Technical Data Sheet

Schulamid F663E33HBGY311GRY

Polyamide 66

Product Description
33% Glass Reinforced Nylon 66

Processing Method	Injection Molding
Forms	Pellets
Filler/Reinforcement	Glass Fiber, 33%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.4	g/cm³	ASTM D792
Mechanical			
Tensile Strength at Yield, (5.0 mm/min, 23 °C, Injection Molded)	150	MPa	ASTM D638
Flexural Strength at Yield			
(1.3 mm/min, 23 °C, Injection Molded, 50.8 mm)	200	MPa	ASTM D790
(1.3 mm/min, 23 °C, Injection Molded, 50.8 mm) - Conditioned	123	MPa	ASTM D790
Tensile Strength at Break			
(5.0 mm/min, 23 °C, Injection Molded)	150	MPa	ASTM D638
(5.0 mm/min, 23 °C, Injection Molded) - Conditioned	91.0	MPa	ASTM D638
Flexural Modulus			
(1.3 mm/min, 23 °C, Injection Molded, 50.8 mm, Chord)	9670	MPa	ASTM D790
(23 °C, 1.3 mm/min, Injection Molded, Chord, 50.8 mm)	9670	MPa	ISO 178
(1.3 mm/min, 23 °C, Injection Molded, 50.8 mm, Chord) - Conditioned	6420	MPa	ASTM D790
(23 °C, 1.3 mm/min, Injection Molded, Chord, 50.8 mm) - Conditioned	9670	MPa	ISO 178
Tensile Modulus			
(1.0 mm/min, 23 °C, Injection Molded)	10200	MPa	ASTM D638
(1.0 mm/min, 23 °C, Injection Molded) - Conditioned	7050	MPa	ASTM D638

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	71 to 93	°C
Processing (Melt) Temp	249 to 293	°C
Front Temperature	249 to 293	°C
Middle Temperature	249 to 293	°C
Rear Temperature	249 to 271	°C
Injection Rate	Moderate-Fast	
Back Pressure	<0.345	MPa
Mold Temperature	66 to 93	°C
Cushion	6.35 to 12.7	mm