Technical Data Sheet

Schulamid 6 MKF 4520 H

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description
45% glass fiber and mineral reinforced PA 6, heat stabilized, high strength, low warpage

General			
Filler / Reinforcement	• Glass Fiber, 45% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Heat Stabilized	• High Strength	• Low Warpage
Processing Method	• Injection Molding		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.52	--	g/cm³	ISO 1183/A
Viscosity Number	145	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	1.60E+6 (11000)	856000 (5900)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	20300 (140)	11600 (80.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	4.0	%	ISO 527-2/1A/5
Flexural Modulus	1.32E+6 (9100)	--	psi (MPa)	ISO 178
Flexural Stress	29000 (200)	--	psi (MPa)	ISO 178
Flexural Strain at Flexural Strength	3.0	--	%	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°f (-30°c)	1.9 (4.0)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	3.3 (7.0)	4.3 (9.0)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°f (-30°c)	21 (45)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	23 (48)	29 (60)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	419 (215)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	392 (200)	--	°F (°C)	ISO 75-2/Af
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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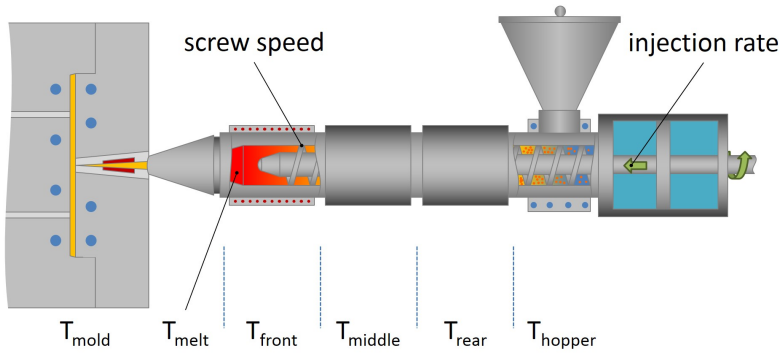

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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