Technical Data Sheet

Schulamid 66 GF30 HE BEI961624

Polyamide 66

Product Description

30% glass fiber reinforced and heat stabilized polyamide 66-compound, electrical neutral

Processing Method	Injection Molding
Filler/Reinforcement	Glass Fiber, 30%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.38	g/cm³	ISO 1183
Viscosity Number	145	cm³/g	ISO 307
Mechanical			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	2.6	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	10	%	ISO 527-2
Flexural Modulus, (2.0 mm/min)	8700	MPa	ISO 178
Tensile Stress at Break			
(Type 1A, 5 mm/min)	130	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	70.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	9500	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	5200	MPa	ISO 527-1
Flexural Stress, (2.0 mm/min, 3.0%)	210	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	4.0	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	3.0	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	6.0	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	35	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	30	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	65	kJ/m²	ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	>246	°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)	229	°C	ISO 75-2/A
Flammable			
Burning Rate			
(2.00 mm)	30	mm/min	FMVSS 302
(2.00 mm)	30	mm/min	ISO 3795

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