

Technical Data Sheet

Schulamid 6 GF 30 H LW

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

30 % glassfiber reinforced and heatstabilized PA 6 Compound, transparent for laserlight in laser welding applications

General

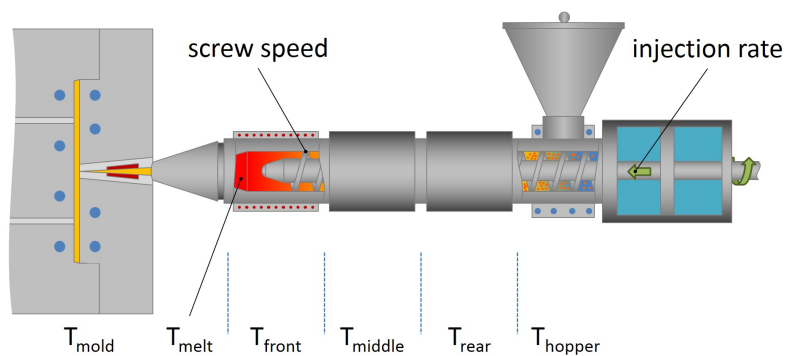
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA6-GF

Physical	Dry	Conditioned	Unit	Test Method
Density	1.35	--	g/cm ³	ISO 1183/A
Water Absorption				ISO 62
Equilibrium, 73°F (23°C), 50% Rh	2.0	--	%	
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.33E+6 (9200)	725000 (5000)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	24700 (170)	14500 (100)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.5	8.0	%	ISO 527-2/1A/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	3.8 (8.0)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	5.7 (12)	9.5 (20)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	26 (55)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	38 ft·lb/in ² (80 kJ/m ²)	No Break	(kJ/m ²)	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	428 (220)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	392 (200)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature	410 (210)	--	°F (°C)	ISO 306/B50
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 In (2.00 Mm)	1.2 (30)	--	in/min (mm/min)	ISO 3795
0.0787 In (2.00 Mm)	1.2 (30)	--	in/min (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 %
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.