

Technical Data Sheet

Schulamid 66 MW 30 FR 4 K2031

Polyamide 66
LyondellBasell Industries
Engineering Plastics

Product Description

30% mineral filled flame-retardant Polyamide 66 grade with low warpage; without PBDE

General

Filler / Reinforcement	• Mineral, 30% Filler by Weight		
Features	• Flame Retardant	• Good Strength	• Low Warpage
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA66 MF30 FR(17)		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.60	--	g/cm ³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.33E+6 (9200)	653000 (4500)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	11600 (80.0)	5800 (40.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	6.0	%	ISO 527-2/1A/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	0.95 (2.0)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	0.95 (2.0)	0.95 (2.0)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	5.7 (12)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	11 (23)	16 (33)	ft·lb/in ² (kJ/m ²)	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 Psi (0.45 Mpa), Unannealed	457 (236)	--	°F (°C)	ISO 75-2/Bf
264 Psi (1.8 Mpa), Unannealed	307 (153)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	462 (239)	--	°F (°C)	ISO 306/B50
--	> 482 (> 250)	--	°F (°C)	ISO 306/A50
Ball Pressure Test (392°F (200°C))	Pass	--		IEC 60695-10-2
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	300	--	V	IEC 60112

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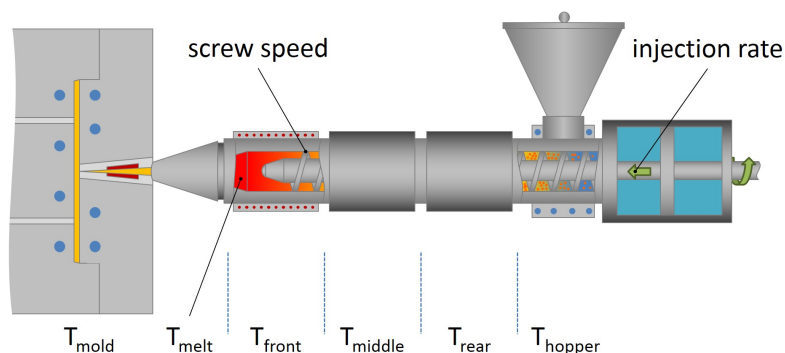
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Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				ISO 3795
0.0295 In (0.750 Mm), Self-extinguishing	0.0	--	in/min (mm/min)	
0.0591 In (1.50 Mm), Self-extinguishing	0.0	--	in/min (mm/min)	
0.118 In (3.00 Mm), Self-extinguishing	0.0	--	in/min (mm/min)	
Flame Rating				UL 94 IEC 60695-11-10, -20
0.030 In (0.75 Mm)	V-2	--		
0.06 In (1.5 Mm)	V-2	--		
0.12 In (3.0 Mm)	V-0	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.030 In (0.75 Mm)	1760 (960)	--	°F (°C)	
0.06 In (1.5 Mm)	1760 (960)	--	°F (°C)	
0.12 In (3.0 Mm)	1760 (960)	--	°F (°C)	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.030 In (0.75 Mm)	1610 (875)	--	°F (°C)	
0.06 In (1.5 Mm)	1610 (875)	--	°F (°C)	
0.12 In (3.0 Mm)	1610 (875)	--	°F (°C)	
Oxygen Index	33	--	%	ISO 4589-2

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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	518 to 554 °F	270 to 290 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Back Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Screw Speed	< 591 in/min	< 15 m/min

Injection Notes

Mould surface contacting melt should
be of non-corrosive steel (content of chrome > 12%)

Notes

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