Clariant Nylon 6/6 PA-113C

Polyamide 66

Clariant Corporation

Message:

Clariant Nylon 6/6 PA-113C 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-113C are:
flame retardant/rated flame
heat stabilizer
Lubrication
The typical application field of Clariant Nylon 6/6 PA-113C is: wire and cable

General Information			
Additive	Molybdenum disulfide lubricant heat stabilizer		
Features	Thermal Stability Lubrication		
Agency Ratings	UL 94		
Forms	Particle		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.14	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.0	%	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	82.7	MPa	ASTM D638
Tensile Elongation (Yield)	15	%	ASTM D638
Flexural Modulus	2900	MPa	ASTM D790
Flexural Strength	138	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	480	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	193	°C	ASTM D648
1.8 MPa, not annealed	76.7	°C	ASTM D648
CLTE - Flow	6.8E-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	V-2		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. phase.Hold Pressure: 30% to 75% of injection pressure.Mold Temp. Target: 180°FScrew Speed Target: 75 RPM

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