

Technical Data Sheet

Schulamid 66 GF 33 FC

Polyamide 66
LyondellBasell Industries
Engineering Plastics

Product Description

33% glassfiber reinforced PA 66 for food contact applications

General

Filler / Reinforcement	• Glass Fiber, 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	1.60E+6 (11000)	1.16E+6 (8000)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	24700 (170)	18100 (125)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	4.7	%	ISO 527-2/1A/5
Flexural Modulus ¹	1.33E+6 (9200)	--	psi (MPa)	ISO 178
Flexural Stress ¹ (3.5% Strain)	25800 (178)	--	psi (MPa)	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	3.3 (7.0)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	4.3 (9.0)	5.7 (12)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	29 (60)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	31 (65)	36 (75)	ft·lb/in ² (kJ/m ²)	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	> 482 (> 250)	--	°F (°C)	ISO 75-2/B
264 Psi (1.8 Mpa), Unannealed	462 (239)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature	> 482 (> 250)	--	°F (°C)	ISO 306/B50 ISO 306/A50
Ball Pressure Test (365°F (185°C))	Pass	--		IEC 60695-10-2

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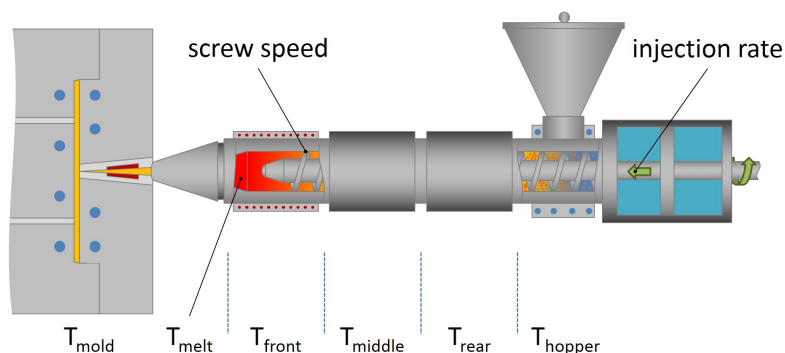
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Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 In (2.00 Mm)	1.2 (30)	--	in/min (mm/min)	ISO 3795
0.0787 In (2.00 Mm)	1.2 (30)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.03 In (0.8 Mm)	HB	--		
0.06 In (1.6 Mm)	HB	--		
0.13 In (3.2 Mm)	HB	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.06 In (1.5 Mm)	1200 (650)	--	°F (°C)	
0.12 In (3.0 Mm)	1250 (675)	--	°F (°C)	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.06 In (1.5 Mm)	1250 (675)	--	°F (°C)	
0.12 In (3.0 Mm)	1290 (700)	--	°F (°C)	

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Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 4.0 hr	3.0 to 4.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Processing (Melt) Temp	536 to 572 °F	280 to 300 °C
Mold Temperature	140 to 248 °F	60 to 120 °C

Notes

¹ 0.079 in/min (2.0 mm/min)

Notes

These are typical property values not to be construed as specification limits.