Technical Data Sheet

SCHULAMID® 6 GF 15 HI K2073 BLACK 96.8001

Polyamide 6
Engineering Plastics

Product Description
15% glass fiber reinforced and impact modified Polyamide 6

General	
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA 6 GF 15 HI

Physical	Dry	Conditioned	Unit	Test Method
Density	1.21	--	g/cm³	ISO 1183/A
Viscosity Number	145	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	783000 (5400)	442000 (3050)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	14200 (98.0)	8560 (59.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.7	14	%	ISO 527-2/1A/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	2.0 (4.2)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	4.3 (9.0)	7.6 (16)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	22 (46)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	30 (62)	43 (90)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	410 (210)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	374 (190)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	419 (215)	--	°F (°C)	ISO 306/A50
--	401 (205)	--	°F (°C)	ISO 306/B50
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

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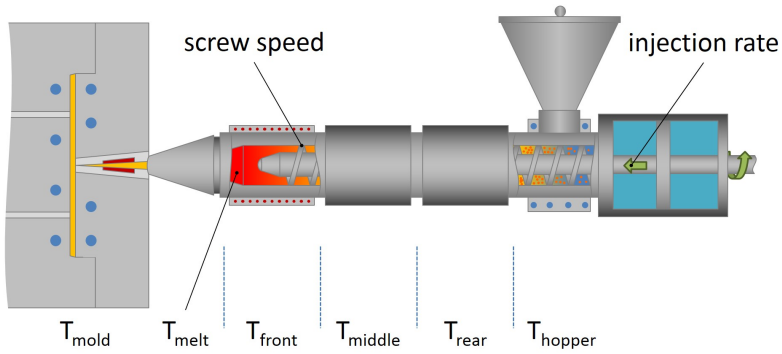

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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