Technical Data Sheet

Schulamid F662E33HLBKBLK

Polyamide 66

Product Description

Schulamid F662E33HLBKBLK is a Polyamide 66 Glass Fiber, 33% filled material and is typically used in Injection Molding applications. Features include: Heat Stabilized, Lubricated, and Medium Impact Resistance.

Processing Method	Injection Molding
Attribute	Heat Stabilized; Lubricated; Medium Impact Resistance
Forms	Pellets
Additive	Heat Stabilizer; Lubricant
Filler/Reinforcement	Glass Fiber, 33%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.37	g/cm³	ASTM D792
Mechanical			
Tensile Strength at Yield, (23 °C)	159	MPa	ASTM D638
Flexural Modulus, (Tangent)	9650	MPa	ASTM D790
Impact			
Gardner Impact	0.904	J	ASTM D3029
Notched Izod Impact, (3.18 mm)	110	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	215	°C	ASTM D648
Deflection Temperature Under Load Unannealed (66 psi)	224	°C	ASTM D648

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	71 to 93	°C
Processing (Melt) Temp	277 to 299	°C
Front Temperature	271 to 299	°C
Middle Temperature	271 to 299	°C
Rear Temperature	271 to 299	°C
Injection Rate	Moderate-Fast	
Back Pressure	<0.345	MPa
Mold Temperature	66 to 93	°C
Cushion	6.35 to 12.7	mm