

SCHULAMID® 6 HV 2 FR

Polyamide 6
A. Schulman Europe

Message:
High viscosity flame-retardant Polyamide 6 grade; halogen and phosphorus-free

General Information				
UL YellowCard		E86615-252165		
Features		Phosphorus content, low (to none)		
		Halogen-free		
		Viscosity, High		
		Flame retardancy		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183/A
Viscosity Number	195	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3100	--	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	80.0	--	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	--	%	ISO 527-2/1A/50
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	7.0	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	No Break	--		ISO 179/1eU
23°C	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	188	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	63.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature				
--	220	--	°C	ISO 306/A50
--	206	--	°C	ISO 306/B50
Ball Pressure Test (200°C)	Pass	--		IEC 60695-10-2
RTI Elec				UL 746
0.750 mm	65.0	--	°C	UL 746
1.50 mm	65.0	--	°C	UL 746

3.00 mm	65.0	--	°C	UL 746
RTI Imp				UL 746
0.750 mm	65.0	--	°C	UL 746
1.50 mm	65.0	--	°C	UL 746
3.00 mm	65.0	--	°C	UL 746
RTI				UL 746
0.750 mm	65.0	--	°C	UL 746
1.50 mm	65.0	--	°C	UL 746
3.00 mm	65.0	--	°C	UL 746
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	> 1.0E+15	> 1.0E+12	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	> 1.0E+10	ohms·cm	IEC 60093
Comparative Tracking Index	600	--	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
Flame Rating				UL 94, IEC 60695-11-10, -20
0.750 mm	V-2	--		UL 94, IEC 60695-11-10, -20
1.50 mm	V-2	--		UL 94, IEC 60695-11-10, -20
3.00 mm	V-2	--		UL 94, IEC 60695-11-10, -20
Glow Wire Flammability Index				IEC 60695-2-12
0.750 mm	960	--	°C	IEC 60695-2-12
1.50 mm	960	--	°C	IEC 60695-2-12
3.00 mm	960	--	°C	IEC 60695-2-12
Glow Wire Ignition Temperature				IEC 60695-2-13
0.750 mm	700	--	°C	IEC 60695-2-13
1.50 mm	700	--	°C	IEC 60695-2-13
3.00 mm	700	--	°C	IEC 60695-2-13
Oxygen Index	34	--	%	ISO 4589-2
Additional Information				
干燥				
1.)				
Not for use in food contact applications2.)				
Not for use in medical or pharmaceutical applications				

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.040 - 0.10	%
Hopper Temperature	70.0	°C
Rear Temperature	230	°C
Middle Temperature	245	°C
Front Temperature	260	°C
Processing (Melt) Temp	< 260	°C
Mold Temperature	60.0 - 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
Screw Speed	250	mm/sec
Injection instructions		

During transport one component of the dryblend can go more to the bottom. It is therefore recommended to tumble the material before use to assure an even distribution of the dryblend components.

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