

# Chemlon® 66GF4H

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, June 30, 2017

## General Information

### Product Description

66GF4H is a 20% glass fibre reinforced, heat stabilised nylon 66 that offers good mechanical performance coupled with good surface finish and flow.

### General

Material Status	• Commercial: Active		
Availability	• Europe		
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Good Flow	• Good Surface Finish	• Heat Stabilized
Processing Method	• Injection Molding		

## ASTM & ISO Properties<sup>1</sup>

Physical	Dry	Conditioned	Unit	Test Method
Density	1.30	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage <sup>2</sup>	0.70 to 1.4	--	%	Internal Method
Water Absorption Equilibrium, 73°F, 50% RH	2.0	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	870000	580000	psi	ISO 527-2
Tensile Stress	18900	14500	psi	ISO 527-2
Tensile Strain (Break)	5.0	10	%	ISO 527-2
Flexural Modulus	870000	580000	psi	ISO 178
Flexural Stress	24700	13100	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength	19	No Break	ft-lb/in <sup>2</sup>	ISO 179/1eU
Notched Izod Impact Strength	2.9	7.1	ft-lb/in <sup>2</sup>	ISO 180/A
Thermal	Dry	Conditioned	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
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+14	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+13	ohms-cm	IEC 60093
Electric Strength (0.118 in)	410	--	V/mil	IEC 60243-1
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating 0.06 in, Teknor Apex test result	HB	--		UL 94

## Processing Information

### Injection

	Dry	Unit
Drying Temperature	176 °F	
Drying Time	2.0 hr	
Rear Temperature	518 to 554 °F	
Middle Temperature	518 to 554 °F	
Front Temperature	518 to 554 °F	

Revision Date: 3/17/2014

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Injection	Dry Unit
Processing (Melt) Temp	518 to 554 °F
Mold Temperature	176 to 194 °F
Injection Rate	Fast
Back Pressure	Low
Screw Speed	Moderate

### Injection Notes

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.

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are 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).

#### 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

#### 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

info@teknorapex.com

上海松翰塑化科技有限公司  
TEKNOR APEX 特诺尔爱佩斯 一级分销商  
teknorapex.shshsj.com 联系电话: 021-58958519

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