

Technical Data Sheet



Schulamid 6 GF 15 4DD

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

15% glass fibre reinforced flame-retardant Polyamide 6 grade; halogen free; very good surface appearance

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Features	• Flame Retardant	• Halogen Free	
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA6 GF15 FR(40)		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.38 g/cm ³	1.38 g/cm ³	ISO 1183/A
Viscosity Number	145 cm ³ /g	145 cm ³ /g	ISO 307
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	1.02E+6 psi	7000 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	13800 psi	95.0 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.8 %	2.8 %	ISO 527-2/1A/5
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F (-30°C)	2.4 ft·lb/in ²	5.0 kJ/m ²	
73°F (23°C)	3.6 ft·lb/in ²	7.5 kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	21 ft·lb/in ²	45 kJ/m ²	
73°F (23°C)	24 ft·lb/in ²	50 kJ/m ²	
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			
66 psi (0.45 MPa), Unannealed	423 °F	217 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	387 °F	197 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	414 °F	212 °C	ISO 306/B50
--	423 °F	217 °C	ISO 306/A50
Ball Pressure Test (257°F (125°C))	Pass	Pass	IEC 60695-10-2
Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Surface Resistivity	> 1.0E+15 ohms	> 1.0E+15 ohms	IEC 60093
Volume Resistivity	> 1.0E+13 ohms·m	> 1.0E+13 ohms·m	IEC 62631-3-1
Comparative Tracking Index	600 V	600 V	IEC 60112
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			ISO 3795
0.0315 in (0.800 mm), Self-Extinguishing	0.0 in/min	0.0 mm/min	
0.0591 in (1.50 mm), Self-Extinguishing	0.0 in/min	0.0 mm/min	
0.118 in (3.00 mm), Self-Extinguishing	0.0 in/min	0.0 mm/min	
Flammability Classification			IEC 60695-11-10, -20
0.03 in (0.8 mm)	V-0	V-0	
0.06 in (1.5 mm)	V-0	V-0	
0.12 in (3.0 mm)	V-0	V-0	

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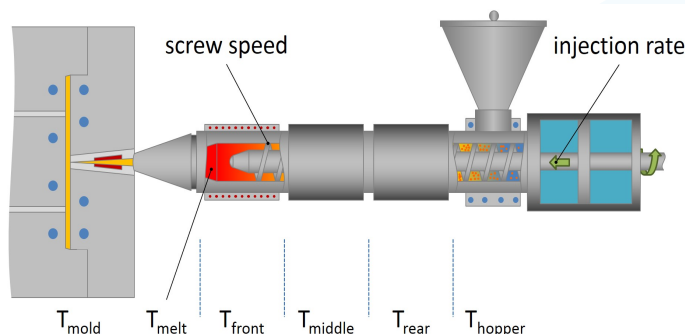
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Glow Wire Flammability Index			IEC 60695-2-12
0.030 in (0.75 mm)	1760 °F	960 °C	
0.06 in (1.5 mm)	1760 °F	960 °C	
0.12 in (3.0 mm)	1760 °F	960 °C	
Glow Wire Ignition Temperature			IEC 60695-2-13
0.030 in (0.75 mm)	1380 °F	750 °C	
0.06 in (1.5 mm)	1380 °F	750 °C	
0.12 in (3.0 mm)	1380 °F	750 °C	

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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 %
Hopper Temperature	158 °F	70 °C
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Injection Rate	Moderate	Moderate
Screw Speed	< 709 in/min	< 18 m/min

Notes

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

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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