

SCHULAMID® 66 GF 33 FC

Polyamide 66
A. Schulman Europe

Message:
33% glassfiber reinforced PA 66 for food contact applications

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 33% filler by weight		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.39	--	g/cm ³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	11000	8000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	170	125	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	4.7	%	ISO 527-2/1A/5
Flexural Modulus ¹	9200	--	MPa	ISO 178
Flexural Stress ² (3.5% Strain)	178	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	7.0	--	kJ/m ²	ISO 179/1eA
23°C	9.0	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	60	--	kJ/m ²	ISO 179/1eU
23°C	65	75	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	> 250	--	°C	ISO 75-2/B
1.8 MPa, not annealed	239	--	°C	ISO 75-2/Af
Vicat Softening Temperature	> 250	--	°C	ISO 306/A50, ISO 306/B50
Ball Pressure Test (185°C)	Pass	--		IEC 60695-10-2
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification				IEC 60695-11-10, -20
0.8 mm	HB	--		IEC 60695-11-10, -20
1.6 mm	HB	--		IEC 60695-11-10, -20
3.2 mm	HB	--		IEC 60695-11-10, -20
Glow Wire Flammability Index				IEC 60695-2-12

1.5 mm	650	--	°C	IEC 60695-2-12
3.0 mm	675	--	°C	IEC 60695-2-12
Glow Wire Ignition Temperature				IEC 60695-2-13
1.5 mm	675	--	°C	IEC 60695-2-13
3.0 mm	700	--	°C	IEC 60695-2-13
Injection	Dry	Unit		
Drying Temperature	80		°C	
Drying Time	3.0 - 4.0		hr	
Suggested Max Moisture	0.040 - 0.10		%	
Suggested Max Regrind	20		%	
Processing (Melt) Temp	280 - 300		°C	
Mold Temperature	60 - 120		°C	
NOTE				
1.	2.0 mm/min			
2.	2.0 mm/min			

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