Technical Data Sheet

SCHULAMID® 6 GBF 3015 FR 2

Polyamide 6
Engineering Plastics

Product Description
30% glass fibre and glass bead reinforced flame retardant PA6 compound, increased strength and dimensional stability; halogenfree; PBDE free, with low warpage

General			
Filler / Reinforcement	• Glass Bead\Glass Fiber, 30% Filler by Weight		
Features	• Flame Retardant • Good Dimensional Stability	• Good Strength • Halogen Free	• Low Warpage
Automotive Specifications	• FORD WSK-M4D665-A		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA6 (GF+GB)30 FR(40)		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.42	--	g/cm³	ISO 1183/A
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	1.20E+6 (8300)	638000 (4400)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	16000 (110)	8990 (62.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.7	5.5	%	ISO 527-2/1A/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	2.6 (5.5)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	3.3 (7.0)	5.9 (13)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	19 (40)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	22 (46)	24 (50)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	417 (214)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	388 (198)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	419 (215)	--	°F (°C)	ISO 306/A120
--	406 (208)	--	°F (°C)	ISO 306/B50
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Comparative Tracking Index	425	--	V	IEC 60112

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Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.030 in (0.75 mm)	V-0	--		
0.06 in (1.5 mm)	V-0	--		
0.12 in (3.0 mm)	V-0	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.030 in (0.75 mm)	1760 (960)	--	°F (°C)	
0.06 in (1.5 mm)	1760 (960)	--	°F (°C)	
0.12 in (3.0 mm)	1760 (960)	--	°F (°C)	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.030 in (0.75 mm)	1380 (750)	--	°F (°C)	
0.06 in (1.5 mm)	1380 (750)	--	°F (°C)	
0.12 in (3.0 mm)	1380 (750)	--	°F (°C)	
Oxygen Index	35	--	%	ISO 4589-2

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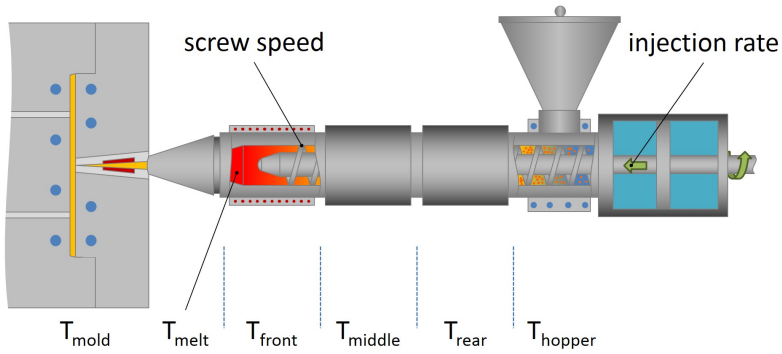

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	25 %	25 %
Processing (Melt) Temp	464 to 518 °F	240 to 270 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	< 591 in/min	< 15 m/min
Screw Speed	< 591 in/min	< 15 m/min

Notes

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