Technical Data Sheet

Schulamid 6 MV14 HI SI K2504 BLK968001

Polyamide 6

Product Description
PA 6, impact modified

Processing Method	Injection Molding
Attribute	Good Mold Release; Impact Modified
Additive	Impact Modifier

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.09	g/cm³	ISO 1183
Mechanical			
Tensile Stress at Yield			
(Type 1A, 23 °C, 50 mm/min)	61.9	MPa	ISO 527-2
(Type 1A, 23 °C, 50 mm/min) - Conditioned	37.3	MPa	ISO 527-2
Flexural Modulus			
(23 °C)	1710	MPa	ISO 178
(23 °C) - Conditioned	845	MPa	ISO 178
Tensile Strain at Yield			
(Type 1A, 23 °C, 50 mm/min)	4.2	%	ISO 527-2
(Type 1A, 23 °C, 50 mm/min) - Conditioned	22	%	ISO 527-2
Tensile Modulus			
(23 °C, 1 mm/min, Type 1A)	2460	MPa	ISO 527-1
(23 °C, 1 mm/min, Type 1A) - Conditioned	905	MPa	ISO 527-1
Flexural Stress			
(23 °C)	73.2	MPa	ISO 178
(23 °C) - Conditioned	29.9	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	13	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	10	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	16	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A) - Conditioned	9.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	80	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	60	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
(-30 °C, Type 1, Edgewise) - Conditioned	67	kJ/m²	ISO 179

Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	182	°C	ISO 306
(A (10N), 50 °C/h)	216	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	114	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	52.0	°C	ISO 75-2/A
Flammable			
Burning Rate			
(2.00 mm)	28	mm/min	FMVSS 302
(2.00 mm)	28	mm/min	ISO 3795

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