Technical Data Sheet

Schulamid 6 MKF4520 H K2067 BLK968017

Polyamide 6

Product Description

45% glass fiber and mineral reinforced PA 6, heat stabilized, high strength, low warpage

Processing Method	Injection Molding
Attribute	Heat Stabilized; High Strength; Low Warpage
Additive	Heat Stabilizer
Filler/Reinforcement	Glass Fiber, 45%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.52	g/cm³	ISO 1183
Viscosity Number	145	cm³/g	ISO 307
Mechanical			
Flexural Strain at Flexural Strength	3	%	ISO 178
Tensile Strain at Break			
(Type 1A, 5 mm/min)	2.0	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	4.0	%	ISO 527-2
Flexural Modulus	9100	MPa	ISO 178
Tensile Stress at Break			
(Type 1A, 5 mm/min)	140	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	80.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	11000	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	5900	MPa	ISO 527-1
Flexural Stress	200	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	7.0	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	4.0	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	9.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	48	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	45	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	60	kJ/m²	ISO 179
Thermal			

Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	215	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	200	°C	ISO 75-2/A
Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302

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