Technical Data Sheet

Schulamid XM GF 60 CN BLK 968001

Polyamide 66 + PA 6I/6T

Product Description

60% glassfiber reinforced semi-aromatic Polyamide Compound with excellent rigity and strength, also if conditioned. Able for Substitution Die Cast Metal.

Processing Method	Injection Molding
Filler/Reinforcement	Glass Fiber, 60%
Resin ID	PA 66 + PA 6I/6T GF 60

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.73	g/cm³	ISO 1183
Viscosity Number, (96% H2SO4 (Sulphuric Acid))	120	cm³/g	ISO 307
Mechanical			
Tensile Strain at Break			
(5 mm/min)	2.4	%	ISO 527-2
(5 mm/min) - Conditioned	2.4	%	ISO 527-2
Flexural Modulus	19800	MPa	ISO 178
Tensile Stress at Break			
(5 mm/min)	260	MPa	ISO 527-2
(5 mm/min) - Conditioned	235	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min)	22000	MPa	ISO 527-1
(1 mm/min) - Conditioned	21000	MPa	ISO 527-1
Flexural Stress, (2.0 mm/min)	395	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	15	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	14	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	13	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	95	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise)	85	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	85	kJ/m²	ISO 179
Thermal			
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	230	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	210	°C	ISO 75-2/A

Electrical			
Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
- Conditioned	>1.0E+10	ohm*m	IEC 62631-3-1
Surface Resistivity	>1.0E+15	ohm	IEC 60093
- Conditioned	>1.0E+12	ohm	IEC 60093
Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	FMVSS 302
(2.00 mm)	<100	mm/min	ISO 3795
UL Information			
Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	3.0 to 6.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	280 to 300	°C
Mold Temperature	80 to 120	°C