

## Technical Data Sheet

**Schulamid 6 GF30 U FR4 BLK968001**

Polyamide 6

**Product Description**

30% glass fibre reinforced flame-retardant halogenated UV stabilized Polyamide 6 grade

<b>Processing Method</b>	Injection Molding
<b>Attribute</b>	Good Strength; UV Stabilized
<b>Additive</b>	Flame Retardant
<b>Filler/Reinforcement</b>	Glass Fiber, 30%
<b>Resin ID</b>	PA6 GF30 FR(17)

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Density, (Method A)	1.60	g/cm <sup>3</sup>	ISO 1183
Viscosity Number	145	cm <sup>3</sup> /g	ISO 307
<b>Mechanical</b>			
Tensile Strain at Break, (Type 1A, 5 mm/min)	2.0	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	150	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	11000	MPa	ISO 527-1
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	10	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	6.0	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	65	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise)	58	kJ/m <sup>2</sup>	ISO 179
<b>Hardness</b>			
Ball Indentation Hardness, (H 358/30)	200	MPa	ISO 2039-1
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	216	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	202	°C	ISO 75-2/A
<b>Electrical</b>			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Comparative Tracking Index (CTI)	250	V	IEC 60112
Surface Resistivity	>1.0E+15	ohm	IEC 60093
<b>Flammable</b>			

Burning Rate			
(0.750 mm, Self-Extinguishing)	0.0	mm/min	ISO 3795
(1.50 mm, Self-Extinguishing)	0.0	mm/min	ISO 3795
(3.00 mm, Self-Extinguishing)	0.0	mm/min	ISO 3795
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)	825	°C	IEC 60695-2-13
(1.5 mm)	825	°C	IEC 60695-2-13
(3.0 mm)	825	°C	IEC 60695-2-13
UL Information			
Flame Rating			
(1.5 mm)	V-0		UL 94
(3.0 mm)	V-0		UL 94
(0.75 mm)	V-0		UL 94
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

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	%
Screw Speed	<250	mm/sec
Processing (Melt) Temp	240 to 270	°C
Injection Rate	Slow-Moderate	
Back Pressure	20 to 80	bar
Mold Temperature	60 to 100	°C