

Clariant Nylon 6/6 6604G33-L

Polyamide 66
Clariant Corporation

Message:

Clariant Nylon 6/6 6604G33-L is a Polyamide 66 (Nylon 66) material filled with 33% glass fiber. It is available in North America for injection molding. Important attributes of Clariant Nylon 6/6 6604G33-L are:
Impact Modified
Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,33% Filler by Weight		
Additive	Impact Modifier		
	Lubricant		
Features	General Purpose		
	Impact Modified		
	Lubricated		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	110	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	5860	MPa	ASTM D790
Flexural Strength	145	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	91	J/m	ASTM D256
Tensile Impact Strength	29.8	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	249	°C	
1.8 MPa, Unannealed	241	°C	
Melting Temperature	259	°C	
Injection	Nominal Value	Unit	
Drying Temperature	71.1 to 82.2	°C	
Suggested Max Regrind	25	%	
Rear Temperature	249 to 271	°C	
Middle Temperature	271 to 288	°C	

Front Temperature	282 to 299	°C
Nozzle Temperature	266 to 288	°C
Mold Temperature	71.1 to 104	°C
Injection Pressure	55.2 to 138	MPa
Back Pressure	0.00 to 1.03	MPa
Screw Speed	30 to 60	rpm

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Recommended distributors for this material

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