

Technical Data Sheet

**Schulamid 6 GF15 SHI K2384 NAT**



Polyamide 6

**Product Description**

15% glass fibre reinforced PA 6, impact modified

**Processing Method** Injection Molding

**Filler/Reinforcement** Glass Fiber, 15%

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Density, (Method A)	1.20	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	15	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	43	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 5 mm/min)	48.0	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	27.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	3150	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	1150	MPa	ISO 527-1
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	18	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	7.5	kJ/m <sup>2</sup>	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	35	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	70	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise)	90	kJ/m <sup>2</sup>	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	119	°C	ISO 75-2/A
<b>Flammable</b>			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302
<b>Injection Parameters</b>			
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	