

Technical Data Sheet

Schulamid F663E13BKBLK

Polyamide 66

Product Description

Schulamid F663E13BKBLK is a Polyamide 66 Glass Fiber, 13% filled material.

Forms Pellets
Filler/Reinforcement Glass Fiber, 13%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.22	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	114	MPa	ASTM D638
Flexural Modulus, (Tangent)	4960	MPa	ASTM D790
Impact			
Notched Izod Impact	53	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	238	°C	ASTM D648
RTI Str	65.6	°C	UL 746B
UL Information			
Flame Rating, (1.5 mm)	HB		UL 94

Injection Parameters	Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	71 to 93	°C
Processing (Melt) Temp	277 to 299	°C
Front Temperature	271 to 299	°C
Middle Temperature	271 to 299	°C
Rear Temperature	271 to 299	°C
Injection Rate	Moderate-Fast	
Back Pressure	<0.345	MPa
Mold Temperature	66 to 93	°C
Cushion	6.35 to 12.7	mm