Technical Data Sheet

Schulamid 6 MV HI K1884 NAT

Polyamide 6

Product Description
PA 6, impact modified

Processing Method	Injection Molding
Attribute	Impact Modified
Additive	Impact Modifier

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.08	g/cm³	ISO 1183
Mechanical			
Tensile Stress at Yield			
(Type 1A, 50 mm/min)	60.0	MPa	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	42.0	MPa	ISO 527-2
Tensile Strain at Yield			
(Type 1A, 50 mm/min)	5.0	%	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	20	%	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	2300	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	1000	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	13	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	7.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	175	°C	ISO 306
(A (10N), 120 °C/h)	210	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	160	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	65.0	°C	ISO 75-2/A
Electrical			

Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Comparative Tracking Index (CTI)	600	V	IEC 60112
Surface Resistivity	>1.0E+15	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

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 270	°C
Mold Temperature	60 to 90	°C