

Technical Data Sheet

Schulamid 6 GF 30 HI FR 4

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

30% glass fibre reinforced and impact modified PA 6; flame retardant containing halogens without PBDE

General

Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Additive	• Impact Modifier
Features	• Flame Retardant • Halogenated • Impact Modified
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA6-I GF30 FR(17)

Physical	Dry	Conditioned	Unit	Test Method
Density	1.59	--	g/cm ³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.60E+6 (11000)	1.23E+6 (8500)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	21800 (150)	15100 (104)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	4.0	%	ISO 527-2/1A/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	4.0 (8.5)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	4.8 (10)	5.7 (12)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	26 (54)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	29 (60)	31 (65)	ft·lb/in ² (kJ/m ²)	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	421 (216)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	405 (207)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	397 (203)	--	°F (°C)	ISO 306/B50
--	412 (211)	--	°F (°C)	ISO 306/A120
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	> 1.0E+15	--	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	--	ohms·m	IEC 62631-3-1
Comparative Tracking Index	225	--	V	IEC 60112

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Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.03 In (0.8 Mm)	V-0	--		
0.06 In (1.6 Mm)	V-2	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.030 In (0.75 Mm)	1760 (960)	--	°F (°C)	
0.06 In (1.5 Mm)	1760 (960)	--	°F (°C)	
0.12 In (3.0 Mm)	1760 (960)	--	°F (°C)	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.030 In (0.75 Mm)	1470 (800)	--	°F (°C)	
0.06 In (1.5 Mm)	1470 (800)	--	°F (°C)	
0.12 In (3.0 Mm)	1470 (800)	--	°F (°C)	
Oxygen Index	34	--	%	ISO 4589-2

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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	464 to 518 °F	240 to 270 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Screw Speed	< 591 in/min	< 15 m/min

Injection Notes

Mould surfaces in contact with melt should be of non-corrosive steel, chrome content >12%

Notes

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