

Chemlon® 104 H

Teknor Apex Company (Chem Polymer) - Polyamide 66

Wednesday, May 2, 2018

General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• General Purpose • Good Impact Resistance • Good Processability	• Good Toughness • Heat Stabilized • High Strength	• Impact Modified
Automotive Specifications	<ul style="list-style-type: none"> • CHRYSLER MS-DB-41 CPN3955 Color: NT001 Natural • CHRYSLER MS-DB-41 Type PA CPN1826 Color: BK001 Black • FORD ESA-M4D267-A • FORD ESA-M4D387-A • FORD ESB-M4D178-A2 • FORD ESK-M4D178-A2 • FORD WSB-M4D706-A • FORD WSB-M4D706-A2 • FORD WSK-M4D706-A • FORD WSK-M4D706-A2 • FORD WSS-M4D706-B1 • GM GMP.PA66.015 Color: Natural • GM GMW16447P-PA66-T2 		
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.2 to 2.0	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	62.1	MPa	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break)	35	%	ASTM D638
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	140	J/m	
23°C	240	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed	213	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed	79.4	°C	ASTM D648
Melting Temperature	257	°C	
CLTE - Flow	7.1E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257

Revision Date: 12/11/2008

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Electrical	Nominal Value	Unit	Test Method
Dielectric Strength (3.00 mm)	17	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746

Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94
Oxygen Index	22	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	79	°C
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	241 to 254	°C
Middle Temperature	257 to 274	°C
Front Temperature	263 to 282	°C
Nozzle Temperature	263 to 279	°C
Processing (Melt) Temp	263 to 279	°C

Notes

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

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