Technical Data Sheet

Schulamid FP63E33FDNANAT

Polyamide 6

Product Description

Schulamid FP63E33FDNANAT 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
Physical			
Density - Specific Gravity	1.38	g/cm³	ASTM D792
Mechanical			
Tensile Strength at Yield	186	MPa	ASTM D638
Tensile Strength at Break	152	MPa	ASTM D638
Flexural Modulus, (Tangent)	8270	MPa	ASTM D790
Impact			
Notched Izod Impact	96	J/m	ASTM D256
Thermal			
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