Technical Data Sheet

Schulamid 6 GBF 3015 FR 2

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description
30% glass fibre and glass bead reinforced flame retardant PA6 compound, increased strength and dimensional stability; halogenfree; PBDE free, with low warpage

General			
Filler / Reinforcement	• Glass Bead\Glass Fiber, 30% Filler by Weight		
Features	• Flame Retardant • Good Dimensional Stability	• Good Strength • Halogen Free	• Low Warpage
Automotive Specifications	• FORD WSK-M4D665-A		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA6 (GF+GB)30 FR(40)		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.42 g/cm³	1.42 g/cm³	ISO 1183/A
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	1.20E+6 psi	8300 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	16000 psi	110 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.7 %	2.7 %	ISO 527-2/1A/5
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°f (-30°c)	2.6 ft·lb/in²	5.5 kJ/m²	
73°f (23°c)	3.3 ft·lb/in²	7.0 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°f (-30°c)	19 ft·lb/in²	40 kJ/m²	
73°f (23°c)	22 ft·lb/in²	46 kJ/m²	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	417 °F	214 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	388 °F	198 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	406 °F	208 °C	ISO 306/B50
--	419 °F	215 °C	ISO 306/A120
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Comparative Tracking Index	425 V	425 V	IEC 60112
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Flammability Classification			IEC 60695-11-10, -20
0.030 In (0.75 Mm)	V-0	V-0	
0.06 In (1.5 Mm)	V-0	V-0	
0.12 In (3.0 Mm)	V-0	V-0	
Glow Wire Flammability Index			IEC 60695-2-12
0.030 In (0.75 Mm)	1760 °F	960 °C	
0.06 In (1.5 Mm)	1760 °F	960 °C	
0.12 In (3.0 Mm)	1760 °F	960 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.030 In (0.75 Mm)	1380 °F	750 °C	
0.06 In (1.5 Mm)	1380 °F	750 °C	
0.12 In (3.0 Mm)	1380 °F	750 °C	

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Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Oxygen Index	35 %	35 %	ISO 4589-2

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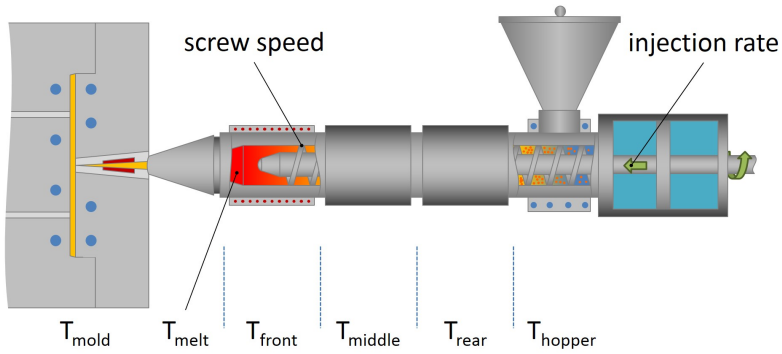

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	464 to 518 °F	240 to 270 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	< 591 in/min	< 15 m/min
Screw Speed	< 591 in/min	< 15 m/min

Notes

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