

Technical Data Sheet

# Schulamid 6 GBF 3015 FC

Polyamide 6  
LyondellBasell Industries  
Engineering Plastics

**Product Description**  
30% glass fibre and glass bead reinforced PA 6, high strength, low warpage for food contact applications

General	
Filler / Reinforcement	• Glass Bead\Glass Fiber, 30% Filler by Weight
Features	• High Strength • Low Warpage
UL File Number	• E86615
Processing Method	• Injection Molding
Part Marking Code (ISO 11469)	• >PA6-(GB15+GF15)<

Physical	Dry	Conditioned	Unit	Test Method
Density	1.35	--	g/cm <sup>3</sup>	ISO 1183/A
Viscosity Number	145	--	cm <sup>3</sup> /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	870000 (6000)	435000 (3000)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	17400 (120)	8700 (60.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	4.0	10	%	ISO 527-2/1A/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (73°F (23°C))	2.4 (5.0)	4.8 (10)	ft·lb/in <sup>2</sup> (kJ/m <sup>2</sup> )	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
73°F (23°C)	21 (45)	38 (80)	ft·lb/in <sup>2</sup> (kJ/m <sup>2</sup> )	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/Af
264 Psi (1.8 Mpa), Unannealed	374 (190)	--	°F (°C)	
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 In (2.00 Mm)	< 3.9 (< 100)	--	in/min (mm/min)	ISO 3795
0.0787 In (2.00 Mm)	< 3.9 (< 100)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.06 In (1.5 Mm)	HB	--		

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Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

**Notes**

These are typical property values not to be construed as specification limits.