Chemlon® 66M8

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, June 30, 2017

General Information

Product Description

66M8 is a 40% mineral filled injection moulding grade of nylon 66.

General	
Material Status	• Commercial: Active
Availability	• Europe
Filler / Reinforcement	• Mineral, 40% Filler by Weight
Features	• Good Stiffness
Processing Method	• Injection Molding

ASTM & ISO Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.45	--	g/cm³	ISO 1183
Molding Shrinkage [2]	1.0 to 1.4	--	%	Internal Method
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	827000	363000	psi	ISO 527-2
Tensile Stress	14500	8120	psi	ISO 527-2
Flexural Stress	23200	11200	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	4.3	4.8	ft·lb/in²	ISO 179/1eA
Charpy Unnotched Impact Strength	19	No Break	ft·lb/in²	ISO 179/1eU
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/B
66 psi, Unannealed	464	--	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	329	--	°F	
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
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Flame Rating				UL 94
0.06 in, Teknor Apex test result	HB	--		
Oxygen Index	24	--	%	ISO 4589-2

Processing Information

Injection	Dry	Unit
Drying Temperature	176	°F
Drying Time	2.0	hr
Rear Temperature	527 to 563	°F
Middle Temperature	527 to 563	°F
Front Temperature	527 to 563	°F
Processing (Melt) Temp	536 to 563	°F
Mold Temperature	176 to 194	°F
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Revision Date: 3/17/2014

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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).

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