

SCHULAMID® 66 MV 5 FR

Polyamide 66
A. Schulman Europe

Message:
Medium viscosity flame-retardant Polyamide 66 grade, V-0 by 0,38 mm; halogen free

General Information			
Features	Low smoke		
	Halogen-free		
	No antimony		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm³	ISO 1183/A
Viscosity Number	152	cm³/g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3600	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	80.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.9	%	ISO 527-2/1A/50
Flexural Modulus ¹	3700	MPa	ISO 178
Flexural Stress			ISO 178
6.3% strain	130	MPa	ISO 178
3.5% strain ²	115	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	5.0	kJ/m²	ISO 179/1eA
23°C	3.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	25	kJ/m²	ISO 179/1eU
23°C	70	kJ/m²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	222	°C	ISO 75-2/Bf
Vicat Softening Temperature	240	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flammability Classification			IEC 60695-11-10, -20
0.380 mm	V-0		IEC 60695-11-10, -20

0.800 mm	V-0		IEC 60695-11-10, -20
1.50 mm	V-0		IEC 60695-11-10, -20
3.00 mm	V-0		IEC 60695-11-10, -20
Glow Wire Flammability Index			IEC 60695-2-12
0.750 mm	960	°C	IEC 60695-2-12
1.50 mm	960	°C	IEC 60695-2-12
3.00 mm	960	°C	IEC 60695-2-12
Oxygen Index	35	%	ISO 4589-2

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	0.040 - 0.10	%
Hopper Temperature	80.0	°C
Rear Temperature	250	°C
Middle Temperature	265	°C
Front Temperature	280	°C
Processing (Melt) Temp	280	°C
Mold Temperature	60.0 - 100	°C
Injection Pressure	80.0 - 140	MPa
Holding Pressure	40.0 - 85.0	MPa
Back Pressure	2.00 - 8.00	MPa
Screw Speed	250	mm/sec

Injection instructions

Characteristic propertiesSCHULAMID ... FR is the trade name of the halogen and (red) phosphorous free flame retardant Polyamide 6, 66 and 66/6 grades. Predrying "Typically a minimum predrying time of 3 to 4 hours at 80°C is recommended in an 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 Addition of regrind is not recommended for nylons containing flame retardant. Shut down "Long residence time should be avoided. Purge with polyolefin or with base polymer." Finishing "The material is suitable for machining. Varnishing, printing, gluing and embossing can be carried out using commercially available products." Conditioning "Recently processed mouldings which not have been conditioned are brittle. The material picks up moisture until the equilibrium moisture content is reached. 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." Remarks "For permanent processing of glass fibre reinforced grades wear resistant screws and cylinders are recommended."

NOTE

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

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