

Technical Data Sheet

SCHULAMID® XM GF 60 BLACK

Polyamide 66 + PA 6I/6T
Engineering Plastics

Product Description

60% glassfiber reinforced semi-aromatic Polyamide Compound with excellent rigity and strength, also if conditioned. Able for Substitution Die Cast Metal.

General

Filler / Reinforcement	• Glass Fiber, 60% Filler by Weight
Processing Method	• Injection Molding
Resin ID (ISO 1043)	• PA 66 + PA 6I/6T GF 60

Physical	Dry	Conditioned	Unit	Test Method
Density	1.73	--	g/cm ³	ISO 1183/A
Viscosity Number				ISO 307
96% H2SO4 (Sulphuric Acid)	120	--	cm ³ /g	

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3.19E+6 (22000)	3.05E+6 (21000)	psi (MPa)	ISO 527-2/1
Tensile Stress (Break)	37700 (260)	34100 (235)	psi (MPa)	ISO 527-2/5
Tensile Strain (Break)	2.4	2.4	%	ISO 527-2/5
Flexural Modulus	2.87E+6 (19800)	--	psi (MPa)	ISO 178
Flexural Stress ¹	57300 (395)	--	psi (MPa)	ISO 178

Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	6.7 (14)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	7.1 (15)	6.2 (13)	ft·lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	40 (85)	--	ft·lb/in ² (kJ/m ²)	
73°F (23°C)	45 (95)	40 (85)	ft·lb/in ² (kJ/m ²)	

Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
66 psi (0.45 MPa), Unannealed	446 (230)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	410 (210)	--	°F (°C)	ISO 75-2/Af

Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	> 1.0E+15	> 1.0E+12	ohms	IEC 60093
Volume Resistivity	> 1.0E+13	> 1.0E+10	ohms·m	IEC 62631-3-1

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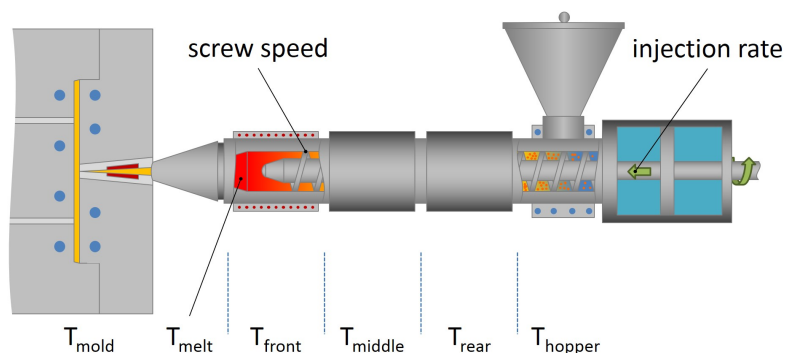
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Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				
0.0787 in (2.00 mm)	< 3.9 (< 100)	--	in/min (mm/min)	ISO 3795
0.0787 in (2.00 mm)	< 3.9 (< 100)	--	in/min (mm/min)	FMVSS 302
Flammability Classification				IEC 60695-11-10, -20
0.06 in (1.5 mm)	HB	--		
0.12 in (3.0 mm)	HB	--		

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Injection	Dry (English)	Dry (SI)
Drying Temperature	176 °F	80 °C
Drying Time	3.0 to 6.0 hr	3.0 to 6.0 hr
Suggested Max Moisture	0.04 to 0.10 %	0.04 to 0.10 %
Suggested Max Regrind	10 %	10 %
Processing (Melt) Temp	536 to 572 °F	280 to 300 °C
Mold Temperature	176 to 248 °F	80 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.