

InStruc® PA66GF25

Americhem - Polyamide 66

General Information
Product Description

25% Glass Fiber Reinforced 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		
Features	• Filled • Good Dimensional Stability	• 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 ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.33		ASTM D792
Molding Shrinkage - Flow	4.0E-3 to 6.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.40E+6	psi	ASTM D638
Tensile Strength	23000	psi	ASTM D638
Tensile Elongation (Yield)	3.0 to 4.0	%	ASTM D638
Flexural Modulus	1.20E+6	psi	ASTM D790
Flexural Strength	34000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.6	ft·lb/in	ASTM D256
Unnotched Izod Impact (0.125 in)	13	ft·lb/in	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	475	°F	ASTM D648

Processing Information

Injection	Nominal Value	Unit
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

