

Technical Data Sheet



Schulamid 66 MW 30 FR 4 K2031

Polyamide 66
LyondellBasell Industries
Engineering Plastics

Product Description

30% mineral filled flame-retardant Polyamide 66 grade with low warpage; without PBDE

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Mineral, 30% Filler by Weight		
Features	• Flame Retardant	• Good Strength	• Low Warpage
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA66 MF30 FR(17)		

Physical	Dry	Conditioned	Unit	Test Method
Density	1.60	--	g/cm ³	ISO 1183/A
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.33E+6 (9200)	653000 (4500)	psi (MPa)	ISO 527-1/1A/1
Tensile Stress (Break)	11600 (80.0)	5800 (40.0)	psi (MPa)	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	6.0	%	ISO 527-2/1A/5
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-22°F (-30°C)	0.95 (2.0)	--	ft-lb/in ² (kJ/m ²)	
73°F (23°C)	0.95 (2.0)	0.95 (2.0)	ft-lb/in ² (kJ/m ²)	
Charpy Unnotched Impact Strength				ISO 179/1eU
-22°F (-30°C)	5.7 (12)	--	ft-lb/in ² (kJ/m ²)	
73°F (23°C)	11 (23)	16 (33)	ft-lb/in ² (kJ/m ²)	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
66 psi (0.45 MPa), Unannealed	457 (236)	--	°F (°C)	ISO 75-2/Bf
264 psi (1.8 MPa), Unannealed	307 (153)	--	°F (°C)	ISO 75-2/Af
Vicat Softening Temperature				
--	462 (239)	--	°F (°C)	ISO 306/B50
--	> 482 (> 250)	--	°F (°C)	ISO 306/A50
Ball Pressure Test (392°F (200°C))	Pass	--		IEC 60695-10-2
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	300	--	V	IEC 60112

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Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate				ISO 3795
0.0295 in (0.750 mm), Self-Extinguishing	0.0	--	in/min (mm/min)	
0.0591 in (1.50 mm), Self-Extinguishing	0.0	--	in/min (mm/min)	
0.118 in (3.00 mm), Self-Extinguishing	0.0	--	in/min (mm/min)	
Flame Rating				UL 94 IEC 60695-11-10, -20
0.030 in (0.75 mm)	V-2	--		
0.06 in (1.5 mm)	V-2	--		
0.12 in (3.0 mm)	V-0	--		
Glow Wire Flammability Index				IEC 60695-2-12
0.030 in (0.75 mm)	1760 (960)	--	°F (°C)	
0.06 in (1.5 mm)	1760 (960)	--	°F (°C)	
0.12 in (3.0 mm)	1760 (960)	--	°F (°C)	
Glow Wire Ignition Temperature				IEC 60695-2-13
0.030 in (0.75 mm)	1610 (875)	--	°F (°C)	
0.06 in (1.5 mm)	1610 (875)	--	°F (°C)	
0.12 in (3.0 mm)	1610 (875)	--	°F (°C)	
Oxygen Index	33	--	%	ISO 4589-2

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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	518 to 554 °F	270 to 290 °C
Mold Temperature	140 to 212 °F	60 to 100 °C
Back Pressure	290 to 1160 psi	2.00 to 8.00 MPa
Screw Speed	< 591 in/min	< 15 m/min

Injection Notes

Mould surface contacting melt should be of non-corrosive steel (content of chrome > 12%)

Notes

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

Processing Techniques

Specific recommendations for resin type and processing conditions can only be made when the end use, required properties and fabrication equipment are known.

Product Storage and Handling

- Product should be stored in dry conditions at temperatures below 50°C and protected from UV-light
- Improper storage may bring damage to the packaging and can negatively affects on the quality of this product
- Keep material completely dry for good processing

Company Information

For further information regarding the LyondellBasell company, please visit <http://www.lyb.com/>.

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