Technical Data Sheet

Schulamid 66 GF 25 H LW

Polyamide 66
LyondellBasell Industries
Engineering Plastics

Product Description		
25% glass fiber reinforced PA 66, heat stabilized, laser transparent for laser welding		
General		
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight	
Additive	• Heat Stabilizer	
Features	• Heat Stabilized	• Laser Weldable
Processing Method	• Injection Molding	

Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm³	ISO 1183/A
Viscosity Number	145	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	1.23E+6 (8500)	870000 (6000)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	24700 (170)	17400 (120)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	6.0	%	ISO 527-2/1A/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°f (-30°c)	3.3 (7.0)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	4.3 (9.0)	5.7 (12)	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°f (-30°c)	27 (56)	--	ft·lb/in² (kJ/m²)	
73°f (23°c)	29 (60)	43 (90)	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	> 482 (> 250)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	468 (242)	--	°F (°C)	ISO 75-2/Af
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Burning Rate				
0.0787 In (2.00 Mm)	1.2 (30)	--	in/min (mm/min)	ISO 3795
0.0787 In (2.00 Mm)	1.2 (30)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.030 In (0.75 Mm)	HB	--		

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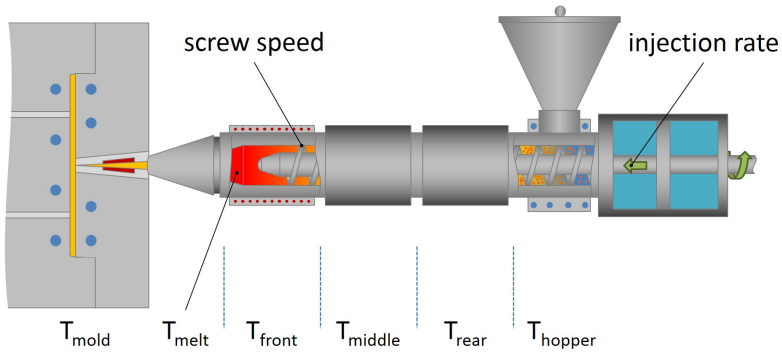

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	536 to 572 °F	280 to 300 °C
Mold Temperature	140 to 248 °F	60 to 120 °C

Notes

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