

Technical Data Sheet

Schulamid F663E33HLBKBLK



Polyamide 66

Product Description

Schulamid F663E33HLBKBLK 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.

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|-----------------------------|---|
| 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/cm ³ | 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 |