

Clariant Nylon 6/6 PA-113M40

Polyamide 66
Clariant Corporation

Message:

Clariant Nylon 6/6 PA-113M40 is a polyamide 66 (nylon 66) material, which contains 40% mineral fillers. This product is available in North America and is processed by injection molding.

The main features of Clariant Nylon 6/6 PA-113M40 are:

flame retardant/rated flame
Flame Retardant
high strength
Good processability
Hard

Typical application areas include:

House
engineering/industrial accessories
marine applications
military applications
Automotive Industry

General Information	
Filler / Reinforcement	Mineral filler, 40% filler by weight
Additive	heat stabilizer
Features	Good dimensional stability
	Rigidity, high
	Rigid, good
	High strength
	Antistatic property
	Workability, good
	Good corrosion resistance
	Good coloring
	Good chemical resistance
	Thermal Stability
	Good toughness
	Low or no water absorption
	Flame retardancy
Uses	Ship application
	Metal substitution
	Military application
	Application in Automobile Field
	Sporting goods
	Shell
	Knob
	Medical/nursing supplies

Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.90	%	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
Class m	92		ASTM D785
Class r	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	103	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	5860	MPa	ASTM D790
Flexural Strength	138	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	43	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	249	°C	ASTM D648
1.8 MPa, not annealed	204	°C	ASTM D648
CLTE - Flow	3.6E-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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Recommended distributors for this material

Susheng Import & Export Trading Co., Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

