

Clariant 6604-HSL Nylon 66, Impact Modified, Heat Stabilized

Category : Polymer , Thermoplastic , Nylon , Nylon 66 , Nylon 66, Heat Stabilized

Material Notes:

Data provided by Clariant Masterbatches

Order this product through the following link:

http://www.lookpolymers.com/polymer_Clariant-6604-HSL-Nylon-66-Impact-Modified-Heat-Stabilized.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	ASTM D792
Linear Mold Shrinkage, Flow	0.015 cm/cm	0.015 in/in	ASTM D955

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	51.7 MPa	7500 psi	ASTM D638
Elongation at Yield	90 %	90 %	ASTM D638
Flexural Yield Strength	68.9 MPa	10000 psi	ASTM D790
Flexural Modulus	1.21 GPa	175 ksi	ASTM D790
Izod Impact, Notched	1.60 J/cm @Temperature 22.8 °C	3.00 ft-lb/in @Temperature 73.0 °F	ASTM D256

Thermal Properties	Metric	English	Comments
Deflection Temperature at 0.46 MPa (66 psi)	165 °C	329 °F	ASTM D648
Deflection Temperature at 1.8 MPa (264 psi)	70.0 °C	158 °F	ASTM D648

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	254 - 282 °C	490 - 540 °F	
Middle Barrel Temperature	260 - 288 °C	500 - 550 °F	
Front Barrel Temperature	266 - 293 °C	510 - 560 °F	
Nozzle Temperature	266 - 293 °C	510 - 560 °F	
Melt Temperature	266 - 288 °C	510 - 550 °F	
Mold Temperature	82.2 °C	180 °F	
Dry Time	2 - 4 hour	2 - 4 hour	to ensure moisture content is less

Processing Properties	@Temperature 79.4 °C Metric	@Temperature 175 °F English	than 0.2% Comments
Injection Pressure	4.96 - 8.27 MPa	720 - 1200 psi	Secondary
	8.27 - 13.8 MPa	1200 - 2000 psi	Initial
Back Pressure	0.345 - 0.689 MPa	50.0 - 100 psi	
Shot Size	30 - 80 %	30 - 80 %	
Screw Speed	20 - 100 rpm	20 - 100 rpm	

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