

# Schulamid 66 GF 25 HE LW BLACK 96.8069

Polyamide 66  
LyondellBasell Industries  
Engineering Plastics

## Product Description

25% glass fiber reinforced and heat stabilized polyamide 66-compound, electrical neutral, laser transparent for laser welding processes

## General

|                        |                                     |
|------------------------|-------------------------------------|
| Filler / Reinforcement | • Glass Fiber, 25% Filler by Weight |
| Additive               | • Heat Stabilizer                   |
| Features               | • Heat Stabilized • Laser Weldable  |
| Processing Method      | • Injection Molding                 |

| Physical | Dry  | Conditioned | Unit              | Test Method |
|----------|------|-------------|-------------------|-------------|
| Density  | 1.32 | --          | g/cm <sup>3</sup> | ISO 1183/A  |

|                  |     |    |                    |         |
|------------------|-----|----|--------------------|---------|
| Viscosity Number | 145 | -- | cm <sup>3</sup> /g | ISO 307 |
|------------------|-----|----|--------------------|---------|

| Mechanical             | Dry               | Conditioned      | Unit         | Test Method    |
|------------------------|-------------------|------------------|--------------|----------------|
| Tensile Modulus        | 1.23E+6<br>(8500) | 870000<br>(6000) | psi<br>(MPa) | ISO 527-1/1A/1 |
| Tensile Stress (Break) | 24700<br>(170)    | 17400<br>(120)   | psi<br>(MPa) | ISO 527-2/1A/5 |
| Tensile Strain (Break) | 3.0               | 6.0              | %            | ISO 527-2/1A/5 |

| Impact                           | Dry          | Conditioned | Unit                                          | Test Method |
|----------------------------------|--------------|-------------|-----------------------------------------------|-------------|
| Charpy Notched Impact Strength   |              |             |                                               | ISO 179/1eA |
| -22°F (-30°C)                    | 3.3<br>(7.0) | --          | ft·lb/in <sup>2</sup><br>(kJ/m <sup>2</sup> ) |             |
| 73°F (23°C)                      | 4.3<br>(9.0) | 5.7<br>(12) | ft·lb/in <sup>2</sup><br>(kJ/m <sup>2</sup> ) |             |
| Charpy Unnotched Impact Strength |              |             |                                               | ISO 179/1eU |
| -22°F (-30°C)                    | 27<br>(56)   | --          | ft·lb/in <sup>2</sup><br>(kJ/m <sup>2</sup> ) |             |
| 73°F (23°C)                      | 29<br>(60)   | 43<br>(90)  | ft·lb/in <sup>2</sup><br>(kJ/m <sup>2</sup> ) |             |

| Thermal                           | Dry              | Conditioned | Unit       | Test Method |
|-----------------------------------|------------------|-------------|------------|-------------|
| Deflection Temperature Under Load |                  |             |            |             |
| 66 Psi (0.45 Mpa), Unannealed     | > 482<br>(> 250) | --          | °F<br>(°C) | ISO 75-2/Bf |
| 264 Psi (1.8 Mpa), Unannealed     | 468<br>(242)     | --          | °F<br>(°C) | ISO 75-2/Af |

| Flammability                | Dry         | Conditioned | Unit               | Test Method             |
|-----------------------------|-------------|-------------|--------------------|-------------------------|
| Burning Rate                |             |             |                    |                         |
| 0.0787 In (2.00 Mm)         | 1.2<br>(30) | --          | in/min<br>(mm/min) | ISO 3795                |
| 0.0787 In (2.00 Mm)         | 1.2<br>(30) | --          | in/min<br>(mm/min) | FMVSS 302               |
| Flammability Classification |             |             |                    | IEC 60695-11-10,<br>-20 |
| 0.030 In (0.75 Mm)          | HB          | --          |                    |                         |

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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

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