Technical Data Sheet

Schulamid 66 MK30 HI H K135 GRY967370

Polyamide 66

Product Description
30% mineral filled PA 66, impact modified, heat stabilized

Processing Method	Injection Molding
Attribute	Heat Stabilized; Impact Modified
Additive	Heat Stabilizer; Impact Modifier
Filler/Reinforcement	Mineral, 40%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density, (Method A)	1.36	g/cm³	ISO 1183
Mechanical			
Tensile Strain at Break			
(Type 1A, 5 mm/min)	12	%	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	>50	%	ISO 527-2
Flexural Modulus	3200	MPa	ISO 178
Tensile Stress at Break			
(Type 1A, 5 mm/min)	60.0	MPa	ISO 527-2
(Type 1A, 5 mm/min) - Conditioned	38.0	MPa	ISO 527-2
Tensile Modulus			
(1 mm/min, Type 1A)	3200	MPa	ISO 527-1
(1 mm/min, Type 1A) - Conditioned	1000	MPa	ISO 527-1
Flexural Stress	92	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	10	kJ/m²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	6.0	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise, Notch A) - Conditioned	12	kJ/m²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	90	kJ/m²	ISO 179
(23 °C, Type 1, Edgewise) - Conditioned	No Break		ISO 179
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	200	°C	ISO 306
(A (10N), 50 °C/h)	240	°C	ISO 306

Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	115	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	62.0	°C	ISO 75-2/A
Electrical			
Comparative Tracking Index (CTI), (3.00 mm)	450	V	IEC 60112
Flammable			
Burning Rate			
(2.00 mm)	<100	mm/min	ISO 3795
(2.00 mm)	<100	mm/min	FMVSS 302
Glow Wire Flammability Index			
(1.5 mm)	700	°C	IEC 60695-2-12
(3.0 mm)	725	°C	IEC 60695-2-12
Glow Wire Ignition Temperature			
(1.5 mm)	725	°C	IEC 60695-2-13
(3.0 mm)	725	°C	IEC 60695-2-13
Additional Information			
Water Absorption 23C/50RH	2.1	%	ISO 62
UL Information			
Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	3.0 to 4.0	hr
Drying Temperature	80	°C
Suggested Max Moisture	0.040 to 0.10	%
Processing (Melt) Temp	280 to 300	°C
Mold Temperature	60 to 120	°C