

SCHULAMID[®] 6 MKF 3010 H

Polyamide 6
Engineering Plastics

Product Description

30% glass fiber and mineral reinforced Polyamide 6; heat stabilized

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass\Mineral, 30% Filler by Weight		
Features	• Good Surface Finish • Heat Aging Resistant	• Low Warpage • Oil Resistant	
Processing Method	• Injection Molding		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.35	--	g/cm ³	ISO 1183/A
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	870000 (6000)	653000 (4500)	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	14500 (100)	8700 (60.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.5	5.0	%	ISO 527-2/1A/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	1.9 (4.0)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	2.9 (6.0)	4.8 (10)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	17 (35)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	19 (40)	28 (58)	ft·lb/in ² (kJ/m ²)	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	410 (210)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	347 (175)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	428 (220)	--	°F (°C)	ISO 306/A50
--	419 (215)	--	°F (°C)	ISO 306/B50



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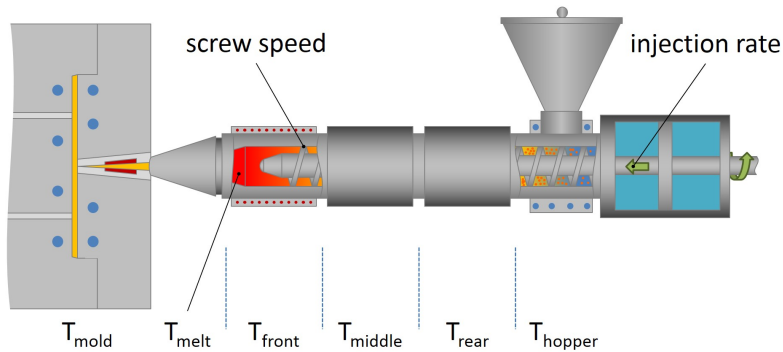
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Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	< 3.9 (< 100)	--	in/min (mm/min)	ISO 3795
Flammability Classification				IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	--		
0.12 in (3.0 mm)	HB	--		



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Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	482 to 536 °F	250 to 280 °C
Mold Temperature	140 to 212 °F	60 to 100 °C