

Technical Data Sheet



Schulamid 6 MKF 4520 H

Polyamide 6
LyondellBasell Industries
Engineering Plastics

Product Description

45% glass fiber and mineral reinforced PA 6, heat stabilized, high strength, low warpage

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 45% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Heat Stabilized	• High Strength	• Low Warpage
Processing Method	• Injection Molding		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.52	--	g/cm ³	ISO 1183/A
Viscosity Number	145	--	cm ³ /g	ISO 307

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.60E+6 (11000)	856000 (5900)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	20300 (140)	11600 (80.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	4.0	%	ISO 527-2/1A/5
Flexural Modulus	1.32E+6 (9100)	--	psi (MPa)	ISO 178
Flexural Stress	29000 (200)	--	psi (MPa)	ISO 178
Flexural Strain at Flexural Strength	3.0	--	%	ISO 178

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	1.9 (4.0)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	3.3 (7.0)	4.3 (9.0)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	21 (45)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	23 (48)	29 (60)	ft·lb/in ² (kJ/m ²)	

Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 psi (0.45 MPa), Unannealed	419 (215)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	392 (200)	--	°F (°C)	ISO 75-2/Af

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

Technical Data Sheet



Schulamid 6 MKF 4520 H

Polyamide 6
LyondellBasell Industries
Engineering Plastics



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/>.

© LyondellBasell Industries Holdings, B.V. 2024

Disclaimer

Information in this document is accurate to the best of our knowledge at the date of publication. The document is designed to provide users general information for safe handling, use, processing, storage, transportation, disposal and release and does not constitute any warranty or quality specification, either express or implied, including any warranty of merchantability or fitness for any particular purpose. Users shall determine whether the product is suitable for their use and can be used safely and legally.

In addition to any prohibitions of use specifically noted in this document, LyondellBasell may further prohibit or restrict the sale of its products into certain applications. For further information, please contact a LyondellBasell representative.

Trademarks

The Trademark referenced within the product name is owned or used by the LyondellBasell family of companies.