InStruc® PA66GF33IM2HS

Americhem - *Polyamide 66*

General Information

Product Description			
33% GLASS FIBER REINFORCED, IMPACT MODIFIED, HEAT-STABILIZED, NYLON 6/6			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• Filled • Good Dimensional Stability • Heat Stabilized	• High Impact Resistance • High Stiffness • High Strength	• Impact Modified • Low Temperature Toughness
Uses	• Automotive Applications • Closures • Consumer Applications • Electrical/Electronic Applications	• Engineering Parts • Household Goods • Industrial Applications • Industrial Parts	• Office Automation Equipment • Outdoor Applications • Window & Door Components
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow	2.0E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.40E+6	psi	ASTM D638
Tensile Strength	18500	psi	ASTM D638
Tensile Elongation (Yield)	3.0 to 6.0	%	ASTM D638
Flexural Modulus	1.25E+6	psi	ASTM D790
Flexural Strength (Break)	26000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	2.5	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	18	ft·lb/in	ASTM D4812
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	490	°F	ASTM D648
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	> 1.0E+17	ohms	ASTM D257
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.06 in	HB		
0.13 in	HB		

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	175	°F
Drying Time	4.0	hr
Processing (Melt) Temp	500 to 575	°F
Mold Temperature	200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm