

Chemlon® 109-18 G

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, June 30, 2017

General Information

General

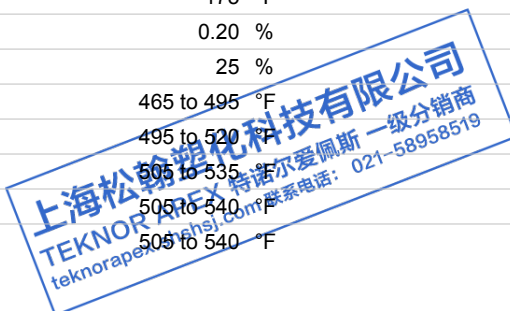
Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 18% Filler by Weight
Features	• High Impact Resistance
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow	4.0E-3 to 7.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	15500	psi	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Tensile Elongation (Break)	6.0	%	ASTM D638
Flexural Modulus	600000	psi	ASTM D790
Flexural Strength	21500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	3.2	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	430	°F	ASTM D648
Melting Temperature	495	°F	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+18	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	280	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	21	%	ASTM D2863
FMVSS Flammability	PASSES		FMVSS 302

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	465 to 495	°F
Middle Temperature	495 to 520	°F
Front Temperature	505 to 535	°F
Nozzle Temperature	505 to 540	°F
Processing (Melt) Temp	505 to 540	°F



Notes

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

Revision Date: 4/28/2010

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