Technical Data Sheet

Schulamid 6 GF15 HI K2073 BLK968001

Polyamide 6

Product Description

15% glass fiber reinforced and impact modified Polyamide 6

Processing Method	Injection Molding
Filler/Reinforcement	Glass Fiber, 15%
Resin ID	PA 6 GF 15 HI

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.21	g/cm³	ISO 1183
Viscosity Number	145	cm³/g	ISO 307
Mechanical			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	3.7	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	14	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 5 mm/min)	98.0	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	59.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	5400	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	3050	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	9.0	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	4.2	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	16	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	62	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	46	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	90	kJ/m²	ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	205	°C	ISO 306
(A (10N), 50 °C/h)	215	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	210	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	190	°C	ISO 75-2/A

Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302

Injection Parameters	Nominal Value	Units
Drying Time	3.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	250 to 280	°C
Mold Temperature	60 to 100	°C