

Technical Data Sheet

Schulamid FP63D13WRBKBLK



Polyamide 6

Product Description

13% Glass Reinforced, Wear Resistant Nylon 6

Processing Method Injection Molding

Attribute Impact Modified

Forms Pellets

Filler/Reinforcement Glass Fiber, 13%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.23	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Break	89.6	MPa	ASTM D638
Flexural Modulus, (Tangent)	4340	MPa	ASTM D790
Impact			
Notched Izod Impact	130	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	188	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	199	°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