

## Technical Data Sheet

### *Schulamid* FP63E33BKBLK



Polyamide 6

#### Product Description

*Schulamid* FP63E33BKBLK is a Polyamide 6 Glass Fiber, 33% filled material and is typically used in Injection Molding applications.

**Processing Method** Injection Molding

**Forms** Pellets

**Filler/Reinforcement** Glass Fiber, 33%

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Density - Specific Gravity	1.38	g/cm <sup>3</sup>	ASTM D792
<b>Mechanical</b>			
Tensile Strength at Yield	186	MPa	ASTM D638
Tensile Strength at Break	152	MPa	ASTM D638
Flexural Modulus, (Tangent)	8270	MPa	ASTM D790
<b>Impact</b>			
Notched Izod Impact	96	J/m	ASTM D256
<b>Thermal</b>			
Deflection Temperature Under Load Unannealed (264 psi)	199	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	210	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	71 to 93	°C
Suggested Max Moisture	0.1	%
Processing (Melt) Temp	249 to 282	°C
Front Temperature	260 to 282	°C
Middle Temperature	260 to 282	°C
Rear Temperature	249 to 282	°C
Injection Rate	Moderate-Fast	
Back Pressure	<0.345	MPa
Mold Temperature	82 to 93	°C
Cushion	6.35 to 12.7	mm