Technical Data Sheet

Schulamid 6 GF 15 HI

Polyamide 6
LyondellBasell Industries
Engineering Plastics

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

General		
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight	
Features	• Good Processability • Good Toughness	• High Impact Resistance • Oil Resistant
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA6I-GF15	

Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm³	ISO 1183/A
Viscosity Number	145	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	725000 (5000)	377000 (2600)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	14500 (100)	8700 (60.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	5.0	15	%	ISO 527-2/1A/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°f (-30°c)	3.3 (7.0)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	7.6 (16)	11 (24)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°f (-30°c)	27 (56)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	33 ft·lb/in² (70 kJ/m²)	No Break	(kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				
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				
--	401 (205)	--	°F (°C)	ISO 306/B50
--	419 (215)	--	°F (°C)	ISO 306/A50
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+15	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+13	1.0E+10	ohms·m	IEC 62631-3-1

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Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 In (2.00 Mm)	2.0 (50)	--	in/min (mm/min)	ISO 3795
0.0787 In (2.00 Mm)	2.0 (50)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.06 In (1.5 Mm)	HB	--		
0.12 In (3.0 Mm)	HB	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.06 In (1.5 Mm)	1200 (650)	--	°F (°C)	
0.12 In (3.0 Mm)	1200 (650)	--	°F (°C)	

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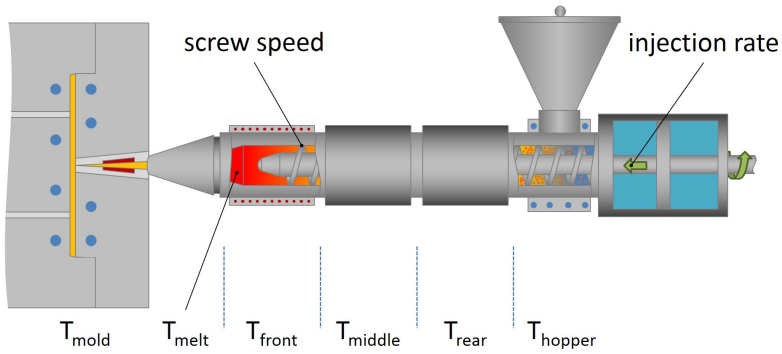

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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