Technical Data Sheet

SCHULAMID® 66 GF 30 FR 4

Polyamide 66
Engineering Plastics

Product Description
30% glass fibre reinforced PA 66 with halogenous flame retardant agent; without PBDE

General		
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Features	• Flame Retardant	• Halogenated
Processing Method	• Injection Molding	
Part Marking Code (ISO 11469)	• >PA66-GF FR()<	
Resin ID (ISO 1043)	• PA66 GF30 FR(17)	

Physical	Dry	Conditioned	Unit	Test Method
Density	1.60	--	g/cm³	ISO 1183/A
Viscosity Number	145	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	1.60E+6 (11000)	--	psi (MPa)	ISO 527-2/1A/1
Tensile Stress (Break)	24700 (170)	--	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.2	--	%	ISO 527-2/1A/5
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	4.3 (9.0)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	4.8 (10)	--	ft·lb/in² (kJ/m²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	26 (55)	--	ft·lb/in² (kJ/m²)	
73°F (23°C)	31 (65)	--	ft·lb/in² (kJ/m²)	
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	482 (250)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	473 (245)	--	°F (°C)	ISO 75-2/Af
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·m	IEC 62631-3-1
Comparative Tracking Index	150	--	V	IEC 60112

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Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.030 in (0.75 mm)	V-0	--		
0.06 in (1.5 mm)	V-0	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.08 in (2.0 mm)	1760 (960)	--	°F (°C)	
Oxygen Index	37	--	%	ISO 4589-2

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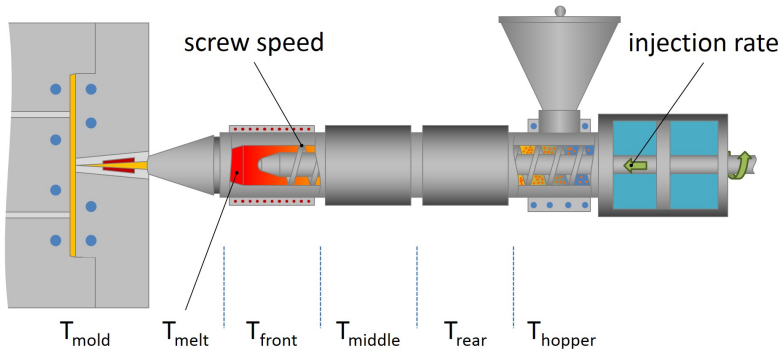

Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	25 %	25 %
Processing (Melt) Temp	518 to 554 °F	270 to 290 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Injection Rate	Slow-Moderate	Slow-Moderate
Back Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Screw Speed	< 591 in/min	< 15 m/min
Injection Notes		
Mould surfaces in contact with melt should be of non-corrosive steel, chrome content >12%		

Notes

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