

Technical Data Sheet

Schulamid 66 GF 25 HE LW BLACK 96.8069

Polyamide 66
LyondellBasell Industries
Engineering Plastics

Product Description

25% glass fiber reinforced and heat stabilized polyamide 66-compound, electrical neutral, laser transparent for laser welding processes

General

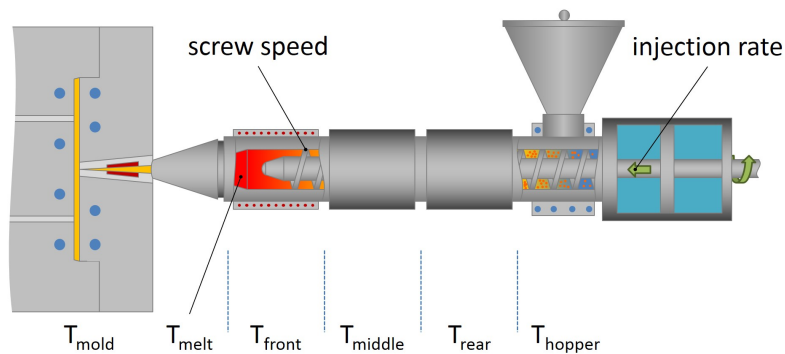
| | |
|------------------------|-------------------------------------|
| Filler / Reinforcement | • Glass Fiber, 25% Filler by Weight |
| Additive | • Heat Stabilizer |
| Features | • Heat Stabilized • Laser Weldable |
| Processing Method | • Injection Molding |

| Physical | Dry | Conditioned | Unit | Test Method |
|-----------------------------------|-------------------|------------------|---|-------------------------|
| Density | 1.32 | -- | g/cm ³ | ISO 1183/A |
| Viscosity Number | 145 | -- | cm ³ /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/in ² (kJ/m ²) | |
| 73°F (23°C) | 4.3 (9.0) | 5.7 (12) | ft·lb/in ² (kJ/m ²) | |
| Charpy Unnotched Impact Strength | | | | ISO 179/1eU |
| -22°F (-30°C) | 27 (56) | -- | ft·lb/in ² (kJ/m ²) | |
| 73°F (23°C) | 29 (60) | 43 (90) | ft·lb/in ² (kJ/m ²) | |
| 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.