

SCHULAMID® 6 GF 30 FR 2 BLACK HL3

Polyamide 6

A. Schulman Europe

Message:

30% glass fibre reinforced flame-retardant Polyamide 6 grade; halogen free

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 30% filler by weight		
Features		Halogen-free		
		Flame retardancy		
UL File Number		E86615		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.44	--	g/cm ³	ISO 1183/A
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	10800	7500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	160	105	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	5.0	%	ISO 527-2/1A/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	8.0	--	kJ/m ²	ISO 179/1eA
23°C	10	15	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	56	--	kJ/m ²	ISO 179/1eU
23°C	70	75	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	220	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	209	--	°C	ISO 75-2/Af
Vicat Softening Temperature				
--	216	--	°C	ISO 306/A50
--	212	--	°C	ISO 306/B50
Ball Pressure Test (200°C)	Pass	--		IEC 60695-10-2
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	475	--	V	IEC 60112

Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				ISO 3795
0.750mm, automatic fire extinguishing	0.0	--	mm/min	ISO 3795
1.50mm, automatic fire extinguishing	0.0	--	mm/min	ISO 3795
3.00mm, automatic fire extinguishing	0.0	--	mm/min	ISO 3795
Flammability Classification				IEC 60695-11-10, -20
0.75 mm	V-0	--		IEC 60695-11-10, -20
1.5 mm	V-0	--		IEC 60695-11-10, -20
3.0 mm	V-0	--		IEC 60695-11-10, -20
Glow Wire Flammability Index				IEC 60695-2-12
0.75 mm	960	--	°C	IEC 60695-2-12
1.5 mm	960	--	°C	IEC 60695-2-12
3.0 mm	960	--	°C	IEC 60695-2-12
Glow Wire Ignition Temperature				IEC 60695-2-13
0.75 mm	750	--	°C	IEC 60695-2-13
1.5 mm	750	--	°C	IEC 60695-2-13
3.0 mm	750	--	°C	IEC 60695-2-13
Oxygen Index	35	--	%	ISO 4589-2
Smoke Toxicity	0.540	--		NF X70-100
Smoke Density				ISO 5659-2
1.00 mm	280	--		ISO 5659-2
1.60 cm	100	--		ISO 5659-2
Screw Speed			mm/sec	
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0 - 4.0		hr	
Suggested Max Moisture	0.040 - 0.10		%	
Hopper Temperature	70		°C	
Rear Temperature	240		°C	
Middle Temperature	255		°C	
Front Temperature	270		°C	
Mold Temperature	60 - 100		°C	
Injection Pressure	80.0 - 140		MPa	
Injection Rate	Moderate			
Holding Pressure	40.0 - 85.0		MPa	
Back Pressure	2.00 - 8.00		MPa	

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