

Technical Data Sheet

**Schulamid 6 MV14 HI SI K2504 BLK968001**



Polyamide 6

**Product Description**

PA 6, impact modified

**Processing Method** Injection Molding

**Attribute** Good Mold Release; Impact Modified

**Additive** Impact Modifier

Typical Properties	Nominal Value	Units	Test Method
<b>Physical</b>			
Density, (Method A)	1.09	g/cm <sup>3</sup>	ISO 1183
<b>Mechanical</b>			
Tensile Stress at Yield			
(Type 1A, 23 °C, 50 mm/min)	61.9	MPa	ISO 527-2
(Type 1A, 23 °C, 50 mm/min) - Conditioned	37.3	MPa	ISO 527-2
Flexural Modulus			
(23 °C)	1710	MPa	ISO 178
(23 °C) - Conditioned	845	MPa	ISO 178
Tensile Strain at Yield			
(Type 1A, 23 °C, 50 mm/min)	4.2	%	ISO 527-2
(Type 1A, 23 °C, 50 mm/min) - Conditioned	22	%	ISO 527-2
Tensile Modulus			
(23 °C, 1 mm/min, Type 1A)	2460	MPa	ISO 527-1
(23 °C, 1 mm/min, Type 1A) - Conditioned	905	MPa	ISO 527-1
Flexural Stress			
(23 °C)	73.2	MPa	ISO 178
(23 °C) - Conditioned	29.9	MPa	ISO 178
<b>Impact</b>			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	13	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	10	kJ/m <sup>2</sup>	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	16	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise, Notch A) - Conditioned	9.0	kJ/m <sup>2</sup>	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	80	kJ/m <sup>2</sup>	ISO 179
(-30 °C, Type 1, Edgewise)	60	kJ/m <sup>2</sup>	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
(-30 °C, Type 1, Edgewise) - Conditioned	67	kJ/m <sup>2</sup>	ISO 179

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**Thermal**

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## Vicat Softening Temperature

(B (50N), 50 °C/h)	182 °C	ISO 306
(A (10N), 50 °C/h)	216 °C	ISO 306

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Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	114 °C	ISO 75-2/B
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Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	52.0 °C	ISO 75-2/A
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**Flammable**

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## Burning Rate

(2.00 mm)	28 mm/min	FMVSS 302
(2.00 mm)	28 mm/min	ISO 3795

**Injection Parameters****Nominal Value Units**

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Drying Time	3.0 to 4.0	hr
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Drying Temperature	80	°C
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Suggested Max Moisture	0.040 to 0.10	%
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Processing (Melt) Temp	250 to 270	°C
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Mold Temperature	60 to 90	°C
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