

Technical Data Sheet

Schulamid 6 GF35 HE NAT



Polyamide 6

Product Description

35% glass fiber reinforced PA 6, electrically neutral heat stabilized

| | |
|-----------------------------|-------------------|
| Processing Method | Injection Molding |
| Attribute | Heat Stabilized |
| Additive | Heat Stabilizer |
| Filler/Reinforcement | Glass Fiber, 35% |

| Typical Properties | Nominal Value | Units | Test Method |
|--|---------------|--------------------|----------------|
| Physical | | | |
| Density, (Method A) | 1.41 | g/cm ³ | ISO 1183 |
| Viscosity Number | 145 | cm ³ /g | ISO 307 |
| Mechanical | | | |
| Tensile Strain at Break | | | |
| (Type 1A, 5 mm/min) | 3.4 | % | ISO 527-2 |
| (Type 1A, 5 mm/min) - Conditioned | 6.0 | % | ISO 527-2 |
| Tensile Stress at Break | | | |
| (Type 1A, 5 mm/min) | 180 | MPa | ISO 527-2 |
| (Type 1A, 5 mm/min) - Conditioned | 110 | MPa | ISO 527-2 |
| Tensile Modulus | | | |
| (1 mm/min, Type 1A) | 11000 | MPa | ISO 527-1 |
| (1 mm/min, Type 1A) - Conditioned | 7000 | MPa | ISO 527-1 |
| Impact | | | |
| Charpy Impact Strength - Notched | | | |
| (23 °C, Type 1, Edgewise, Notch A) | 15 | kJ/m ² | ISO 179 |
| (-30 °C, Type 1, Edgewise, Notch A) | 10 | kJ/m ² | ISO 179 |
| (23 °C, Type 1, Edgewise, Notch A) - Conditioned | 32 | kJ/m ² | ISO 179 |
| Charpy Impact Strength - Unnotched | | | |
| (23 °C, Type 1, Edgewise) | 90 | kJ/m ² | ISO 179 |
| (-30 °C, Type 1, Edgewise) | 70 | kJ/m ² | ISO 179 |
| (23 °C, Type 1, Edgewise) - Conditioned | No Break | | ISO 179 |
| Hardness | | | |
| Ball Indentation Hardness, (H 358/30) | 230 | MPa | ISO 2039-1 |
| Ball Pressure Test, (150 °C) | Pass | | IEC 60695-10-2 |
| Thermal | | | |
| Vicat Softening Temperature, (B (50N), 50 °C/h) | 210 | °C | ISO 306 |

| | | | |
|---|---------------|--------|----------------------|
| Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise) | 215 | °C | ISO 75-2/B |
| Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise) | 210 | °C | ISO 75-2/A |
| Electrical | | | |
| Volume Resistivity | >1.0E+13 | ohm*m | IEC 62631-3-1 |
| - Conditioned | 10000000000 | ohm*m | IEC 62631-3-1 |
| Comparative Tracking Index (CTI) | 450 | V | IEC 60112 |
| Surface Resistivity | >1.0E+15 | ohm | IEC 60093 |
| - Conditioned | 1000000000000 | ohm | IEC 60093 |
| Flammable | | | |
| Burning Rate | | | |
| (2.00 mm) | <100 | mm/min | FMVSS 302 |
| (2.00 mm) | <100 | mm/min | ISO 3795 |
| Glow Wire Flammability Index | 650 | °C | IEC 60695-2-12 |
| UL Information | | | |
| Flammability Classification, (0.75 mm) | HB | | 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 | % |
| Processing (Melt) Temp | 250 to 280 | °C |
| Mold Temperature | 60 to 100 | °C |