

Technical Data Sheet

SCHULAREC PA 6 GF 30

Polyamide 6

Product Description

30% glass fiber reinforced and recycled grade

General

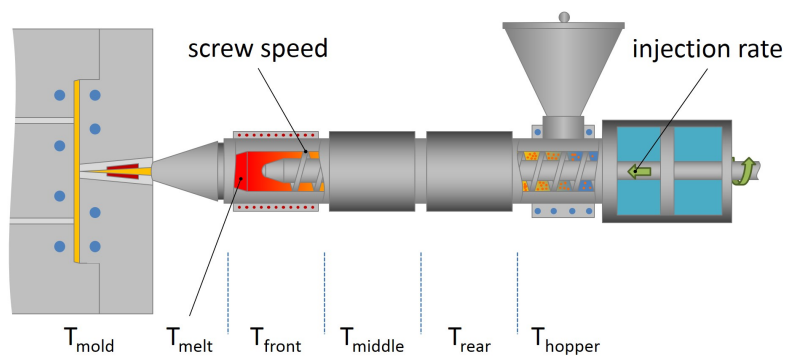
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Processing Method	• Injection Molding

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.34 to 1.38 g/cm³	1.34 to 1.38 g/cm³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	40 cm³/10min	40 cm³/10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	0.80 to 1.4 %	0.80 to 1.4 %	
Flow	0.30 to 0.60 %	0.30 to 0.60 %	
Water Absorption - (23°C, water)	6.0 to 8.0 %	6.0 to 8.0 %	ISO 62
Viscosity Number			ISO 307
96% H2SO4 (Sulphuric Acid)	125 to 145 cm³/g	125 to 145 cm³/g	
Humidity Absorption - (23°C, 50% R. H.)	1.5 to 2.5 %	1.5 to 2.5 %	ISO 62
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	1.10E+6 psi	7600 MPa	ISO 527-2/1A/1
Tensile Stress (Break)	18900 psi	130 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0 %	3.0 %	ISO 527-2/1A/5
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	2.6 ft·lb/in²	5.5 kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength 73°F (23°C)	23 ft·lb/in²	48 kJ/m²	ISO 179/1eU
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Melting Temperature ¹	428 °F	220 °C	ISO 11357-3
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flame Rating			ISO 1210
0.031 in (0.8 mm)	HB	HB	
0.06 in (1.6 mm)	HB	HB	
Additional Information	Nominal Value (English)	Nominal Value (SI)	
Residual Humidity	< 0.20 %	< 0.20 %	
1.) Not for use in food contact applications			
2.) Not for use in medical or pharmaceutical applications			

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Injection	Nominal Value (English)	Nominal Value (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 DSC

Notes

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