Technical Data Sheet

Schulamid 6 GF15 LS GRY967677

Polyamide 6

Product Description

15% glass fibre reinforced Polyamide 6

Processing Method	Injection Molding
Attribute	Good Flow; Good Surface Finish
Filler/Reinforcement	Glass Fiber, 15%
Resin ID	PA6 GF15

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.25	g/cm³	ISO 1183
Viscosity Number	100	cm³/g	ISO 307
Mechanical			
Tensile Strain at Break, (Type 1A, 5 mm/min)	2.5	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	130	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	5500	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched, (23 °C, Type 1, Edgewise, Notch A)	3.5	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched, (25 °C, Type 1, Edgewise)	45	kJ/m²	ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	210	°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)	200	°C	ISO 75-2/A

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