

Technical Data Sheet

Schulamid F663E33HB 7800 VC Green

Polyamide 66

Product Description

33% Glass Reinforced Nylon 66

Processing Method Injection Molding

Forms Pellets

Filler/Reinforcement Glass Fiber, 33%

Typical Properties	Nominal Value	Units	Test Method
Physical			
Density - Specific Gravity	1.38	g/cm ³	ASTM D792
Mechanical			
Tensile Strength at Yield	149	MPa	ASTM D638
Flexural Modulus, (Tangent)	9310	MPa	ASTM D790
Impact			
Notched Izod Impact	80	J/m	ASTM D256
Thermal			
Deflection Temperature Under Load Unannealed (264 psi)	249	°C	ASTM D648
UL Information			
Flame Rating	HB		UL 94

Injection Parameters	Value	Units
Drying Time	4.0 to 6.0	hr
Drying Temperature	71 to 93	°C
Processing (Melt) Temp	249 to 293	°C
Front Temperature	249 to 293	°C
Middle Temperature	249 to 293	°C
Rear Temperature	249 to 271	°C
Injection Rate	Moderate-Fast	
Back Pressure	<0.345	MPa
Mold Temperature	66 to 93	°C
Cushion	6.35 to 12.7	mm