

Technical Data Sheet



Schulamid 6 MKF 4015

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

40% glass fiber and mineral reinforced Polyamide 6 with high tensile strain at break and high dimension stability

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber/Mineral, 40% Filler by Weight		
Features	• Balanced Stiffness/Toughness • Good Processability	• Low Warpage • Oil Resistant	
Processing Method	• Injection Molding		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.45	--	g/cm ³	ISO 1183/A
Water Absorption				ISO 62
Equilibrium, 73°F (23°C), 50% RH	1.9	--	%	
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.02E+6 (7000)	653000 (4500)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	16000 (110)	10200 (70.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	3.0	%	ISO 527-2/1A/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	2.4 (5.0)	3.8 (8.0)	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	3.8 (8.0)	6.2 (13)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	19 (40)	29 (60)	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	24 (50)	36 (75)	ft·lb/in ² (kJ/m ²)	
Hardness	Dry	Conditioned	Unit	Test Method
Ball Indentation Hardness (H 358/30)	29700 (205)	--	psi (MPa)	ISO 2039-1
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 psi (0.45 MPa), Unannealed	410 (210)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	356 (180)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	410 (210)	--	°F (°C)	ISO 306/B50
--	419 (215)	--	°F (°C)	ISO 306/A50

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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
Comparative Tracking Index	400	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 in (2.00 mm)	< 3.9 (< 100)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	< 3.9 (< 100)	--	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		
Glow Wire Flammability Index				IEC 60695-2-12
0.06 in (1.5 mm)	--	1200 (650)	°F (°C)	
0.12 in (3.0 mm)	--	1200 (650)	°F (°C)	

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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

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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