

## Technical Data Sheet

### Schulamid FP63E45GY235GRY



Polyamide 6

#### Product Description

Schulamid FP63E45GY235GRY is a Polyamide 6 Glass Fiber, 45% filled material and is typically used in Injection Molding applications.

**Processing Method** Injection Molding

**Forms** Pellets

**Filler/Reinforcement** Glass Fiber, 45%

| Typical Properties                                     | Nominal Value | Units             | Test Method |
|--------------------------------------------------------|---------------|-------------------|-------------|
| <b>Physical</b>                                        |               |                   |             |
| Density - Specific Gravity                             | 1.5           | g/cm <sup>3</sup> | ASTM D792   |
| <b>Mechanical</b>                                      |               |                   |             |
| Tensile Strength at Yield                              | 165           | MPa               | ASTM D638   |
| Flexural Modulus                                       | 11000         | MPa               | ASTM D790   |
| <b>Impact</b>                                          |               |                   |             |
| Notched Izod Impact                                    | 80            | J/m               | ASTM D256   |
| <b>Thermal</b>                                         |               |                   |             |
| Deflection Temperature Under Load Unannealed (264 psi) | 202           | °C                | ASTM D648   |
| Deflection Temperature Under Load Unannealed (66 psi)  | 210           | °C                | ASTM D648   |

| Injection Parameters   | Value         | Units |
|------------------------|---------------|-------|
| Drying Time            | 4.0 to 6.0    | hr    |
| Drying Temperature     | 71 to 93      | °C    |
| Suggested Max Moisture | 0.1           | %     |
| Processing (Melt) Temp | 249 to 282    | °C    |
| Front Temperature      | 249 to 282    | °C    |
| Middle Temperature     | 249 to 282    | °C    |
| Rear Temperature       | 249 to 271    | °C    |
| Injection Rate         | Moderate-Fast |       |
| Back Pressure          | <0.345        | MPa   |
| Mold Temperature       | 71 to 82      | °C    |
| Cushion                | 6.35 to 12.7  | mm    |