

# SCHULAMID® 6 GF 15 HI K2073 BLACK 96.8001

Polyamide 6  
Engineering Plastics

## Product Description

15% glass fiber reinforced and impact modified Polyamide 6

## General

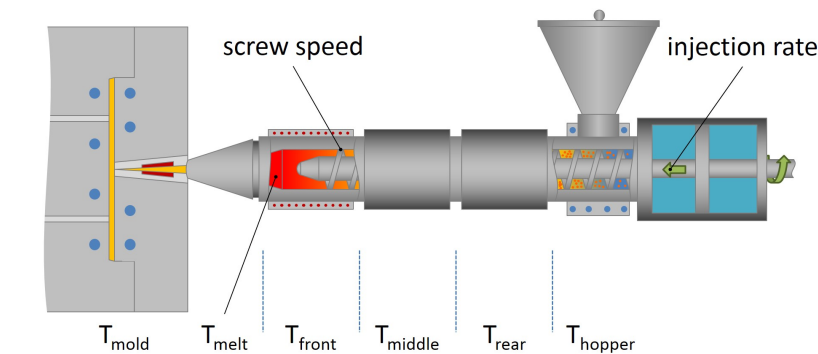
|                        |                                     |
|------------------------|-------------------------------------|
| Filler / Reinforcement | • Glass Fiber, 15% Filler by Weight |
| Processing Method      | • Injection Molding                 |
| Resin ID (ISO 1043)    | • PA 6 GF 15 HI                     |

| Physical                         | Dry              | Conditioned      | Unit                                          | Test Method    |
|----------------------------------|------------------|------------------|-----------------------------------------------|----------------|
| Density                          | 1.21             | --               | g/cm <sup>3</sup>                             | ISO 1183/A     |
| Viscosity Number                 | 145              | --               | cm <sup>3</sup> /g                            | ISO 307        |
| Mechanical                       | Dry              | Conditioned      | Unit                                          | Test Method    |
| Tensile Modulus                  | 783000<br>(5400) | 442000<br>(3050) | psi<br>(MPa)                                  | ISO 527-2/1A/1 |
| Tensile Stress (Break)           | 14200<br>(98.0)  | 8560<br>(59.0)   | psi<br>(MPa)                                  | ISO 527-2/1A/5 |
| Tensile Strain (Break)           | 3.7              | 14               | %                                             | ISO 527-2/1A/5 |
| Impact                           | Dry              | Conditioned      | Unit                                          | Test Method    |
| Charpy Notched Impact Strength   |                  |                  |                                               | ISO 179/1eA    |
| -22°F (-30°C)                    | 2.0<br>(4.2)     | --               | ft·lb/in <sup>2</sup><br>(kJ/m <sup>2</sup> ) |                |
| 73°F (23°C)                      | 4.3<br>(9.0)     | 7.6<br>(16)      | ft·lb/in <sup>2</sup><br>(kJ/m <sup>2</sup> ) |                |
| Charpy Unnotched Impact Strength |                  |                  |                                               | ISO 179/1eU    |
| -22°F (-30°C)                    | 22<br>(46)       | --               | ft·lb/in <sup>2</sup><br>(kJ/m <sup>2</sup> ) |                |
| 73°F (23°C)                      | 30<br>(62)       | 43<br>(90)       | ft·lb/in <sup>2</sup><br>(kJ/m <sup>2</sup> ) |                |
| Thermal                          | Dry              | Conditioned      | Unit                                          | Test Method    |
| Heat Deflection Temperature      |                  |                  |                                               |                |
| 66 psi (0.45 MPa), Unannealed    | 410<br>(210)     | --               | °F<br>(°C)                                    | ISO 75-2/Bf    |
| 264 psi (1.8 MPa), Unannealed    | 374<br>(190)     | --               | °F<br>(°C)                                    | ISO 75-2/Af    |
| Vicat Softening Temperature      |                  |                  |                                               |                |
| --                               | 419<br>(215)     | --               | °F<br>(°C)                                    | ISO 306/A50    |
| --                               | 401<br>(205)     | --               | °F<br>(°C)                                    | ISO 306/B50    |
| Flammability                     | Dry              | Conditioned      | Unit                                          | Test Method    |
| Burning Rate                     |                  |                  |                                               |                |
| 0.0787 in (2.00 mm)              | < 3.9<br>(< 100) | --               | in/min<br>(mm/min)                            | ISO 3795       |
| 0.0787 in (2.00 mm)              | < 3.9<br>(< 100) | --               | in/min<br>(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 | 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.

