Chemlon® E-66 GF30

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, June 30, 2017

General Information

Product Description

Chemlon® E-66 GF30 is an economy range 30% glass fibre reinforced Nylon 66 compound.
It is available in natural or black versions.

General		
Material Status	• Commercial: Active	
Availability	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Appearance	• Black	• Natural Color
Processing Method	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm³	ISO 1183
Molding Shrinkage [2]	0.30 to 0.70	%	Internal Method
Water Absorption (Equilibrium, 73°F, 50% RH)	1.8	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.16E+6	psi	ISO 527-2
Tensile Stress (Break)	23900	psi	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	1.02E+6	psi	ISO 178
Flexural Stress [3]	28300	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact Strength	3.3	ft·lb/in²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (66 psi, Unannealed)	> 464	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	446	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	2.0	hr
Rear Temperature	527 to 572	°F
Middle Temperature	527 to 572	°F
Front Temperature	527 to 572	°F
Processing (Melt) Temp	< 572	°F
Mold Temperature	176 to 194	°F
Injection Rate	Fast	
Screw Speed	50 to 200	rpm

Injection Notes

Back pressure: Low
Injection pressure: High

The material is supplied dry and ready to mould in sealed, moisture proof sacks. No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present. Should drying become necessary, two hours at 80°C in a dehumidifying drier is recommended. The use of air circulating driers is not generally recommended, as longer drying times are often required, with greater potential for product oxidation and yellowing. Drying temperatures should not exceed 80°C.

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Notes

[1] Typical properties: these are not to be construed as specifications.

[2] Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions. The range values stated were determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).

[3] At Break

Teknor Apex Company
Corporate Headquarters

In U.S. for Vinyls, TPEs, Colorants, Engineered Thermoplastics (Chem Polymer)
505 Central Avenue
Pawtucket, Rhode Island 02861 U.S.

Phone: 401-725-8000
Fax: 401-725-8095
Toll Free (U.S. only) 800-556-3864

info@teknorapex.com

Teknor Apex U.K. Ltd.

Tat Bank Road
Oldbury, West Midlands B69 4NH England

Phone: (44) 121-665-2100
Fax: (44) 121-544-5530

etpsales@teknorapex.co.uk

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