

Technical Data Sheet

Schulamid P63E0BKBLK SF

Polyamide 6

Product Description

Unfilled, Medium Impact, Nylon 6

Processing Method Injection Molding

Forms Pellets

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.14	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	74.5	MPa	ASTM D638
Flexural Modulus, (Tangent)	2830	MPa	ASTM D790
Impact			
Notched Izod Impact	80	J/m	ASTM D256

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	82	°C
Suggested Max Moisture	0.1	%
Processing (Melt) Temp	238 to 271	°C
Front Temperature	243 to 271	°C
Middle Temperature	243 to 271	°C
Rear Temperature	243 to 271	°C
Injection Rate	Moderate	
Back Pressure	<0.345	MPa
Mold Temperature	60 to 82	°C
Cushion	3.18 to 6.35	mm