Technical Data Sheet

SCHULAMID® 6 HV 11

Polyamide 6
Engineering Plastics

Product Description
High viscosity Polyamide 6 for extrusion and injection molding

General			
Features	• Good Toughness	• High Viscosity	• Oil Resistant
Processing Method	• Extrusion	• Injection Molding	
Resin ID (ISO 1043)	• PA6		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm³	ISO 1183/A
Water Absorption				ISO 62
Equilibrium, 73°F (23°C), 50% RH	2.5	--	%	
Viscosity Number	245	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	363000 (2500)	174000 (1200)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Yield)	10900 (75.0)	7250 (50.0)	psi (MPa)	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	25	%	ISO 527-2/1A/50
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F (23°C))	6.7 (14)	29 (60)	ft·lb/in² (kJ/m²)	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
73°F (23°C)	No Break	No Break		
Hardness	**Dry**	**Conditioned**	**Unit**	**Test Method**
Ball Indentation Hardness (H 358/30)	18900 (130)	10900 (75.0)	psi (MPa)	ISO 2039-1
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	347 (175)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	149 (65.0)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	414 (212)	--	°F (°C)	ISO 306/A50
--	385 (196)	--	°F (°C)	ISO 306/B50
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
Comparative Tracking Index	600	--	V	IEC 60112

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Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 in (2.00 mm)	3.1 (80)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	3.1 (80)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.030 in (0.75 mm)	HB	--		
0.06 in (1.5 mm)	HB	--		
0.12 in (3.0 mm)	HB	--		

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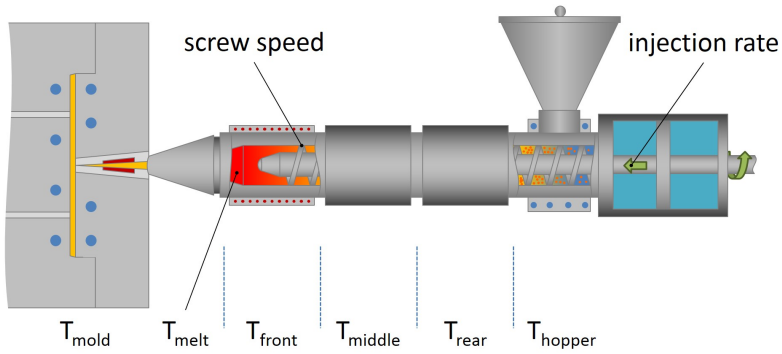

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 518 °F	250 to 270 °C
Mold Temperature	140 to 194 °F	60 to 90 °C

Notes

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