Technical Data Sheet

SCHULAMID® 6 GF 30 IS

Polyamide 6
Engineering Plastics

Product Description
30% glass fiber reinforced Polyamide 6, optimized for GID-processes

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

Physical	Dry	Conditioned	Unit	Test Method
Density	1.35	--	g/cm³	ISO 1183/A
Molding Shrinkage				ISO 294-4
Across Flow	0.90	--	%	
Flow	0.20	--	%	
Viscosity Number	145	--	cm³/g	ISO 307

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.28E+6 (8800)	754000 (5200)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	22500 (155)	13100 (90.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.5	8.5	%	ISO 527-2/1A/5

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	3.8 (8.0)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	5.7 (12)	12 (26)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	35 (74)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	38 (80)	45 (95)	ft·lb/in² (kJ/m²)	

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	419 (215)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	383 (195)	--	°F (°C)	ISO 75-2/Af

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)	1.2 (30)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	1.2 (30)	--	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	--		

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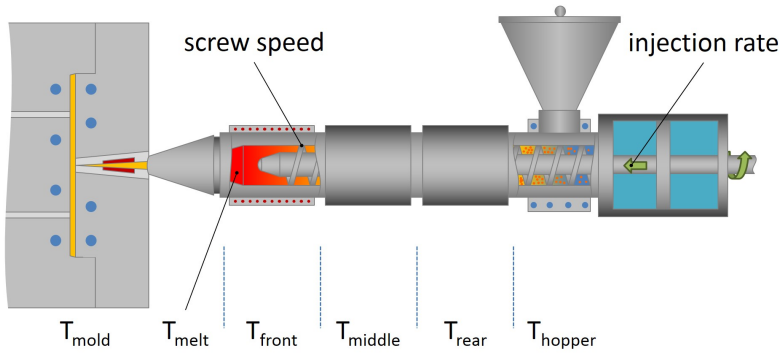

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	158 to 212 °F	70 to 100 °C

Notes

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