

Technical Data Sheet



Schulamid 6 GF 65

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

65% glass fiber reinforced Polyamide 6 with very high tensile strength and stiffness

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 65% Filler by Weight		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PAM 6 GF65		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.77	--	g/cm ³	ISO 1183/A
Viscosity Number (H ₂ SO ₄ (Sulphuric Acid))	120	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3.34E+6 (23000)	2.06E+6 (14200)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	34100 (235)	21800 (150)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	1.8	2.4	%	ISO 527-2/1A/5
Flexural Modulus ¹	2.90E+6 (20000)	--	psi (MPa)	ISO 178
Flexural Stress ¹				ISO 178
2.6% Strain	52200 (360)	--	psi (MPa)	
2.7% Strain ²	50800 (350)	--	psi (MPa)	
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	6.2 (13)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	6.7 (14)	9.5 (20)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	37 (77)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	38 (80)	39 (82)	ft·lb/in ² (kJ/m ²)	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/Af
264 psi (1.8 MPa), Unannealed	419 (215)	--	°F (°C)	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	> 1.0E+15	> 1.0E+12	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	> 1.0E+10	ohms·m	IEC 62631-3-1

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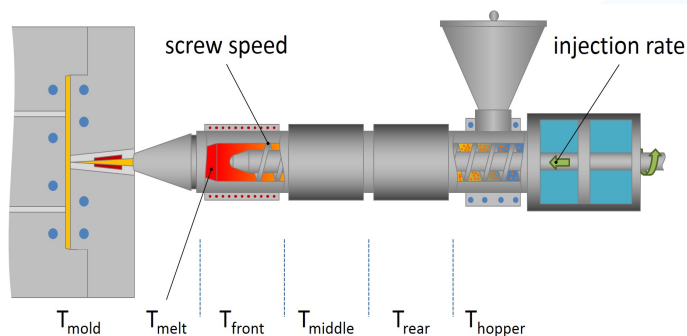
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 in (2.00 mm)	1.2 (30)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	1.2 (30)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	--		
0.12 in (3.0 mm)	HB	--		

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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 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C

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Notes

¹ 0.079 in/min (2.0 mm/min)

² at Break

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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