

SCHULAMID® 66 GF 43

Polyamide 66

A. Schulman Europe

Message:

43% glass fiber reinforced, Polyamid 66

General Information			
UL YellowCard	E86615-252179		
Filler / Reinforcement	Glass fiber reinforced material, 43% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.49	g/cm ³	ISO 1183/A
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	25.0	cm ³ /10min	ISO 1133
Viscosity Number	145	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13500	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	215	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	3.0	%	ISO 527-2/1A/5
Flexural Modulus ¹	12200	MPa	ISO 178
Flexural Stress ²			ISO 178
4.0% strain	335	MPa	ISO 178
3.5% strain	325	MPa	ISO 178
4.0% strain ³	330	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	10	kJ/m ²	ISO 179/1eA
23°C	15	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		ISO 179/1eU
23°C	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	> 250	°C	ISO 75-2/Bf
1.8 MPa, not annealed	> 250	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	Test Method
Drying Temperature	80	°C	
Drying Time	3.0 - 4.0	hr	
Suggested Max Moisture	0.040 - 0.10	%	
Suggested Max Regrind	20	%	

Hopper Temperature	70	°C
Rear Temperature	280	°C
Middle Temperature	287	°C
Front Temperature	293	°C
Nozzle Temperature	300	°C
Processing (Melt) Temp	280 - 300	°C
Mold Temperature	60 - 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

Injection instructions

Characteristic properties" As a semi-crystalline thermoplastic SCHULAMID® 66 possesses high rigidity, hardness and good cold impact resistance." Predrying" Typically a minimum predrying time of 3 to 4 hours at 80°C is recommended in a dehumidifying dryer. For optimal qualities a humidity of 0,04 - 0,1 % is recommended. Drying over 6 hours duration should occur at 60°C. should be placed in the hopper" Reprocessing Up to 20% regrind may be used, in which case use of additional stabilisation is recommended as a safety precaution. Use only well dried regrind. Shut down PA 66 can normally be left in the cylinder. If in doubt purge with polyolefin. Finishing" The material is suitable for machining. Varnishing, printing, gluing and embossing 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 primed. "Conditioning" Recently processed moulding parts possess improved brittleness. The material picks up moisture until the equilibrium moisture content is reached regarding the surrounding atmosphere. This may last for over a half year. Then the article has reached his balanced property profile. For accelerated absorption see our separate Technical instruction."

NOTE

- | | |
|----|------------|
| 1. | 2.0 mm/min |
| 2. | 2.0 mm/min |
| 3. | at break |

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