Technical Data Sheet

Schulamid 6 GF 25 H

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description	
25% glass fibre reinforced PA 6, heat stabilized	

General	
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
Processing Method	• Injection Molding
Part Marking Code (ISO 11469)	• >PA6-GF<

Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm³	ISO 1183/A
Water Absorption				ISO 62
Equilibrium, 73°f (23°c), 50% Rh	1.9	--	%	
Viscosity Number	145	--	cm³/g	ISO 307

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.23E+6 (8500)	696000 (4800)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	22000 (152)	13100 (90.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.5	7.5	%	ISO 527-2/1A/5
Flexural Modulus [1]	1.16E+6 (8000)	667000 (4600)	psi (MPa)	ISO 178
Flexural Stress [1] (3.5% Strain)	34800 (240)	18100 (125)	psi (MPa)	ISO 178

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)	3.8 (8.0)	7.1 (15)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°f (-30°c)	24 (50)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	29 ft·lb/in² (60 kJ/m²)	No Break	(kJ/m²)	

Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 961/30)	34800 (240)	--	psi (MPa)	ISO 2039-1

Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	419 (215)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	392 (200)	--	°F (°C)	ISO 75-2/Af

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Thermal	Dry	Conditioned	Unit	Test Method
Vicat Softening Temperature				
--	410 (210)	--	°F (°C)	ISO 306/B50
--	424 (218)	--	°F (°C)	ISO 306/A120
RTI Elec				UL 746B
0.030 In (0.75 Mm)	257 (125)	--	°F (°C)	
0.06 In (1.5 Mm)	257 (125)	--	°F (°C)	
0.12 In (3.0 Mm)	257 (125)	--	°F (°C)	
RTI Imp				UL 746B
0.030 In (0.75 Mm)	239 (115)	--	°F (°C)	
0.06 In (1.5 Mm)	248 (120)	--	°F (°C)	
0.12 In (3.0 Mm)	257 (125)	--	°F (°C)	
RTI Str				UL 746B
0.030 In (0.75 Mm)	266 (130)	--	°F (°C)	
0.06 In (1.5 Mm)	266 (130)	--	°F (°C)	
0.12 In (3.0 Mm)	266 (130)	--	°F (°C)	

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
Comparative Tracking Index	450	--	V	IEC 60112

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Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 In (2.00 Mm)	1.6 (40)	--	in/min (mm/min)	ISO 3795
0.0787 In (2.00 Mm)	1.6 (40)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.030 In (0.75 Mm)	HB	--		
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)	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.06 In (1.5 Mm)	1250 (675)	--	°F (°C)	
0.12 In (3.0 Mm)	1250 (675)	--	°F (°C)	

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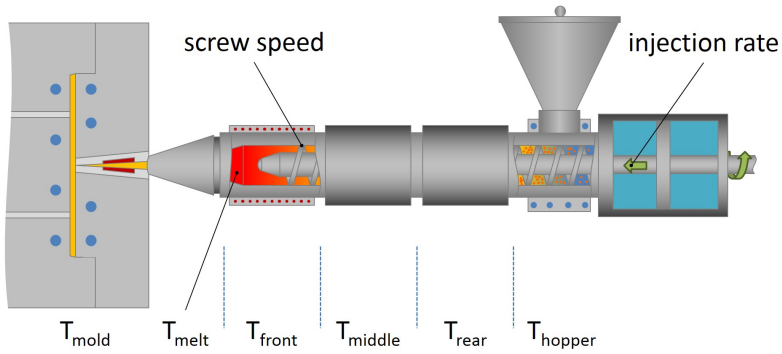

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

[1] 0.079 in/min (2.0 mm/min)

Notes

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