Technical Data Sheet

SCHULAMID® 6 GBF 3310 HI H LS

Polyamide 6
Engineering Plastics

Product Description	
33% glass fibre and glass bead reinforced PA 6; impact modified, heat and UV stabilized	
General	
Filler / Reinforcement	• Glass Bead\Glass Fiber, 33% Filler by Weight
Processing Method	• Injection Molding

Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm³	ISO 1183/A
Viscosity Number	148	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	783000 (5400)	370000 (2550)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	13500 (93.0)	7400 (51.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	4.5	15	%	ISO 527-2/1A/5
Flexural Modulus [1]	667000 (4600)	--	psi (MPa)	ISO 178
Flexural Stress [1]				ISO 178
5.5% Strain	21000 (145)	--	psi (MPa)	
3.5% Strain	18900 (130)	--	psi (MPa)	
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	4.2 (8.8)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	6.5 (14)	11 (24)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	32 (68)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	33 (70)	45 (95)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	401 (205)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	338 (170)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature	403 (206)	--	°F (°C)	ISO 306/B50
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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Additional Information

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

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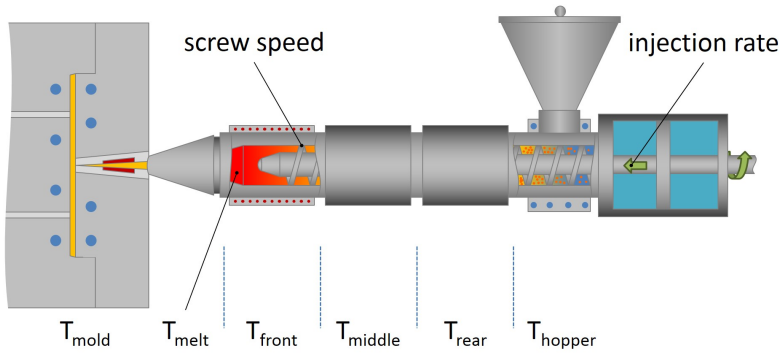

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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

Notes

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