

Technical Data Sheet

**Schulamid 6 GBF3015 FR2 BLK968001**



Polyamide 6

**Product Description**

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

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	Good Dimensional Stability; Good Strength; Halogen Free; Low Warpage; PFAS free
<b>Additive</b>	Flame Retardant
<b>Filler/Reinforcement</b>	Glass Bead\Glass Fiber, 30%
<b>Resin ID</b>	PA6

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Density, (Method A)	1.42	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	2.7	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	5.5	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 5 mm/min)	110	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	62.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	8300	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	4400	MPa	ISO 527-1
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	7.0	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	5.5	kJ/m <sup>2</sup>	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	13	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	46	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise)	40	kJ/m <sup>2</sup>	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	50	kJ/m <sup>2</sup>	ISO 179
<b>Thermal</b>			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	208	°C	ISO 306
(A (10N), 120 °C/h)	215	°C	ISO 306

Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	214	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	198	°C	ISO 75-2/A
<b>Electrical</b>			
Comparative Tracking Index (CTI)	425	V	IEC 60112
<b>Flammable</b>			
Glow Wire Flammability Index			
(0.75 mm)	960	°C	IEC 60695-2-12
(1.5 mm)	960	°C	IEC 60695-2-12
(3.0 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(0.75 mm)	750	°C	IEC 60695-2-13
(1.5 mm)	750	°C	IEC 60695-2-13
(3.0 mm)	750	°C	IEC 60695-2-13
Oxygen Index	35	%	ISO 4589-2
<b>UL Information</b>			
Flammability Classification			
(0.75 mm)	V-0		IEC 60695-11-10, -20
(1.5 mm)	V-0		IEC 60695-11-10, -20
(3.0 mm)	V-0		IEC 60695-11-10, -20
<b>Injection Parameters</b>			
	<b>Nominal Value</b>	<b>Units</b>	
Drying Time	3.0 to 4.0	hr	
Drying Temperature	80	°C	
Suggested Max Moisture	0.040 to 0.10	%	
Screw Speed	<250	mm/sec	
Processing (Melt) Temp	240 to 270	°C	
Injection Rate	Slow-Moderate		
Back Pressure	<250	mm/sec	
Mold Temperature	60 to 100	°C	