Technical Data Sheet

SCHULAMID® 6 GF 40

Polyamide 6
Engineering Plastics

Product Description
40% glass fiber reinforced polyamid 6 compound

General	
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA6-GF

Physical	Dry	Conditioned	Unit	Test Method
Density	1.45	--	g/cm³	ISO 1183/A
Viscosity Number	145	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	2.03E+6 (14000)	1.23E+6 (8500)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	29000 (200)	18600 (128)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.8	6.3	%	ISO 527-2/1A/5
Flexural Modulus [1]	1.74E+6 (12000)	--	psi (MPa)	ISO 178
Flexural Stress [1]	43500 (300)	--	psi (MPa)	ISO 178
Flexural Strain at Flexural Strength	3.5	--	%	ISO 178
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)	10 (22)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	41 (86)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	45 ft·lb/in² (94 kJ/m²)	No Break	(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	401 (205)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	421 (216)	--	°F (°C)	ISO 306/A50
--	414 (212)	--	°F (°C)	ISO 306/B50

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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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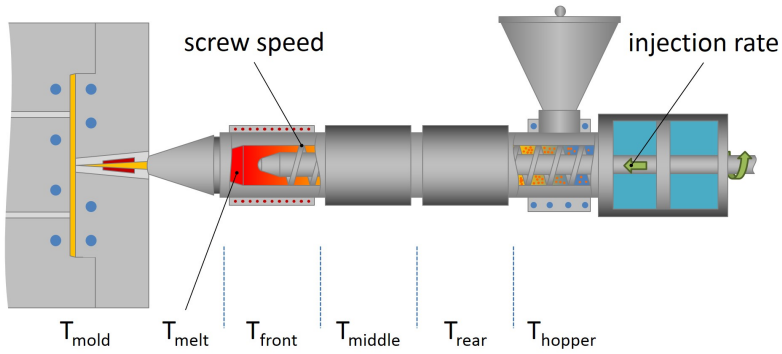

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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

Notes

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