

# Clariant Nylon 6/6 6642M

Polyamide 66  
Clariant Corporation

Message:

Clariant Nylon 6/6 6642M is a Polyamide 66 (Nylon 66) material. It is available in North America for extrusion or injection molding. Important attributes of Clariant Nylon 6/6 6642M are:

High Viscosity  
Lubricated

General Information			
Additive	Molybdenum Disulfide Lubricant		
Features	High Viscosity		
	Lubricated		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	1.1	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	68.9	MPa	ASTM D638
Tensile Elongation (Break)	25	%	ASTM D638
Flexural Modulus	2760	MPa	ASTM D790
Flexural Strength	89.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	43	J/m	ASTM D256
Tensile Impact Strength	63.0	kJ/m <sup>2</sup>	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	193	°C	
1.8 MPa, Unannealed	96.1	°C	
Melting Temperature	257	°C	
Injection	Nominal Value	Unit	
Drying Temperature	71.1 to 82.2	°C	
Suggested Max Regrind	25	%	
Rear Temperature	249 to 266	°C	
Middle Temperature	271 to 288	°C	
Front Temperature	282 to 293	°C	
Nozzle Temperature	266 to 288	°C	

Mold Temperature	54.4 to 93.3	°C
Injection Pressure	34.5 to 103	MPa
Back Pressure	0.00 to 5.52	MPa
Screw Speed	30 to 90	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

