**Technical Data Sheet**

# *Schulamid* 6 MKF 4015

Polyamide 6
LyondellBasell Industries
Engineering Plastics

| Product Description |
|---|
| 40% glass fiber and mineral reinforced Polyamide 6 with high tensile strain at break and high dimension stability |

| General | | |
|---|---|---|
| Filler / Reinforcement | • Glass\Mineral, 40% Filler by Weight | |
| Features | • Balanced Stiffness/Toughness<br>• Good Processability | • Low Warpage<br>• Oil Resistant |
| Processing Method | • Injection Molding | |

| Physical | Dry | Conditioned | Unit | Test Method |
|---|---|---|---|---|
| Density | 1.45 | -- | g/cm³ | ISO 1183/A |
| Water Absorption | | | | ISO 62 |
| Equilibrium, 73°f (23°c), 50% Rh | 1.9 | -- | % | |
| Viscosity Number | 145 | -- | cm³/g | ISO 307 |

| Mechanical | Dry | Conditioned | Unit | Test Method |
|---|---|---|---|---|
| Tensile Modulus | 1.02E+6<br>(7000) | 653000<br>(4500) | psi<br>(MPa) | ISO 527-1/1A/1 |
| Tensile Stress (Break) | 16000<br>(110) | 10200<br>(70.0) | psi<br>(MPa) | ISO 527-2/1A/5 |
| Tensile Strain (Break) | 2.0 | 3.0 | % | ISO 527-2/1A/5 |

| Impact | Dry | Conditioned | Unit | Test Method |
|---|---|---|---|---|
| Charpy Notched Impact Strength | | | | ISO 179/1eA |
| -22°f (-30°c) | 2.4<br>(5.0) | 3.8<br>(8.0) | ft·lb/in²<br>(kJ/m²) | |
| 73°f (23°c) | 3.8<br>(8.0) | 6.2<br>(13) | ft·lb/in²<br>(kJ/m²) | |
| Charpy Unnotched Impact Strength | | | | ISO 179/1eU |
| -22°f (-30°c) | 19<br>(40) | 29<br>(60) | ft·lb/in²<br>(kJ/m²) | |
| 73°f (23°c) | 24<br>(50) | 36<br>(75) | ft·lb/in²<br>(kJ/m²) | |

| Hardness | Dry | Conditioned | Unit | Test Method |
|---|---|---|---|---|
| Ball Indentation Hardness (H 358/30) | 29700<br>(205) | -- | psi<br>(MPa) | ISO 2039-1 |

| Thermal | Dry | Conditioned | Unit | Test Method |
|---|---|---|---|---|
| Deflection Temperature Under Load | | | | |
| 66 Psi (0.45 Mpa), Unannealed | 410<br>(210) | -- | °F<br>(°C) | ISO 75-2/Bf |
| 264 Psi (1.8 Mpa), Unannealed | 356<br>(180) | -- | °F<br>(°C) | ISO 75-2/Af |
| Vicat Softening Temperature | | | | |
| -- | 410<br>(210) | -- | °F<br>(°C) | ISO 306/B50 |
| -- | 419<br>(215) | -- | °F<br>(°C) | ISO 306/A50 |

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| 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 | 400 | -- | V | IEC 60112 |
| **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 |
| Flammability Classification | | | | IEC 60695-11-10, -20 |
| 0.06 In (1.5 Mm) | -- | HB | | |
| 0.12 In (3.0 Mm) | -- | HB | | |
| Glow Wire Flammability Index | | | | IEC 60695-2-12 |
| 0.06 In (1.5 Mm) | -- | 1200 (650) | °F (°C) | |
| 0.12 In (3.0 Mm) | -- | 1200 (650) | °F (°C) | |

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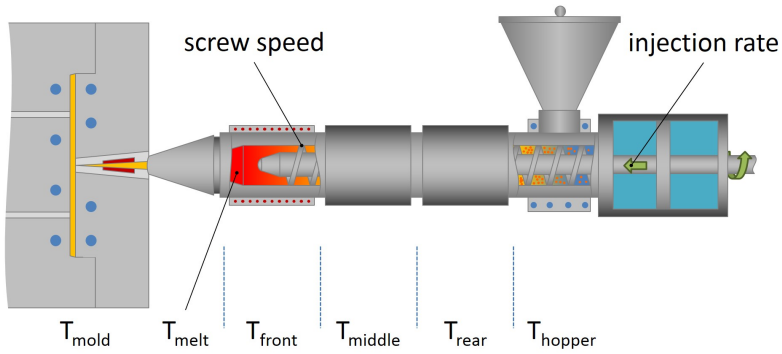


| Injection | Dry (English) | Dry (SI) |
|---|---|---|
| Drying Temperature | 176 °F | 80 °C |
| Drying Time | 3.0 to 4.0 hr | 3.0 to 4.0 hr |
| Suggested Max Moisture | 0.04 to 0.10 % | 0.04 to 0.10 % |
| Processing (Melt) Temp | 482 to 536 °F | 250 to 280 °C |
| Mold Temperature | 140 to 212 °F | 60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

**Notes**

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