

Technical Data Sheet

Schulamid 66 GF25 H LW BLK968069



Polyamide 66

Product Description

25% glass fiber reinforced PA 66, heat stabilized, laser transparent for laser welding

Processing Method	Injection Molding
Attribute	Heat Stabilized; Laser Weldable
Additive	Heat Stabilizer
Filler/Reinforcement	Glass Fiber, 25%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.32	g/cm ³	ISO 1183
Viscosity Number	145	cm ³ /g	ISO 307
Mechanical			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	3.0	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	6.0	%	ISO 527-2
Tensile Stress at Break			
(Type 1A, 5 mm/min)	170	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	120	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	8500	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	6000	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	9.0	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	7.0	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	12	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	60	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise)	56	kJ/m ²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	90	kJ/m ²	ISO 179
Thermal			
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	>250	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	242	°C	ISO 75-2/A
Flammable			

Burning Rate		
(2.00 mm)	30 mm/min	FMVSS 302
(2.00 mm)	30 mm/min	ISO 3795
UL Information		
Flammability Classification, (0.75 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