Technical Data Sheet

Schulamid 6 GF35 LS ORE962535

Polyamide 6

Product Description

35% glass fiber reinforced Polyamide 6

Processing Method	Injection Molding
Attribute	Good Flow; High Stiffness; High Strength; Oil Resistant
Filler/Reinforcement	Glass Fiber, 35%
Resin ID	PA6-GF35

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.41	g/cm³	ISO 1183
Viscosity Number	145	cm³/g	ISO 307
Mechanical			
Tensile Strain at Break, (Type 1A, 5 mm/min)	3.4	%	ISO 527-2
Tensile Stress at Break, (Type 1A, 5 mm/min)	180	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	11000	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	15	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	10	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	90	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	70	kJ/m²	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)	220	°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
Comparative Tracking Index (CTI)	450	V	IEC 60112
Surface Resistivity	>1.0E+15	ohm	IEC 60093
Flammable			

Burning Rate			
(2.00 mm)	30	mm/min	ISO 3795
(2.00 mm)	30	mm/min	FMVSS 302
UL Information			
Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20
UL File Number	E86615		

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