

Technical Data Sheet

SCHULAMID® 6 GF 15

Polyamide 6
Engineering Plastics

Product Description

15% glass fibre reinforced Polyamide 6

General

Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Features	• Good Flow	• Good Surface Finish	• Oil Resistant
Automotive Specifications	• FORD WSK-M4D665-A • GM GMW3029P-PA6-GF15 Color: Natural	• GM QK 002711 Color: 968001 Black • IMDS ID 4784303 Color: 968001 Black	
UL File Number	• E86615		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA6 GF15		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.23	--	g/cm ³	ISO 1183/A
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	841000 (5800)	435000 (3000)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	18900 (130)	10200 (70.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.5	15	%	ISO 527-2/1A/5
Flexural Modulus ¹	624000 (4300)	--	psi (MPa)	ISO 178
Flexural Stress ¹	24700 (170)	--	psi (MPa)	ISO 178
Flexural Strain at Flexural Strength	6.5	--	%	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	2.4 (5.0)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	3.3 (7.0)	7.1 (15)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	19 (40)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	21 ft·lb/in ² (45 kJ/m ²)	No Break	(kJ/m ²)	
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	25200 (174)	--	psi (MPa)	ISO 2039-1

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Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	410 (210)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	392 (200)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	419 (215)	--	°F (°C)	ISO 306/A50
--	410 (210)	--	°F (°C)	ISO 306/B50
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 in (2.00 mm)	1.7 (43)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	1.7 (43)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.030 in (0.75 mm)	HB	--		
0.06 in (1.5 mm)	HB	--		
0.12 in (3.0 mm)	HB	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.06 in (1.5 mm)	--	1200 (650)	°F (°C)	
0.12 in (3.0 mm)	--	1200 (650)	°F (°C)	

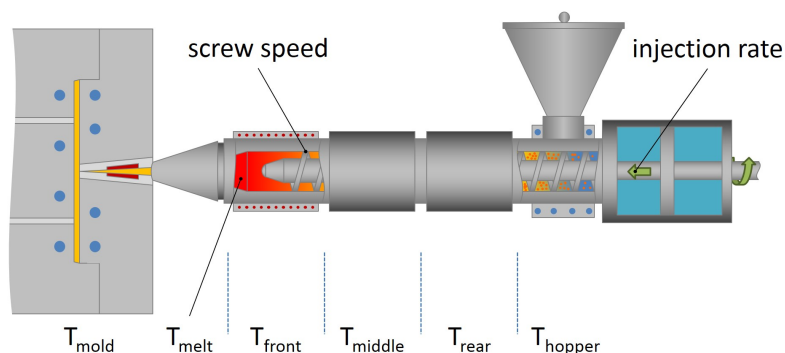
Additional Information

- 1.) Not for use in food contact applications
- 2.) Not for use in medical or pharmaceutical applications

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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

¹ 0.079 in/min (2.0 mm/min)

Notes

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