

Technical Data Sheet



Schulamid 6 GF20 FR2 K2346 GRY967685

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

20% glass fibre reinforced flame-retardant Polyamide 6 grade (V-0); halogen free

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA 6 GF 20 FR(40)		

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.34 g/cm ³	1.34 g/cm ³	ISO 1183/A
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	1.13E+6 psi	7800 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	16000 psi	110 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.7 %	2.7 %	ISO 527-2/1A/5
Flexural Modulus	1.00E+6 psi	6900 MPa	ISO 178
Flexural Stress	25400 psi	175 MPa	ISO 178
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)	4.8 ft·lb/in ²	10 kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F (-30°C)	19 ft·lb/in ²	40 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	480 °F	249 °C	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	381 °F	194 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	415 °F	213 °C	ISO 306/B50
--	424 °F	218 °C	ISO 306/A50
Electrical	Nominal Value (English)	Nominal Value (SI)	Test Method
Comparative Tracking Index	525 V	525 V	IEC 60112
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating			UL 94
0.06 in (1.6 mm)	V-0	V-0	IEC 60695-11-10, -20
0.13 in (3.2 mm)	V-0	V-0	
Glow Wire Flammability Index			IEC 60695-2-12
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
0.06 in (1.5 mm)	1250 °F	675 °C	
0.12 in (3.0 mm)	1250 °F	675 °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 %
Processing (Melt) Temp	464 to 500 °F	240 to 260 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Injection Pressure	11600 to 20300 psi	80.0 to 140 MPa
Injection Rate	Slow-Moderate	Slow-Moderate
Holding Pressure	5800 to 12300 psi	40.0 to 85.0 MPa
Back Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Screw Speed	< 591 in/min	< 15 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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