

Clariant Nylon 6/6 6604G13-L

Polyamide 66
Clariant Corporation

Message:

Clariant Nylon 6/6 6604G13-L is a Polyamide 66 (Nylon 66) material filled with 13% glass fiber. It is available in North America for injection molding. Important attributes of Clariant Nylon 6/6 6604G13-L are:
Impact Modified
Lubricated

General Information			
Filler / Reinforcement	Glass Fiber,13% 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	1.18	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	75.8	MPa	ASTM D638
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus	3100	MPa	ASTM D790
Flexural Strength	117	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	69	J/m	ASTM D256
Tensile Impact Strength	24.8	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	243	°C	
1.8 MPa, Unannealed	227	°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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