SCHULAMID® 66 GF 30 HE

Polyamide 66

A. Schulman Europe

Message:

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

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 30% filler by weight		
Processing Method		Injection molding		
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.38	--	g/cm³	ISO 1183/A
Viscosity Number	145	--	cm³/g	ISO 307
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	9500	5200	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	130	70.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.6	10	%	ISO 527-2/1A/5
Flexural Modulus [1]	8700	--	MPa	ISO 178
Flexural Stress [2] (3.0% strain)	210	--	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	3.0	--	kJ/m²	ISO 179/1eA
23°C	4.0	6.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	30	--	kJ/m²	ISO 179/1eU
23°C	35	65	kJ/m²	ISO 179/1eU
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	> 250	--	°C	ISO 75-2/Bf
1.8 MPa, not annealed	229	--	°C	ISO 75-2/Af
Vicat Softening Temperature				
--	> 250	--	°C	ISO 306/A50
--	> 246	--	°C	ISO 306/B50

Additional Information
干燥 1.) Not for use in food contact applications2.) Not for use in medical or pharmaceutical applicationsCharacteristic propertiesAs a semi-crystalline thermoplastic SCHULAMID® 66 possesses high rigidity,hardness and good cold impact resistance.

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.040 - 0.10	%
Suggested Max Regrind	10	%
Hopper Temperature	70.0	°C
Rear Temperature	280	°C
Middle Temperature	290	°C
Front Temperature	300	°C
Nozzle Temperature	300	°C
Processing (Melt) Temp	280 - 300	°C
Mold Temperature	80.0 - 120	°C
Injection Pressure	100 - 180	MPa
Injection Rate	Fast	
Holding Pressure	30.0 - 90.0	MPa
Back Pressure	2.00 - 8.00	MPa
Cushion	2.00 - 5.00	mm
Vent Depth	0.020	mm
Screw Speed		mm/sec

Injection instructions
PredryingTypically a minimum predrying time of 3 to 4 hours at 80°C is recommended ina dehumidifying dryer. For optimal qualities a humidity of 0,04 - 0,1 % isrecommended.Drying over 6 hours duration should occur at 60°C should be placed in the hopper.ReprocessingUp to 20% regind may be used, in which case use of additional stabilisation is recommended as a safety precaution. Use only well dried regrind.Shut downPA 66 can normally be left in the cyclinder. If in doubt purge with polyolefin.FinishingThe material is suitable for machining. Varnishing, printing, gluing andembossing can be carried out using commercially available products.Later colouring is possible with azo-colours. Take care of the self-colour.For metalising in vacuum the articles must be primered.ConditioningRecently processed moulding parts possess improved brittleness. The materialpicks up moisture until the equilibrium moisture content is reached regardingthe surrounding atmosphere. This may last for over a half year. Then the articlehas reached his balanced property profile. For accelerated absoption see ourseparate Technical instruction.

NOTE	
1.	2.0 mm/min
2.	2.0 mm/min

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

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WECHAT