

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

Filler / Reinforcement	• Glass\Mineral, 40% Filler by Weight
Features	• Balanced Stiffness/Toughness • Low Warpage • Good Processability • 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.

