Technical Data Sheet

Schulamid 66 GF 15 HI NAT

Polyamide 66

Product Description

15% glass fibre reinforced PA 66, impact modified

Processing Method	Injection Molding
Attribute	Impact Modified
Filler/Reinforcement	Glass Fiber, 15%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.20	g/cm³	ISO 1183
Mechanical			
Flexural Strain at Flexural Strength	6.5	%	ISO 178
Tensile Strain at Break			
(Type 1A, 5 mm/min)	3.6	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	15	%	ISO 527-2
Flexural Modulus, (2.0 mm/min)	3900	MPa	ISO 178
Tensile Stress at Break			
(Type 1A, 5 mm/min)	110	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	72.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	5500	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	3200	MPa	ISO 527-1
Flexural Stress, (2.0 mm/min)	145	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	15	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	8.0	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	22	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	70	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	55	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	95	kJ/m²	ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	245	°C	ISO 306
(A (10N), 50 °C/h)	>250	°C	ISO 306

Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	>250	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	235	°C	ISO 75-2/A
Electrical			
Comparative Tracking Index (CTI), (3.00 mm, Solution A)	600	V	IEC 60112
Flammable			
Burning Rate			
(2.00 mm)	25	mm/min	ISO 3795
(2.00 mm)	25	mm/min	FMVSS 302
Glow Wire Flammability Index			
(1.5 mm)	700	°C	IEC 60695-2-12
(3.0 mm)	700	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(1.5 mm)	725	°C	IEC 60695-2-13
(3.0 mm)	725	°C	IEC 60695-2-13
UL Information			
Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	3.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	280 to 300	°C
Mold Temperature	60 to 120	°C