

Chemlon® 104 HU

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, June 30, 2017

General Information

General

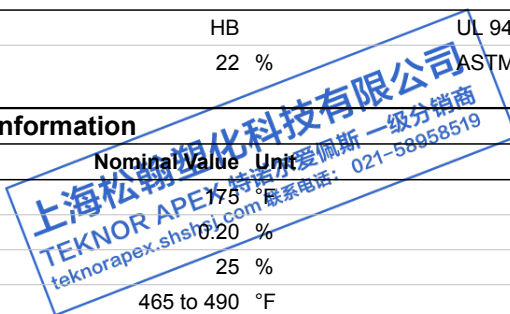
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Heat Stabilizer • Impact Modifier	• Lubricant • UV Stabilizer	
Features	• Good Toughness • Heat Stabilized	• Impact Modified • Lubricated	• Medium Viscosity • UV Resistant
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12		ASTM D792
Molding Shrinkage - Flow	0.010 to 0.017	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	9300	psi	ASTM D638
Tensile Elongation (Yield)	3.5	%	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	10800	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F	2.0	ft-lb/in	
73°F	3.2	ft-lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	395	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	170	°F	ASTM D648
Melting Temperature	495	°F	
CLTE - Flow	3.9E-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)	430	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	22	%	ASTM D2863

Processing Information

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



Revision Date: 12/11/2008

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Injection	Nominal Value	Unit
Front Temperature	505 to 540	°F
Nozzle Temperature	505 to 535	°F
Processing (Melt) Temp	505 to 535	°F

Notes

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

Teknor Apex Company Corporate Headquarters

*In U.S. for Vinyls, TPEs, Colorants,
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