

# Clariant Nylon 6 60G33-L

Polyamide 6  
Clariant Corporation

Message:

Clariant Nylon 6 60G33-L is a polyamide 6 (nylon 6) material, and the filler is 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 60G33-L are:  
flame retardant/rated flame  
Lubrication

| General Information               |                                                       |                   |             |
|-----------------------------------|-------------------------------------------------------|-------------------|-------------|
| UL YellowCard                     | E103015-218179                                        |                   |             |
| Filler / Reinforcement            | Glass fiber reinforced material, 33% filler by weight |                   |             |
| Additive                          | Lubricant                                             |                   |             |
| Features                          | Lubrication                                           |                   |             |
| Forms                             | Particle                                              |                   |             |
| Processing Method                 | Injection molding                                     |                   |             |
| Physical                          | Nominal Value                                         | Unit              | Test Method |
| Specific Gravity                  | 1.37                                                  | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow          | 0.35                                                  | %                 | ASTM D955   |
| Mechanical                        | Nominal Value                                         | Unit              | Test Method |
| Tensile Strength (Yield)          | 165                                                   | MPa               | ASTM D638   |
| Tensile Elongation (Yield)        | 3.0                                                   | %                 | ASTM D638   |
| Flexural Modulus                  | 8960                                                  | MPa               | ASTM D790   |
| Flexural Strength (Yield)         | 248                                                   | MPa               | ASTM D790   |
| Impact                            | Nominal Value                                         | Unit              | Test Method |
| Notched Izod Impact (23°C)        | 130                                                   | J/m               | ASTM D256   |
| Thermal                           | Nominal Value                                         | Unit              | Test Method |
| Deflection Temperature Under Load |                                                       |                   | ASTM D648   |
| 0.45 MPa, unannealed, 6.35mm      | 215                                                   | °C                | ASTM D648   |
| 1.8 MPa, unannealed, 6.35mm       | 210                                                   | °C                | ASTM D648   |
| Flammability                      | Nominal Value                                         |                   | Test Method |
| Flame Rating (1.50 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                                                  | %                 |             |
| Suggested Shot Size               | 30 - 80                                               | %                 |             |
| Rear Temperature                  | 249 - 266                                             | °C                |             |
| Middle Temperature                | 249 - 266                                             | °C                |             |
| Front Temperature                 | 254 - 271                                             | °C                |             |

|                        |             |     |
|------------------------|-------------|-----|
| Nozzle Temperature     | 254 - 274   | °C  |
| Processing (Melt) Temp | 254 - 271   | °C  |
| Mold Temperature       | 79.4 - 121  | °C  |
| Injection Pressure     | 8.27 - 13.8 | MPa |
| Back Pressure          | 0.345       | MPa |
| Screw Speed            | 20 - 100    | rpm |

Injection instructions

Injection Pressure, Secondary: 60% of Initial

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