

# Clariant Nylon 6/6 PA-113G20

Polyamide 66  
Clariant Corporation

Message:

Clariant Nylon 6/6 PA-113G20 is a polyamide 66 (nylon 66) material, which contains a 20% glass fiber reinforced material. This product is available in North America and is processed by injection molding.

The main features of Clariant Nylon 6/6 PA-113G20 are:

flame retardant/rated flame

Flame Retardant

high strength

Good processability

Hard

Typical application areas include:

Wire and cable

military applications

Sporting goods

medical/health care

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 20% filler by weight		
Additive	heat stabilizer		
Features	Rigidity, high		
	High strength		
	Workability, good		
	Good corrosion resistance		
	Good coloring		
	Good chemical resistance		
	Thermal Stability		
	Good toughness		
	Low or no water absorption		
	Flame retardancy		
Uses	Metal substitution		
	Military application		
	Sporting goods		
	Medical/nursing supplies		
Agency Ratings	UL 94		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	0.50	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
Class m	93		ASTM D785
Class r	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	141	MPa	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	6210	MPa	ASTM D790
Flexural Strength	207	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	64	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	238	°C	ASTM D648
CLTE - Flow	4.1E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength	20	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

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