

**InStruc® PA66GF25HSHR**

Americhem - Polyamide 66

**General Information**
**Product Description**

INSTRUC PA66GF25HSHR is a 25% Glass Fiber reinforced, heat stabilized Nylon 66.

**General**

Material Status	• Commercial: Active
Availability	• Africa & Middle East • Asia Pacific • Europe • Latin America • North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Additive	• Heat Stabilizer
Features	• Filled • Good Dimensional Stability • Heat Stabilized • High Stiffness • High Strength
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 <sup>1</sup>**

<b>Physical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Density / Specific Gravity	1.33		ASTM D792
Molding Shrinkage - Flow	1.0E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
<b>Mechanical</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Tensile Modulus	1.30E+6	psi	ASTM D638
Tensile Strength	25000	psi	ASTM D638
Tensile Elongation (Yield)	3.0 to 4.0	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength	36000	psi	ASTM D790
<b>Impact</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Notched Izod Impact (0.125 in)	2.0	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	15	ft·lb/in	ASTM D4812
<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load (264 psi, Unannealed)	475	°F	ASTM D648

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
Drying Temperature	175	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	530 to 570	°F
Mold Temperature	150 to 200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

