Technical Data Sheet

SCHULAMID® 6 GF 30 HI WIT

Polyamide 6
Engineering Plastics

Product Description
30% glass fiber reinforced high impact Polyamide 6, optimized for WIT-processes

General			
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Features	• Good Processability • Good Stiffness	• Good Surface Finish • Good Toughness	• Impact Modified • Oil Resistant
Processing Method	• Injection Molding	• Water-Assisted Injection Molding	

Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm³	ISO 1183/A
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	1.07E+6 (7400)	725000 (5000)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	16700 (115)	12300 (85.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	4.0	10	%	ISO 527-2/1A/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	4.8 (10)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	6.7 (14)	9.5 (20)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	33 (70)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	36 (75)	38 (80)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/Af
264 psi (1.8 MPa), Unannealed	365 (185)	--	°F (°C)	
Vicat Softening Temperature	392 (200)	--	°F (°C)	ISO 306/B50
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+15	--	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	> 1.0E+10	ohms·m	IEC 62631-3-1
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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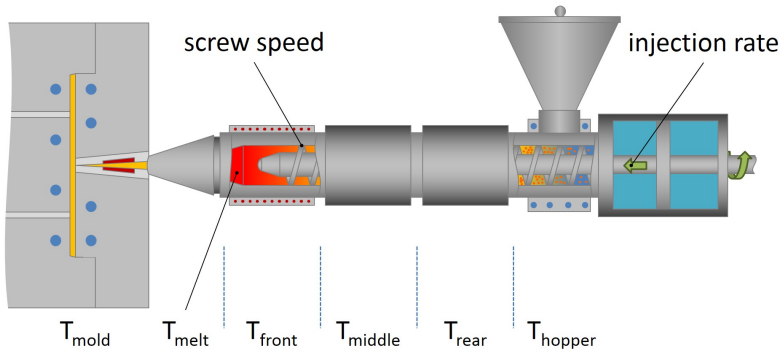

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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