Technical Data Sheet

Schulamid 66 GF 30 FR 2 K2322

Polyamide 66
LyondellBasell Industries
Engineering Plastics

Product Description		
30% glass fiber reinforced flame-retardant Polyamide 66 grade; halogen free		
General		
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Features	• Flame Retardant	• Halogen Free
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA66 GF30 FR(40)	

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.43 g/cm³	1.43 g/cm³	ISO 1183/A
Viscosity Number	145 cm³/g	145 cm³/g	ISO 307
Mechanical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Tensile Modulus	1.60E+6 psi	11000 MPa	ISO 527-1/1A/1
Tensile Stress (Break)	22500 psi	155 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.5 %	2.5 %	ISO 527-2/1A/5
Impact	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°f (-30°c)	4.3 ft·lb/in²	9.0 kJ/m²	
73°f (23°c)	4.3 ft·lb/in²	9.0 kJ/m²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°f (-30°c)	26 ft·lb/in²	55 kJ/m²	
73°f (23°c)	31 ft·lb/in²	65 kJ/m²	
Thermal	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Deflection Temperature Under Load			
66 Psi (0.45 Mpa), Unannealed	493 °F	256 °C	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	468 °F	242 °C	ISO 75-2/Af
Vicat Softening Temperature			
--	444 °F	229 °C	ISO 306/B50
--	491 °F	255 °C	ISO 306/A50
Ball Pressure Test (392°f (200°c))	Pass	Pass	IEC 60695-10-2
Electrical	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Comparative Tracking Index	500 V	500 V	IEC 60112
Flammability	**Nominal Value (English)**	**Nominal Value (SI)**	**Test Method**
Burning Rate			ISO 3795
0.0295 In (0.750 Mm), Self-extinguishing	0.0 in/min	0.0 mm/min	
0.0591 In (1.50 Mm), Self-extinguishing	0.0 in/min	0.0 mm/min	
0.118 In (3.00 Mm), Self-extinguishing	0.0 in/min	0.0 mm/min	
Flammability Classification			IEC 60695-11-10, -20
0.08 In (2.0 Mm)	V-0	V-0	
0.12 In (3.0 Mm)	V-0	V-0	
Glow Wire Flammability Index			IEC 60695-2-12
0.030 In (0.75 Mm)	1760 °F	960 °C	
0.06 In (1.5 Mm)	1760 °F	960 °C	
0.12 In (3.0 Mm)	1760 °F	960 °C	

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Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Glow Wire Ignition Temperature			IEC 60695-2-13
0.030 In (0.75 Mm)	1380 °F	750 °C	
0.06 In (1.5 Mm)	1380 °F	750 °C	
0.12 In (3.0 Mm)	1380 °F	750 °C	

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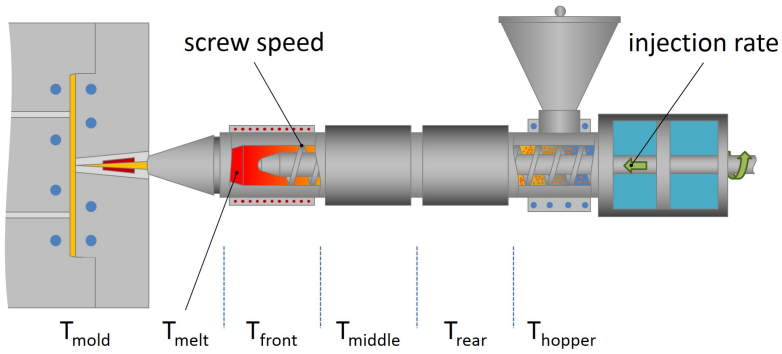

Injection	Nominal Value (English)	Nominal Value (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	518 to 572 °F	270 to 300 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Screw Speed	< 591 in/min	< 15 m/min

Notes

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