Clariant Nylon 6/6 PA-113G33C

Polyamide 66

Clariant Corporation

Message:

Clariant Nylon 6/6 PA-113G33C 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-113G33C are:
flame retardant/rated flame
heat stabilizer
Lubrication
The typical application field of Clariant Nylon 6/6 PA-113G33C is: wire and cable

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 33% filler by weight		
Additive	heat stabilizer Lubricant		
Features	Thermal Stability Lubrication		
Agency Ratings	UL 94		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.43	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.30	%	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness			ASTM D785
Class m	97		ASTM D785
Class r	122		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	172	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	9650	MPa	ASTM D790
Flexural Strength	262	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	96	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	246	°C	ASTM D648

CLTE - Flow	2.0E-5	cm/cm/°C	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength	19	kV/mm	ASTM D149
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating	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°FScrew Speed Target: 75 RPM

Recommended distributors for this material

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