

Technical Data Sheet

Schulamid 6 GF20 FR2 K2346 GRY 967685



Polyamide 6

Product Description

20% glass fibre reinforced flame-retardant Polyamide 6 grade (V-0); halogen free

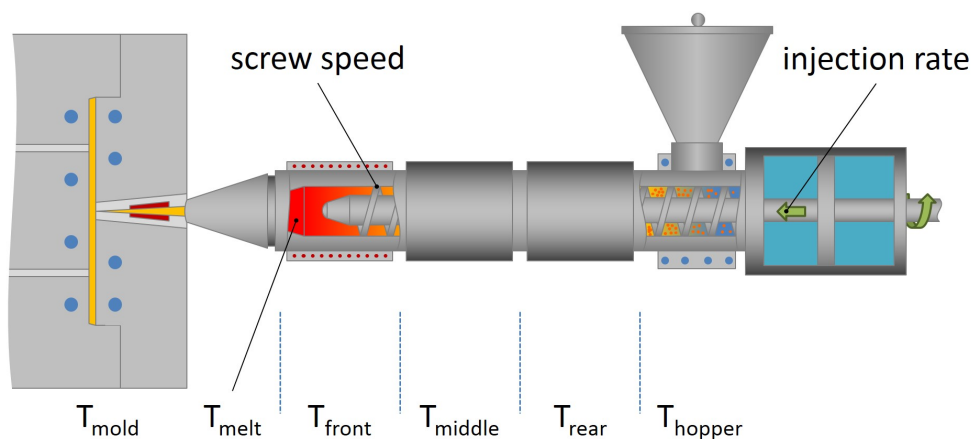
Regulatory Status

For regulatory compliance information, see *Schulamid* 6 GF20 FR2 K2346 GRY 967685 [Product Stewardship Bulletin \(PSB\)](#) and [Safety Data Sheet \(SDS\)](#).

Status	Commercial: Active
Availability	Africa-Middle East; Asia-Pacific; Europe; Latin America; North America
Processing Method	Injection Molding
Attribute	PFAS free
Filler/Reinforcement	Glass Fiber, 20%
Resin ID	PA 6 GF 20 FR(40)

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.34	g/cm ³	ISO 1183
Mechanical			
Tensile Strain at Break, (Type 1A, 5 mm/min)	2.7	%	ISO 527-2
Flexural Modulus	6900	MPa	ISO 178
Tensile Stress at Break, (Type 1A, 5 mm/min)	110	MPa	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	7800	MPa	ISO 527-1
Flexural Stress	175	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	10	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	5.0	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	50	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise)	40	kJ/m ²	ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	213	°C	ISO 306
(A (10N), 50 °C/h)	218	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	249	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	194	°C	ISO 75-2/A
Electrical			
Comparative Tracking Index (CTI)	525	V	IEC 60112
Flammable			

Glow Wire Flammability Index			
(1.5 mm)	960	°C	IEC 60695-2-12
(3.0 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(1.5 mm)	675	°C	IEC 60695-2-13
(3.0 mm)	675	°C	IEC 60695-2-13
UL Information			
Flame Rating			
(1.6 mm)	V-0		UL 94
(3.2 mm)	V-0		UL 94
Flammability Classification			
(1.6 mm)	V-0		IEC 60695-11-10, -20
(3.2 mm)	V-0		IEC 60695-11-10, -20



Injection Parameters	Nominal Value	Units
Drying Time	3.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Screw Speed	<250	mm/sec
Processing (Melt) Temp	240 to 260	°C
Holding Pressure	40.0 to 85.0	MPa
Injection Rate	Slow-Moderate	
Back Pressure	20 to 80	bar
Mold Temperature	60 to 100	°C
Injection Pressure	80.0 to 140	MPa

Notes

These are typical property values not to be construed as specification limits.

Processing notes

Melt contacting surfaces should be made of a high quality, corrosive resistant steel. Positive experiences have been made with steel qualities containing > 12% chromium.

Avoid processing at very barrel high temperatures or above the recommended melt temperature range as this can increase risk of deposit onto the tool surfaces. Avoid long residence times. At start and end of production, it is recommended to purge clean with non-flame retardant polymer or a polyolefin.

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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