

SCHULAMID® 6 CF 10

Polyamide 6
Engineering Plastics

Product Description

10% carbon fiber reinforced Polyamide 6, available with different kinds of Heat Stabilizations Systems

General

Filler / Reinforcement	• Carbon Fiber, 10% Filler by Weight
Processing Method	• Injection Molding

Physical	Dry	Conditioned	Unit	Test Method
Density	1.19	--	g/cm ³	ISO 1183/A
Molding Shrinkage				ISO 294-4
Across Flow	1.1	--	%	
Flow	0.40	--	%	
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.74E+6 (12000)	943000 (6500)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	25400 (175)	16700 (115)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	6.5	%	ISO 527-2/1A/5
Flexural Modulus ¹	1.45E+6 (10000)	--	psi (MPa)	ISO 178
Flexural Stress ¹				ISO 178
4.0% Strain	37700 (260)	--	psi (MPa)	
4.0% Strain ²	37000 (255)	--	psi (MPa)	
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)	3.1 (6.5)	7.6 (16)	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)	29 (60)	43 (90)	ft·lb/in ² (kJ/m ²)	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				ISO 75-2/Af
264 psi (1.8 MPa), Unannealed	392 (200)	--	°F (°C)	
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+2	--	ohms·m	IEC 62631-3-1





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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



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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 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	500 to 572 °F	260 to 300 °C
Mold Temperature	140 to 248 °F	60 to 120 °C

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.

