InStruc® PA66GF33IMHS

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	1.32		ASTM D792
Molding Shrinkage - Flow	4.0E-3 to 6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.10E+6	psi	ASTM D638
Tensile Strength	20000	psi	ASTM D638
Tensile Elongation (Yield)	4.0 to 5.0	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength	28000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (0.125 in)	5.7	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)	480	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Drying Time	2.0 to 4.0	hr
Processing (Melt) Temp	545 to 575	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm