Packaging/Packing of Plastics

D6779 Classification System for and Basis of Specification for Polyamide Molding and Extrusion Materials (PA)

D7209 Guide for Waste Reduction, Resource Recovery, and Use of Recycled Polymeric Materials and Products

2.2 Federal Standard:³

LP-410A Nylon Stock Shapes

3. Terminology

3.1 Definitions:

3.1.1 *regrind (plastic), n*—a product or scrap such as sprues, runners and edge trim that have been reclaimed by shredding and granulating for use in-house.

3.1.2 For definitions of other technical terms pertaining to plastics used in this specification, see Terminology D883 or Guide D7209.

3.2 Definitions of Terms Specific to This Standard:

3.2.1 *finished product (F), n*—product that meets the dimensional criteria of Table 1, Table 2, Table 3, or Table 4 of this specification.

3.2.2 *monomer-cast nylon, n*—nylon polymer prepared by polymerization of epsilon-caprolactam or lauryllactam monomer.

3.2.3 *oversize product (O), n*—product that meets only the designated dimensional criteria of Table 2 or Table 4.

3.2.4 *plate, n*—flat stock greater than 3/8 in. (9.5 mm).

³ Available from U.S. Government Printing Office Superintendent of Documents, 732 N. Capitol St., NW, Mail Stop: SDE, Washington, DC 20401, http://www.access.gpo.gov.

*A Summary of Changes section appears at the end of this standard

TABLE 1 Dimensional Requirements for Extruded Nylon Rod^A

Size, in. ^B	Length Tolerance, in.	Diameter Tolerance, in.	Roundness TIR, in.	Camber, in./ft
1/16	+1 -0	+0.003 -0	0.002	2 1/2 /8
1/8	+1 -0	+0.003 -0	0.002	2 1/2 /8
3/16	+1 -0	+0.003 -0	0.002	2 1/2 /8
1/4	+1 -0	+0.003 -0	0.002	2 1/2 /8
3/8	+1 -0	+0.003 -0	0.002	2 1/2 /8
1/2	+1 -0	+0.003 -0	0.002	2 1/2 /8
5/8	+1 -0	+0.003 -0	0.002	2 1/2 /8
3/4	+1 -0	+0.003 -0	0.002	2 1/2 /8
7/8	+1 -0	+0.003 -0	0.002	2 1/2 /8
1	+1 -0	+0.003 -0	0.002	1 1/4 /8
1 1/8	+1 -0	+0.005 -0	0.005	1 1/4 /8
1 1/4	+1 -0	+0.005 -0	0.005	1 1/4 /8
1 3/8	+1 -0	+0.005 -0	0.005	1 1/4 /8
1 1/2	+1 -0	+0.005 -0	0.005	1 1/4 /8
1 5/8	+1 -0	+0.005 -0	0.005	1 1/4 /8
1 3/4	+1 -0	+0.005 -0	0.005	1 1/4 /8
1 7/8	+1 -0	+0.005 -0	0.005	1 1/4 /8
2	+1 -0	+0.005 -0	0.010	1 1/4 /8
2 1/8 -2 3/4	+1 -0	+0.015 -0	0.030	1 1/4 /8
3-5	+1 -0	+0.250 -0	0.060	1/4 /4
Over 5	+1 -0	+0.250 -0	0.060	1/4 /4

^ABased on dry-as-manufactured condition and proper product storage and handling.

^BTo convert inches to millimetres, multiply by 25.40.

3.2.5 *recycled-plastic shape, n*—a product made from up to 100 % post-consumer material.

3.2.6 *rod, n*—an extruded solid cylindrical shape with a minimum diameter of 1/16 in., or cast solid cylindrical shapes with a minimum diameter of 1 in. (25.4 mm).

3.2.7 *sheet, n*—flat stock less than and including 3/8 in. thickness.

3.2.8 *tubular bar, n*—extruded annular shapes with minimum inside diameter of 3/8 in. (9.5 mm) and minimum wall thickness of 1/16 in. (1.6 mm), or cast shapes with minimum inside diameter of 1/2 in. (12.7 mm), and minimum wall of 1/4 in. (6.4 mm).

3.2.9 *unmodified virgin plastic shape, n*—a product produced from virgin plastic, as furnished by a manufacturer, with no additives or processing aids.

3.2.10 *virgin-plastic shape, n*—product that is produced from 100 % plastic resin that has not been subjected to subsequent melt processing.

TABLE S-PA Requirements for Nylon (Polyamide) Shapes, Dry-as-Manufactured (<0.2 % Moisture)

Type	Description	Class	Description	Grade	Applicable Classification System D6779 Callout ^A	Description	Ultimate Tensile Strength, min, psi (MPa)	Tensile Elongation, % at Break, min	Tensile Modulus, min, psi (MPa)	Dimensional Stability, %, max		
01	Nylon 66	1	Unfilled	1	...	General purpose	10 000 (69)	25	350 000 (2400)	0.4		
				2	...	Recycled	9000 (62)	15	350 000 (2400)	0.7		
		2	MoS ₂ filled	3	PA 0114 ^B	Unmodified virgin	10 000 (69)	25	350 000 (2400)	0.4		
				1	PA 0110L01	General purpose	11 000 (76)	15	450 000 (3100)	0.4		
				2	...	Recycled	9000 (62)	5	350 000 (2400)	0.7		
				1	PA 0124	General purpose	10 000 (69)	25	350 000 (2400)	0.4		
				4	Weather resistant	1	PA 0180	General purpose	10 000 (69)	5	350 000 (2400)	0.4
				0	As specified	1	See Table 5	General purpose	
				2	See Table 5	Recycled		
				3	See Table 5	Unmodified virgin		
02	Monomer Cast Nylon 6	1	Unfilled	1	...	General purpose	10 000 (69)	25	350 000 (2400)	0.4		
				2	MoS ₂ filled, 0.5–1.5 %	1	...	General purpose	10 000 (69)	15	350 000 (2400)	0.4
				3	Heat stabilized ^C	1	...	General purpose	10 000 (69)	25	350 000 (2400)	0.4
				4	Internally lubricated	1	...	General purpose	9000 (62)	25	320 000 (2100)	0.4
				5	Oil-filled	1	...	General purpose	9000 (62)	25	350 000 (2400)	0.4
				6	Highly plasticized	1	...	General purpose	8000 (53)	100	275 000 (1845)	0.4
				0	As specified	1	See Table 5	General purpose	
03	Monomer Cast Nylon 612	1	Unfilled	1	...	General purpose	8000 (53)	40	300 000 (2000)	0.4		
				0	As specified	1	See Table 5	General purpose	
04	Nylon 6	1	Unfilled	1	...	General purpose	10 000 (69)	25	328 000 (2260)	0.4		
				0	As specified	1	See Table 5	General purpose	
05	Nylon 6/12	1	Unfilled	1	PA 0612/0613	General purpose	8000 (53)	20	300 000 (2000)	0.4		
				0	Unfilled	1	See Table 5	General purpose	
00	Other	0	...	0			

^A Applicable Classification System D6779 resin type to be specified on purchase order.

^B In accordance with Classification System D6779.

^C Heat resistance requirement is 75 % retention of original tensile strength after aging 100 h at 300 ± 3.5°F. After heat aging, use Test Method D638 procedure.

TABLE 2 Dimensional Requirements for Monomer Cast Nylon Rod^A

Size, in. ^B	Length Tolerance, in.	Diameter Tolerance, in.		Roundness TIR, in.		Camber, in./ft	
		Finished ^C	Oversize ^D	Finished ^C	Oversize ^D	Finished ^C	Oversize ^D
1	+1 -0	+0.015 -0	...	0.015	N/A ^E	¼ /4	N/A
1½	+1 -0	+0.015 -0	...	0.015	N/A	¼ /4	N/A
1¾	+1 -0	+0.015 -0	...	0.015	N/A	¼ /4	N/A
1⅝	+1 -0	+0.015 -0	+0.100 -0	0.015	N/A	¼ /4	N/A
1½	+1 -0	+0.015 -0	+0.100 -0	0.015	N/A	¼ /4	N/A
1⅝	+1 -0	+0.015 -0	+0.100 -0	0.015	N/A	¼ /4	N/A
1¾	+1 -0	+0.015 -0	+0.100 -0	0.015	N/A	¼ /4	N/A
1⅞	+1 -0	+0.015 -0	+0.100 -0	0.015	N/A	¼ /4	N/A
2-2¾	+1 -0	+0.015 -0	+0.125 -0	0.015	N/A	¼ /4	N/A
3-5	+1 -0	+0.250 -0	+0.250 -0	0.060	N/A	¼ /4	N/A
Over 5	+1 -0	+0.250 -0	+0.500 -0	N/A	N/A	N/A	N/A

^ABased on dry-as-manufactured condition and proper product storage and handling.

^BTo convert inches to millimetres, multiply by 25.40.

^CFinished product as defined in 3.2.1.

^DOversize product as defined in 3.2.3; roundness and camber not applicable.

^ENot applicable.

TABLE 3 Dimensional Requirements for Extruded Nylon Sheets and Plates^A (Squareness Requirement Listed in 11.4)

Size, in. ^B	Width Tolerance, in.	Thickness Tolerances, in. ^C	Length Camber, in./ft	Width Bow, in./ft
¼	+0.5 -0	±0.005	¾ /4	¾ /2
⅜	+0.5 -0	±0.005	¾ /4	¾ /2
½	+0.5 -0	±0.005	¾ /4	¾ /2
⅝	+0.5 -0	+0.025 -0	¾ /4	¾ /2
¾	+0.5 -0	+0.025 -0	¾ /4	¾ /2
⅞	+0.5 -0	+0.025 -0	¾ /4	¾ /2
1	+0.5 -0	+0.025 -0	¾ /4	¾ /2
1¼	+0.5 -0	+0.025 -0	¾ /4	¾ /2
1½	+0.5 -0	+0.025 -0	¾ /4	¾ /2
1¾	+0.5 -0	+0.025 -0	¾ /4	¾ /2
1⅞	+0.5 -0	+0.025 -0	¾ /4	¾ /2
2	+0.5 -0	+0.025 -0	¾ /4	¾ /2
Over 2	+0.5 -0	+0.050 -0	¾ /4	¾ /2

^ABased on dry-as-manufactured condition and proper product storage and handling.

^BTo convert inches to millimetres, multiply by 25.40.

^CLength tolerance in inches for all sizes at 48-in. length is +1.001 -0 and at 144-in. length is +1.001 -0.

(1) Extruded product made using virgin plastic plus up to 15 % maximum of an alternate virgin-nylon as a processing aid.

(2) Monomer-cast nylon made from epsilon-caprolactam or lauryllactam monomer.

4.2.2.2 *Grade 2—Recycled*—This specification allows for the use of nylon plastic materials that are recycled, reconstituted, recycled-regrind, recovered, or preprocessed, or combination thereof, provided that the requirements as stated in this specification are met. It is the responsibility of the supplier and the buyer of recycled, reconstituted recycled-regrind, recovered, or reprocessed Nylon plastic materials, or combination thereof, to ensure compliance. (See Guide D7209.)

(1) Extruded product made using any amount up to 100 % recycled nylon plastic.

(2) Does not apply to cast product.

4.2.2.3 *Grade 3—Unmodified Virgin*: -d5989-14a

(1) Extruded product made using 100 % unmodified virgin plastic.

(2) Does not apply to cast product.

4.3 The type, class, and grade is further differentiated based on dimensional stability (elevated temperature excursion test), Table S-PA, and dimensional requirements. The suffix F is added to any Table S-PA description to specify finished product meeting the dimensional properties of the appropriate table of Tables 1-4. The suffix O is added to any Table S-PA description to excuse cast products from roundness, camber, or bow requirements (3.2.3)

4.4 Property Tables:

4.4.1 Table S-PA is used to describe extruded or cast products, except where it does not cover the product type being considered.

4.4.2 Table 5 is used to describe extruded or cast products for which properties are not included in Table S-PA. A cell callout that includes the applicable Table S-PA nylon type and specific properties in Table 5. These are called out using the appropriate numerical property designations in order (1 through 7) preceded by the number 5. See Example 5 for a possible callout.

4. Classification and Material

4.1 Product shape and size as defined in the applicable purchase order.

4.2 This specification covers product extruded and cast as listed in Table S-PA. Products included in the designations reference Classification System D6779 callouts where applicable.

4.2.1 The type of nylon extruded product is categorized by type, grade and class depending on resin and filler compositions as defined in Table S-PA.

4.2.2 Each type of nylon shape is categorized into one of several grades as follows:

4.2.2.1 *Grade 1—General Purpose*: