Technical Data Sheet

SCHULAMID® 6 GF 15 HI BM

Polyamide 6
Engineering Plastics

Product Description
15% glass fiber reinforced and impact modified Polyamide 6 with high melt strength for blowmoulding processing

General			
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Features	• Good Processing Stability • Heat Aging Resistant	• High Impact Resistance • High Melt Stability	• High Viscosity • Oil Resistant
Processing Method	• Blow Molding	• Injection Molding	
Resin ID (ISO 1043)	• PA6I GF15		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm³	ISO 1183/A
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	725000 (5000)	334000 (2300)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	12500 (86.0)	7980 (55.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	7.0	24	%	ISO 527-2/1A/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	2.9 (6.0)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	5.7 (12)	17 (36)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	29 (60)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	33 ft·lb/in² (70 kJ/m²)	No Break	(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	329 (165)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	428 (220)	--	°F (°C)	ISO 306/A50
--	383 (195)	--	°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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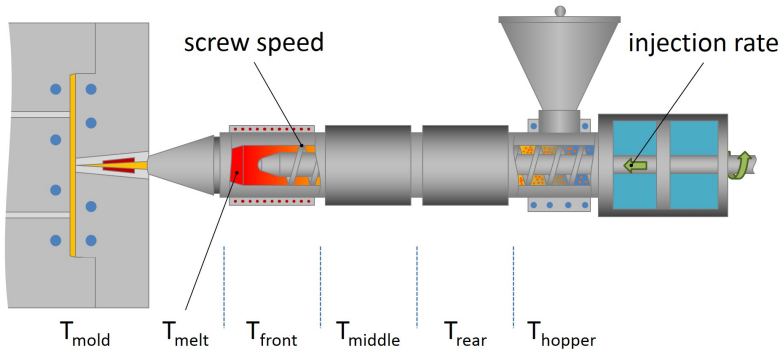

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

Notes

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