

Technical Data Sheet

Schulamid FP64E33HBBKBLK



Polyamide 6

Product Description

33% REINFORCED NYLON, IMPACT MODIFIED

Processing Method Injection Molding

Attribute Impact Modified

Forms Pellets

Filler/Reinforcement Glass Fiber, 33%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.38	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Break	152	MPa	ASTM D638
Flexural Modulus, (Tangent)	8270	MPa	ASTM D790
Impact			
Notched Izod Impact	160	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