

Technical Data Sheet

Schulamid 6 MV HI K2513 NAT



Polyamide 6

Product Description

Impact modified polyamide 6 compound

Processing Method Extrusion; Injection Molding

Attribute Impact Modified

Resin ID PA6-I

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (260 °C/2.16 kg)	15	cm ³ /10 min	ISO 1133
Density, (Method A)	1.12	g/cm ³	ISO 1183
Viscosity Number	155	cm ³ /g	ISO 307
Mechanical			
Tensile Stress at Yield			
(Type 1A, 50 mm/min)	71.0	MPa	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	36.0	MPa	ISO 527-2
Flexural Modulus	2700	MPa	ISO 178
Tensile Strain at Yield			
(Type 1A, 50 mm/min)	5.0	%	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	24	%	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	2500	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	700	MPa	ISO 527-1
Flexural Stress	85	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	10	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	7.0	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	120	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	56	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302

Additional Information

Water Absorption 23C/50RH

2.8 %

ISO 62

Injection Parameters	Nominal	
	Value	Units
Drying Time	3.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	250 to 270	°C
Mold Temperature	60 to 90	°C