

Chemlon® 140 MH

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, June 30, 2017

General Information

General

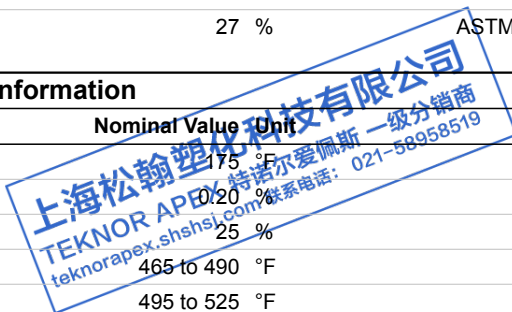
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Mineral, 40% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Fast Molding Cycle	• High Rigidity	
	• Heat Stabilized	• Low Warpage	
Automotive Specifications	• GM GMP.PA66.007 Color: Black	• GM GMP.PA66.007 Color: Natural	
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50		ASTM D792
Molding Shrinkage - Flow	7.0E-3 to 0.012	in/in	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	13000	psi	ASTM D638
Tensile Elongation (Yield)	1.8	%	ASTM D638
Tensile Elongation (Break)	2.0	%	ASTM D638
Flexural Modulus	950000	psi	ASTM D790
Flexural Strength	21000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	0.90	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	395	°F	ASTM D648
Melting Temperature	495	°F	
CLTE - Flow	2.6E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	380	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	27	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrid	25	%
Rear Temperature	465 to 490	°F
Middle Temperature	495 to 525	°F
Front Temperature	505 to 540	°F



Revision Date: 12/11/2008

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Injection	Nominal Value	Unit
Nozzle Temperature	505 to 535	°F
Processing (Melt) Temp	505 to 535	°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.

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