

SCHULAMID® 6 GF 30 TC BLACK

Polyamide 6
A. Schulman Europe

Message:
30% glass fiber reinforced compound based on Polyamide 6

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 30% filler by weight		
Features		Good dimensional stability		
		Low density		
		Low hygroscopicity		
		Gloss, low		
		Noise reduction		
		Workability, good		
		Good liquidity		
		Hydrolysis resistance		
		Oil resistance		
Processing Method		Injection molding		
Resin ID (ISO 1043)		PA6-I-GF30		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.25	--	g/cm ³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	8700	6700	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	130	95.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	4.5	%	ISO 527-2/1A/5
Flexural Modulus	7000	--	MPa	ISO 178
Flexural Stress (3.3% strain)	180	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	10	--	kJ/m ²	ISO 179/1eA
23°C	15	17	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	46	--	kJ/m ²	ISO 179/1eU
23°C	56	60	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	215	--	°C	ISO 75-2/Bf

1.8 MPa, not annealed	190	--	°C	ISO 75-2/Af
Vicat Softening Temperature				
--	220	--	°C	ISO 306/A50
--	175	--	°C	ISO 306/B50
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	12	--	mm/min	ISO 3795
Flammability Classification				IEC 60695-11-10, -20
1.50 mm	HB	--		IEC 60695-11-10, -20
3.00 mm	HB	--		IEC 60695-11-10, -20
Additional Information				

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1.)

Not for use in food contact applications2.)

Not for use in medical or pharmaceutical applicationsCharacteristic propertiesAs a semi-crystalline thermoplastic SCHULAMID® 6 possesses high rigidity,hardness and good cold impact resistance.

Injection	Dry	Unit	
Drying Temperature	80.0		°C
Drying Time	3.0 - 4.0		hr
Suggested Max Moisture	0.040 - 0.10		%
Suggested Max Regrind	10		%
Hopper Temperature	70.0		°C
Rear Temperature	230		°C
Middle Temperature	240		°C
Front Temperature	250		°C
Nozzle Temperature	260		°C
Processing (Melt) Temp	240 - 270		°C
Mold Temperature	60.0 - 90.0		°C
Injection Pressure	100 - 180		MPa
Injection Rate	Fast		
Holding Pressure	50.0 - 110		MPa
Back Pressure	2.00 - 8.00		MPa
Cushion	2.00 - 5.00		mm
Vent Depth	0.020		mm
Screw Speed			mm/sec

Injection instructions

PredryingTypically a minimum predrying time of 3 to 4 hours at 80°C is recommended inan dehumidifying dryer. For optimal qualities a humidity of 0,04 - 0,1 % isrecommended.. Drying over 6 hours duration should occur at 60°C.ReprocessingUp to 10% regind may be used without change of property profile. Use onlydried regrind.Shut downPA 6 can normally be left in the cyclinder. If in doubt purge with polyolefin.FinishingThe material is suitable for machining. Varnishing, printing, gluing andembossing can be carried out using commercially available products.ConditioningRecently processed moulding parts possess improved brittleness. The materialpicks up moisture until the equilibrium moisture content is reached regardingthe surrounding atmosphere. This may last for over a half year. Then the articlehas reached his balanced property profile. For accelerated absoption see ourseparate Technical instruction.

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