

Clariant Nylon 6/6 PA-133

Polyamide 66
Clariant Corporation

Message:

Clariant Nylon 6/6 PA-133 is a polyamide 66 (nylon 66) material. This product is available in North America and is processed by injection molding. The main features of Clariant Nylon 6/6 PA-133 are:

- flame retardant/rated flame
- Good toughness
- Impact resistance
- heat stabilizer

Typical application areas include:

- safety equipment
- Wire and cable
- House
- Automotive Industry

General Information			
UL YellowCard	E103015-218192		
Additive	heat stabilizer		
Features	Ultra-high impact resistance		
	Shock absorption		
	Noise reduction		
	Thermal Stability		
	Good toughness		
Uses	Safety helmet		
	Shell		
Agency Ratings	UL 94		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.7	%	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	44.8	MPa	ASTM D638
Tensile Elongation (Yield)	50	%	ASTM D638
Flexural Modulus	1720	MPa	ASTM D790
Flexural Strength	66.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact (3.18 mm)	800	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	216	°C	ASTM D648
1.8 MPa, not annealed	71.1	°C	ASTM D648
CLTE - Flow	8.3E-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°F Screw Speed Target: 75 RPM

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