

Technical Data Sheet

SCHULAREC PA 66 GF 25 HI H

Polyamide 66

Product Description
25% glass fiber reinforced, impact modified and heat stabilized, recycled grade

General	
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Additive	• Heat Stabilizer
Features	• Impact Modified
Processing Method	• Extrusion

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.30 g/cm ³	1.30 g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR)	40 cm ³ /10min	40 cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	0.90 to 1.1 %	0.90 to 1.1 %	
Flow	0.40 %	0.40 %	
Water Absorption - (23°C, water)	5.5 %	5.5 %	GE
Viscosity Number			ISO 307
96% H2SO4 (Sulphuric Acid)	155 cm ³ /g	155 cm ³ /g	
Humidity Absorption - (23°C, 50% R. H.)	1.5 %	1.5 %	ISO 62

Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Modulus	986000 psi	6800 MPa	ISO 527-2/1A/1
Tensile Stress (Break)	20300 psi	140 MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.5 %	3.5 %	ISO 527-2/1A/5

Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	4.8 ft·lb/in ²	10 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength 73°F (23°C)	36 ft·lb/in ²	75 kJ/m ²	ISO 179/1eU

Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Heat Deflection Temperature			
66 psi (0.45 MPa), Unannealed	482 °F	250 °C	ISO 75-2/B
264 psi (1.8 MPa), Unannealed	455 °F	235 °C	ISO 75-2/A
Vicat Softening Temperature	473 °F	245 °C	ISO 306
Melting Temperature ¹	500 °F	260 °C	ISO 11357-3

Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Burning Rate			
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	ISO 3795
0.0787 in (2.00 mm)	< 3.9 in/min	< 100 mm/min	FMVSS 302
Flame Rating			ISO 1210
0.031 in (0.8 mm)	HB	HB	
0.06 in (1.6 mm)	HB	HB	

Additional Information	Nominal Value (English)	Nominal Value (SI)
Residual Humidity	< 0.20 %	< 0.20 %
1.) Not for use in food contact applications		
2.) Not for use in medical or pharmaceutical applications		

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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 %
Suggested Max Regrind	20 %	20 %
Processing (Melt) Temp	536 to 572 °F	280 to 300 °C
Mold Temperature	140 to 248 °F	60 to 120 °C

Notes

¹ DSC

Notes

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