Technical Data Sheet

Schulamid 6 GF 30 FR 2 H0

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description
30% glass fibre reinforced flame-retardant Polyamide 6 grade; halogen free, electrically neutral

General		
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Features	• Flame Retardant	• Halogen Free
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA6 GF30 FR(40)	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.43 g/cm³	1.43 g/cm³	ISO 1183/A
Viscosity Number	143 cm³/g	143 cm³/g	ISO 307
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	1.52E+6 psi	10500 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	21000 psi	145 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0 %	3.0 %	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)	4.3 ft·lb/in²	9.0 kJ/m²	
73°f (23°c)	5.2 ft·lb/in²	11 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°f (-30°c)	29 ft·lb/in²	60 kJ/m²	
73°f (23°c)	33 ft·lb/in²	70 kJ/m²	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	419 °F	215 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	399 °F	204 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	397 °F	203 °C	ISO 306/B50
--	414 °F	212 °C	ISO 306/A50
Ball Pressure Test (392°f (200°c))	Pass	Pass	IEC 60695-10-2
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Comparative Tracking Index	600 V	600 V	IEC 60112
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Burning Rate			ISO 3795
0.0295 In (0.750 Mm), Self-extinguishing	0.0 in/min	0.0 mm/min	
0.0591 In (1.50 Mm), Self-extinguishing	0.0 in/min	0.0 mm/min	
0.118 In (3.00 Mm), Self-extinguishing	0.0 in/min	0.0 mm/min	
Flammability Classification			IEC 60695-11-10, -20
0.030 In (0.75 Mm)	V-0	V-0	
--	• V-0 • 5VA	• V-0 • 5VA	
0.12 In (3.0 Mm)	• V-0 • 5VA	• V-0 • 5VA	
0.08 In (2.0 Mm)	5VA	5VA	

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Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
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)	1470 °F	800 °C	
0.06 In (1.5 Mm)	1470 °F	800 °C	
0.12 In (3.0 Mm)	1470 °F	800 °C	
Oxygen Index	32 %	32 %	ISO 4589-2

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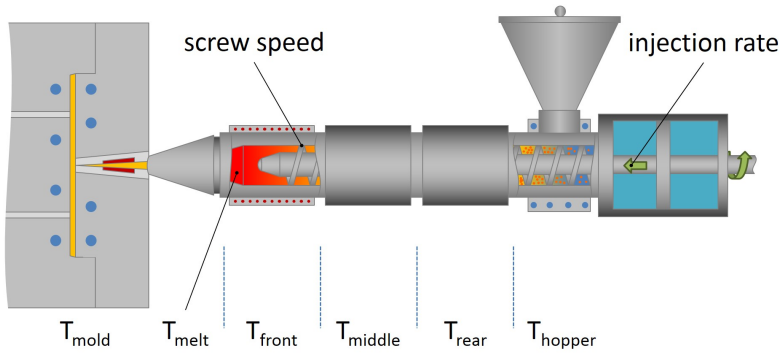

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	518 to 572 °F	270 to 300 °C
Mold Temperature	140 to 194 °F	60 to 90 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Screw Speed	< 591 in/min	< 15 m/min

Notes

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