Clariant Nylon 6/6 PA-123

Polyamide 66

Clariant Corporation

Message:

Clariant Nylon 6/6 PA-123 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-123 are:
flame retardant/rated flame
Flame Retardant
Impact modification
high strength
Good processability
Typical application areas include:
Automotive Industry
safety equipment
House
engineering/industrial accessories
military applications

General Information	
Additive	Impact modifier heat stabilizer
Features	Impact modification Rigidity, high High strength Impact resistance, good Workability, good Good corrosion resistance Good coloring Good chemical resistance Thermal Stability Good toughness Low or no water absorption Flame retardancy
Uses	Safety helmet Conveyor accessories Metal substitution Fasteners Military application Sporting goods Shell Medical/nursing supplies

Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.09	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.5	%	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	112		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	55.2	MPa	ASTM D638
Tensile Elongation (Yield)	60	%	ASTM D638
Flexural Modulus	2070	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	150	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	227	°C	ASTM D648
1.8 MPa, not annealed	71.1	°C	ASTM D648
CLTE - Flow	7.9E-5	cm/cm/°C	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength	18	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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