

Technical Data Sheet

# SCHULAMID® 6 GF 15 HI K2073 BLACK 96.8001

Polyamide 6  
Engineering Plastics

## Product Description

15% glass fiber reinforced and impact modified Polyamide 6

## General

|                        |                                     |
|------------------------|-------------------------------------|
| Filler / Reinforcement | • Glass Fiber, 15% Filler by Weight |
| Processing Method      | • Injection Molding                 |
| Resin ID (ISO 1043)    | • PA 6 GF 15 HI                     |

| Physical         | Dry  | Conditioned | Unit  | Test Method |
|------------------|------|-------------|-------|-------------|
| Density          | 1.21 | --          | g/cm³ | ISO 1183/A  |
| Viscosity Number | 145  | --          | cm³/g | ISO 307     |

| Mechanical             | Dry              | Conditioned      | Unit         | Test Method    |
|------------------------|------------------|------------------|--------------|----------------|
| Tensile Modulus        | 783000<br>(5400) | 442000<br>(3050) | psi<br>(MPa) | ISO 527-2/1A/1 |
| Tensile Stress (Break) | 14200<br>(98.0)  | 8560<br>(59.0)   | psi<br>(MPa) | ISO 527-2/1A/5 |
| Tensile Strain (Break) | 3.7              | 14               | %            | ISO 527-2/1A/5 |

| Impact                           | Dry          | Conditioned | Unit                 | Test Method |
|----------------------------------|--------------|-------------|----------------------|-------------|
| Charpy Notched Impact Strength   |              |             |                      | ISO 179/1eA |
| -22°F (-30°C)                    | 2.0<br>(4.2) | --          | ft·lb/in²<br>(kJ/m²) |             |
| 73°F (23°C)                      | 4.3<br>(9.0) | 7.6<br>(16) | ft·lb/in²<br>(kJ/m²) |             |
| Charpy Unnotched Impact Strength |              |             |                      | ISO 179/1eU |
| -22°F (-30°C)                    | 22<br>(46)   | --          | ft·lb/in²<br>(kJ/m²) |             |
| 73°F (23°C)                      | 30<br>(62)   | 43<br>(90)  | ft·lb/in²<br>(kJ/m²) |             |

| Thermal                       | Dry          | Conditioned | Unit       | Test Method |
|-------------------------------|--------------|-------------|------------|-------------|
| Heat Deflection Temperature   |              |             |            |             |
| 66 psi (0.45 MPa), Unannealed | 410<br>(210) | --          | °F<br>(°C) | ISO 75-2/Bf |
| 264 psi (1.8 MPa), Unannealed | 374<br>(190) | --          | °F<br>(°C) | ISO 75-2/Af |
| Vicat Softening Temperature   |              |             |            |             |
| --                            | 419<br>(215) | --          | °F<br>(°C) | ISO 306/A50 |
| --                            | 401<br>(205) | --          | °F<br>(°C) | ISO 306/B50 |

| Flammability        | Dry              | Conditioned | Unit               | Test Method |
|---------------------|------------------|-------------|--------------------|-------------|
| Burning Rate        |                  |             |                    |             |
| 0.0787 in (2.00 mm) | < 3.9<br>(< 100) | --          | in/min<br>(mm/min) | ISO 3795    |
| 0.0787 in (2.00 mm) | < 3.9<br>(< 100) | --          | in/min<br>(mm/min) | FMVSS 302   |

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| Injection              | Dry (English)  | Dry (SI)       |
|------------------------|----------------|----------------|
| Drying Temperature     | 176 °F         | 80 °C          |
| Drying Time            | 3.0 to 4.0 hr  | 3.0 to 4.0 hr  |
| Suggested Max Moisture | 0.04 to 0.10 % | 0.04 to 0.10 % |
| Suggested Max Regrind  | 20 %           | 20 %           |
| Processing (Melt) Temp | 482 to 536 °F  | 250 to 280 °C  |
| Mold Temperature       | 140 to 212 °F  | 60 to 100 °C   |

## Notes

These are typical property values not to be construed as specification limits.