

Clariant Nylon 6/6 6604-L

Polyamide 66
Clariant Corporation

Message:

Clariant Nylon 6/6 6604-L is a Polyamide 66 (Nylon 66) material. It is available in North America for injection molding.
Important attributes of Clariant Nylon 6/6 6604-L are:
Impact Modified
Lubricated

General Information			
UL YellowCard	E103015-218196		
Additive	Impact Modifier		
	Lubricant		
Features	Impact Modified		
	Lubricated		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.4 to 1.9	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	51.7	MPa	ASTM D638
Tensile Elongation (Break)	65	%	ASTM D638
Flexural Modulus	1720	MPa	ASTM D790
Flexural Strength	68.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	160	J/m	ASTM D256
Tensile Impact Strength (23°C)	198	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	221	°C	
1.8 MPa, Unannealed	73.9	°C	
Melting Temperature	257	°C	
Injection	Nominal Value	Unit	
Drying Temperature	71.1 to 82.2	°C	
Suggested Max Regrind	25	%	
Rear Temperature	249 to 266	°C	
Middle Temperature	271 to 288	°C	
Front Temperature	282 to 293	°C	

Nozzle Temperature	266 to 288	°C
Mold Temperature	54.4 to 93.3	°C
Injection Pressure	34.5 to 103	MPa
Back Pressure	0.00 to 5.52	MPa
Screw Speed	30 to 90	rpm

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Recommended distributors for this material

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