

# Clariant Nylon 6 PA-213XO12

Polyamide 6  
Clariant Corporation

Message:

Clariant Nylon 6 PA-213XO12 is a polyamide 6 (nylon 6) material. This product is available in North America and is processed by extrusion or injection molding.

The main features of the Clariant Nylon 6 PA-213XO12 are:

- flame retardant/rated flame
- Copolymer
- Good toughness
- Good flexibility
- Impact resistance

Typical application areas include:

- Wire and cable
- Hose

General Information	
Additive	heat stabilizer
Features	Copolymer
	Impact resistance, good
	Good melt strength
	Good flexibility
	Good wear resistance
	Thermal Stability
	Good toughness
Uses	Cable sheath
	Pipe fittings
Agency Ratings	UL 94
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.3	%	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	40		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	45.5	MPa	ASTM D638
Tensile Elongation (Yield)	200	%	ASTM D638

Flexural Modulus	1170	MPa	ASTM D790
Flexural Strength	46.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	46.1	°C	ASTM D648
Melting Temperature	216	°C	
CLTE - Flow	1.2E-4	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (1.59 mm)	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	249 - 274	°C	
Middle Temperature	249 - 274	°C	
Front Temperature	249 - 274	°C	
Processing (Melt) Temp	254 - 271	°C	
Melt Temperature (Aim)	266	°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



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