

Technical Data Sheet

Schulamid 6 GF15 SHI K2384 NAT



Polyamide 6

Product Description

15% glass fibre reinforced PA 6, impact modified

Processing Method Injection Molding

Filler/Reinforcement Glass Fiber, 15%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.20	g/cm ³	ISO 1183
Mechanical			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	15	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	43	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 5 mm/min)	48.0	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	27.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	3150	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	1150	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	18	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	7.5	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	35	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	70	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise)	90	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
Thermal			
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	119	°C	ISO 75-2/A
Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302

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