

Technical Data Sheet

Schulamid 66 MV3 FR NAT



Polyamide 66

Product Description

Medium viscosity flame-retardant Polyamide 66 grade, V-0 by 0,75 mm; halogen free

Processing Method	Injection Molding
Attribute	Antimony Free; Halogen Free; Low Smoke Emission
Additive	Flame Retardant
Resin ID	PA66 FR(30)

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.19	g/cm ³	ISO 1183
Viscosity Number	145	cm ³ /g	ISO 307
Mechanical			
Tensile Stress at Yield			
(Type 1A, 50 mm/min)	85.0	MPa	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	45.0	MPa	ISO 527-2
Tensile Strain at Yield			
(Type 1A, 50 mm/min)	3.5	%	ISO 527-2
(Type 1A, 50 mm/min) - Conditioned	6.0	%	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	3800	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	1500	MPa	ISO 527-1
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	4.5	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	3.0	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	85	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise)	65	kJ/m ²	ISO 179
Hardness			
Ball Pressure Test, (125 °C)	Pass		IEC 60695-10-2
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	227	°C	ISO 306
(A (10N), 50 °C/h)	245	°C	ISO 306

Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	242	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	100	°C	ISO 75-2/A
RTI Elec			
(1.5 mm)	130	°C	UL 746B
(3.0 mm)	130	°C	UL 746B
(0.75 mm)	130	°C	UL 746B
RTI Imp			
(1.5 mm)	90.0	°C	UL 746B
(3.0 mm)	90.0	°C	UL 746B
(0.75 mm)	90.0	°C	UL 746B
RTI Str			
(1.5 mm)	120	°C	UL 746B
(3.0 mm)	120	°C	UL 746B
(0.75 mm)	120	°C	UL 746B
Electrical			
Comparative Tracking Index (CTI), (Solution A)	600	V	IEC 60112
High Amp Arc Ignition			UL 746A
Flammable			
Hot-wire Ignition (HWI)			UL 746A
Glow Wire Flammability Index			
(0.75 mm)	960	°C	IEC 60695-2-12
(1.5 mm)	960	°C	IEC 60695-2-12
(3.0 mm)	960	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(0.75 mm)	750	°C	IEC 60695-2-13
(1.5 mm)	750	°C	IEC 60695-2-13
(3.0 mm)	750	°C	IEC 60695-2-13
Oxygen Index	35	%	ISO 4589-2
UL Information			
Flammability Classification			
(0.75 mm)	V-0		IEC 60695-11-10, -20
(1.5 mm)	V-0		IEC 60695-11-10, -20
(3.0 mm)	V-0		IEC 60695-11-10, -20
UL File Number	E86615		

Injection Parameters	Nominal Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Screw Speed	250	mm/sec
Processing (Melt) Temp	260 to 280	°C
Injection Rate	Slow-Moderate	
Back Pressure	20 to 80	bar
Mold Temperature	60 to 100	°C