

Chemlon® 66GF6L

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, June 30, 2017

General Information

Product Description

66GF6L is a 33% glass fibre reinforced nylon 66 that offers good mechanical performance, coupled with good surface finish and flow. It is a heat & light stabilised grade, suitable for extended use in outdoor, elevated service temperature applications.

General

Material Status	• Commercial: Active
Availability	• Europe
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight
Additive	• Heat Stabilizer • UV Stabilizer
Features	• Good Flow • Heat Stabilized • Weather Resistant • Good Surface Finish • Light Stabilized
Uses	• High Temperature Applications • Outdoor Applications
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.40	--	g/cm ³	ISO 1183
Molding Shrinkage ²	0.60 to 1.5	--	%	Internal Method
Water Absorption Equilibrium, 73°F, 50% RH	1.7	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.38E+6	1.06E+6	psi	ISO 527-2
Tensile Stress	26100	20300	psi	ISO 527-2
Tensile Strain (Break)	3.0	4.0	%	ISO 527-2
Flexural Modulus	1.41E+6	841000	psi	ISO 178
Flexural Stress	39200	21800	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength	29	No Break	ft·lb/in ²	ISO 179/1eU
Notched Izod Impact Strength	5.7	17	ft·lb/in ²	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	464	--	°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

Revision Date: 3/17/2014

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Injection	Dry Unit
Rear Temperature	518 to 554 °F
Middle Temperature	518 to 554 °F
Front Temperature	518 to 554 °F
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

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

² 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



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