

Clariant Nylon 6/6 66G33M

Polyamide 66
Clariant Corporation

Message:

Clariant Nylon 6/6 66G33M is a Polyamide 66 (Nylon 66) material filled with 33% glass fiber. It is available in North America for injection molding. Important attributes of Clariant Nylon 6/6 66G33M are:

Flame Rated
Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,33% Filler by Weight		
Additive	Molybdenum Disulfide Lubricant		
Features	General Purpose		
	Lubricated		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	145	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	8270	MPa	ASTM D790
Flexural Strength	193	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	64	J/m	ASTM D256
Tensile Impact Strength	231	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	254	°C	
1.8 MPa, Unannealed	243	°C	
Melting Temperature	257	°C	
RTI Elec			UL 746
1.57 mm	105	°C	
3.18 mm	110	°C	
6.10 mm	110	°C	
RTI Imp			UL 746
1.57 mm	65.0	°C	
3.18 mm	65.0	°C	
6.10 mm	65.0	°C	

RTI Str		UL 746
1.57 mm	105	°C
3.18 mm	110	°C
6.10 mm	110	°C
Flammability	Nominal Value	Test Method
Flame Rating		UL 94
1.57 mm	HB	
3.18 mm	HB	
6.10 mm	HB	
Injection	Nominal Value	Unit
Drying Temperature	71.1 to 82.2	°C
Suggested Max Regrind	25	%
Rear Temperature	249 to 271	°C
Middle Temperature	271 to 288	°C
Front Temperature	282 to 299	°C
Nozzle Temperature	266 to 288	°C
Mold Temperature	71.1 to 104	°C
Injection Pressure	55.2 to 138	MPa
Back Pressure	0.00 to 1.03	MPa
Screw Speed	30 to 60	rpm

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