

Chemlon® 109-33 GH

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, 33% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Creep Resistant	• Good Stiffness	• High Strength
	• Good Impact Resistance	• Good Toughness	
	• Good Processability	• Heat Stabilized	
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

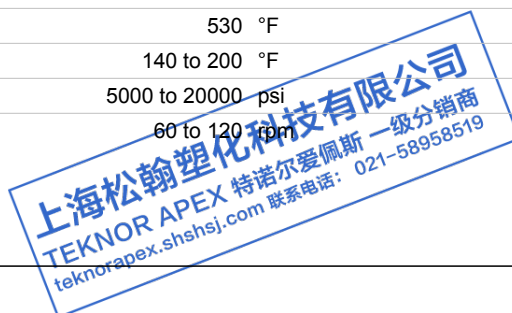
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34		ASTM D792
Molding Shrinkage - Flow	3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	20000	psi	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength	29500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	3.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	475	°F	
Melting Temperature	490	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150 to 180	°F
Suggested Max Moisture	0.20	%
Rear Temperature	560	°F
Middle Temperature	540	°F
Front Temperature	530	°F
Nozzle Temperature	530	°F
Mold Temperature	140 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

Notes

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



Revision Date: 12/11/2008

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