

Clariant Nylon 6/6 PA-111G33

Polyamide 66

Clariant Corporation

Message:

Clariant Nylon 6/6 PA-111G33 is a polyamide 66 (nylon 66) material, which contains a 33% glass fiber reinforced material. This product is available in North America and is processed by injection molding.

The main features of Clariant Nylon 6/6 PA-111G33 are:

flame retardant/rated flame

Good stiffness

Typical application areas include:

Wire and cable

House

engineering/industrial accessories

General Information			
UL YellowCard	E103015-218190		
Filler / Reinforcement	Glass fiber reinforced material, 33% filler by weight		
Features	Rigid, good		
Uses	Gear Shell		
Agency Ratings	UL 94		
Appearance	Available colors		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.50	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
Class m	96		ASTM D785
Class r	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	186	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	8960	MPa	ASTM D790
Flexural Strength	262	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	260	°C	ASTM D648

1.8 MPa, not annealed	254	°C	ASTM D648
Melting Temperature	255	°C	
CLTE - Flow	3.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength	21	kV/mm	ASTM D149
Arc Resistance (3.05 mm)	150	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.710 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	266 - 293	°C	
Middle Temperature	266 - 293	°C	
Front Temperature	266 - 293	°C	
Processing (Melt) Temp	266 - 288	°C	
Melt Temperature (Aim)	274	°C	
Mold Temperature	65.6 - 93.3	°C	
Injection Rate	Fast		
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	20 - 100	rpm	
Cushion	3.18 - 6.35	mm	

Injection instructions

Injection Pressure: Use minimum pressure to achieve 95% fill during the boost inj. pressure phase. Hold Pressure: 30% to 75% of injection pressure. Mold Temp. Target: 180°F. Screw Speed Target: 75 RPM

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