Technical Data Sheet

SCHULAMID® 6 MKF 4015 K2098

Polyamide 6
Engineering Plastics

Product Description
40% glass fiber and mineral reinforced Polyamide 6

General	
Filler / Reinforcement	• Glass\Mineral, 40% Filler by Weight
Processing Method	• Injection Molding

Physical	Dry	Conditioned	Unit	Test Method
Density	1.45	--	g/cm³	ISO 1183/A
Viscosity Number	140	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	943000 (6500)	450000 (3100)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	13100 (90.0)	6530 (45.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.6	4.8	%	ISO 527-2/1A/5
Flexural Modulus [1]	870000 (6000)	--	psi (MPa)	ISO 178
Flexural Stress [1] (3.5% Strain)	20300 (140)	--	psi (MPa)	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	1.7 (3.5)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	1.9 (4.0)	3.8 (8.0)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	16 (34)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	17 (35)	25 (52)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	410 (210)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	338 (170)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	419 (215)	--	°F (°C)	ISO 306/A50
--	406 (208)	--	°F (°C)	ISO 306/B50
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Burning Rate [2]				
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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Additional Information

1.) Not for use in food contact applications
2.) Not for use in medical or pharmaceutical applications

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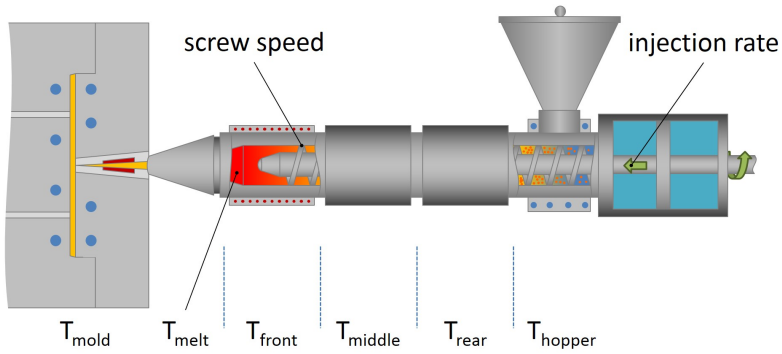

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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

[2] Self-Extinguishing

Notes

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