

Technical Data Sheet

Schulamid 6 GF20 BLK968001

Polyamide 6

Product Description

20% glass fibre reinforced PA 6

Processing Method Injection Molding

Filler/Reinforcement Glass Fiber, 20%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.27	g/cm ³	ISO 1183
Viscosity Number	145	cm ³ /g	ISO 307
Mechanical			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	3.5	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	4.5	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 5 mm/min)	137	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	90.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	7500	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	5100	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	10	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	7.0	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	17	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	57	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise)	45	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	92	kJ/m ²	ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	210	°C	ISO 306
(A (10N), 120 °C/h)	215	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	210	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	200	°C	ISO 75-2/A
Electrical			

Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
- Conditioned	10000000000 0	ohm*m	IEC 62631-3-1
Surface Resistivity	>1.0E+15	ohm	IEC 60093

Flammable

Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302
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 280	°C
Mold Temperature	60 to 100	°C