

# Chemlon® N66A

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, June 30, 2017

## General Information

### Product Description

N66A is a general purpose unfilled injection moulding grade of nylon 66.

### General

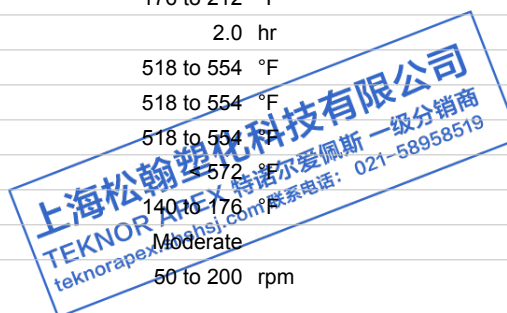
Material Status	• Commercial: Active
Availability	• Europe • North America
Features	• General Purpose
Uses	• General Purpose
Processing Method	• Injection Molding

## ASTM & ISO Properties <sup>1</sup>

Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage <sup>2</sup>	1.5 to 2.0	--	%	Internal Method
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	406000	218000	psi	ISO 527-2
Tensile Stress (Yield)	11600	7250	psi	ISO 527-2
Flexural Modulus	435000	131000	psi	ISO 178
Flexural Stress <sup>3</sup>	13100	3630	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact Strength	2.4	No Break	ft-lb/in <sup>2</sup>	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature 66 psi, Unannealed	419	383	°F	ISO 75-2/B
Heat Deflection Temperature 264 psi, Unannealed	194	167	°F	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+15	1.0E+10	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+12	ohms·cm	IEC 60093
Electric Strength (0.118 in)	460	300	V/mil	IEC 60243-1
Relative Permittivity (1 MHz)	3.80	4.30		IEC 60250
Dissipation Factor (1 MHz)	0.020	0.080		IEC 60250
Comparative Tracking Index	> 600	> 600	V	IEC 60112

## Processing Information

Injection	Dry Unit
Drying Temperature	176 to 212 °F
Drying Time	2.0 hr
Rear Temperature	518 to 554 °F
Middle Temperature	518 to 554 °F
Front Temperature	518 to 554 °F
Processing (Melt) Temp	572 °F
Mold Temperature	140 to 176 °F
Injection Rate	Moderate
Screw Speed	50 to 200 rpm



Revision Date: 3/20/2014

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### Injection Notes

Back Pressure: Low  
Injection Pressure: Medium

No drying is necessary unless the material has been exposed to air for longer than 3 hours.

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions. The range values stated were 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).

<sup>3</sup> At conventional deflection

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