Technical Data Sheet

Schulamid 66 GF15 HI K2034 BLK968001

Polyamide 66

Product Description

15% glass fiber reinforced, impact modified polyamide 66 compound

Processing Method	Injection Molding
Attribute	Impact Modified
Filler/Reinforcement	Glass Fiber, 15%
Resin ID	PA66I-GF

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.21	g/cm³	ISO 1183
Mechanical			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	4.0	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	18	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 5 mm/min)	100	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	60.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	5400	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	3000	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	12	kJ/m²	ISO 179
(-30 °C)	3.5	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	24	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(-30 °C)	40	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise)	60	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	225	°C	ISO 306
(A (10N), 50 °C/h)	>250	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa)	240	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa)	215	°C	ISO 75-2/A

Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
- Conditioned	>1.0E+10	ohm*m	IEC 62631-3-1
Surface Resistivity	>1.0E+15	ohm	IEC 60093
- Conditioned	>1.0E+12	ohm	IEC 60093
Flammable			
Burning Rate			
(2.00 mm)	30	mm/min	FMVSS 302
(2.00 mm)	30	mm/min	ISO 3795
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