Technical Data Sheet

Schulamid 6 GF 65

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description
65% glass fiber reinforced Polyamide 6 with very high tensile strength and stiffness

General	
Filler / Reinforcement	• Glass Fiber, 65% Filler by Weight
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PAM 6 GF65

Physical	Dry	Conditioned	Unit	Test Method
Density	1.77	--	g/cm³	ISO 1183/A
Viscosity Number (H2so4 (sulphuric Acid))	120	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	3.34E+6 (23000)	2.06E+6 (14200)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	34100 (235)	21800 (150)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	1.8	2.4	%	ISO 527-2/1A/5
Flexural Modulus [1]	2.90E+6 (20000)	--	psi (MPa)	ISO 178
Flexural Stress [1]				ISO 178
2.6% Strain	52200 (360)	--	psi (MPa)	
2.7% Strain [2]	50800 (350)	--	psi (MPa)	
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°f (-30°c)	6.2 (13)	--	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)	37 (77)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	38 (80)	39 (82)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				ISO 75-2/Af
264 Psi (1.8 Mpa), Unannealed	419 (215)	--	°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

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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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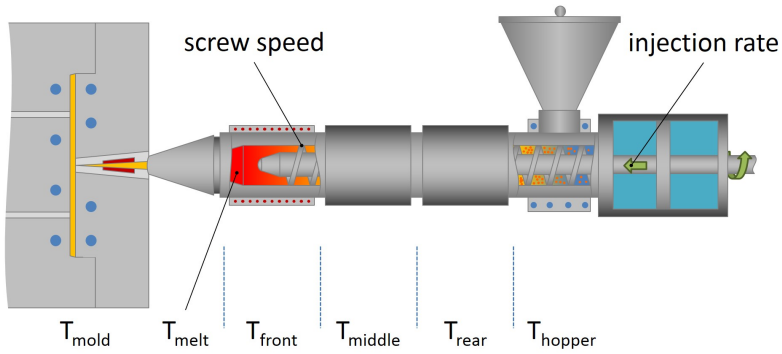

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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

[2] at Break

Notes

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