Technical Data Sheet

# *Schulamid* 66 GF25 H LW CN 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/cm³ | ISO 1183 |
| Viscosity Number | 145 | cm³/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/m² | ISO 179 |
| (-30 °C, Type 1, Edgewise, Notch A) | 7.0 | kJ/m² | ISO 179 |
| (23 °C, Type 1, Edgewise, Notch A) - Conditioned | 12 | kJ/m² | ISO 179 |
| Charpy Impact Strength - Unnotched | | | |
| (23 °C, Type 1, Edgewise) | 60 | kJ/m² | ISO 179 |
| (-30 °C, Type 1, Edgewise) | 56 | kJ/m² | ISO 179 |
| (23 °C, Type 1, Edgewise) - Conditioned | 90 | kJ/m² | 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 | ISO 3795 |
| (2.00 mm) | 30 | mm/min | FMVSS 302 |
| **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 |