Clariant Nylon 6/6 PA-133G33

Polyamide 66

Clariant Corporation

Message:

Clariant Nylon 6/6 PA-133G33 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-133G33 are:
flame retardant/rated flame
high strength
Hard
Good toughness
heat stabilizer
Typical application areas include:
electrical appliances
Wire and cable
building applications
Automotive Industry

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 33% filler by weight		
Additive	heat stabilizer		
Features	Rigidity, high High strength Thermal Stability Good toughness		
Uses	Electrical appliances Architectural application field Application in Automobile Field		
Agency Ratings	UL 94		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.32	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.70	%	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness			ASTM D785
Class m	90		ASTM D785
Class r	118		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	124	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638

Flexural Modulus	5520	MPa	ASTM D790
Flexural Strength	179	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	170	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	238	°C	ASTM D648
1.8 MPa, not annealed	204	°C	ASTM D648
CLTE - Flow	3.6E-5	cm/cm/°C	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength	22	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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