

# Chemlon® A25

Polyamide 66

Teknor Apex Company (Chem Polymer)

## Message:

A25 is a standard, unfilled injection moulding grade of nylon 66.

General Information				
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage <sup>1</sup>	1.1 - 1.7	--	%	Internal method
Water Absorption (23°C, 24 hr)	1.2	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2800	1600	MPa	ISO 527-2
Tensile Stress (Yield)	75.0	60.0	MPa	ISO 527-2
Flexural Modulus	2900	1000	MPa	ISO 178
Flexural Stress <sup>2</sup>	95.0	35.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	13 kJ/m <sup>2</sup>	No Break		ISO 179
Charpy Unnotched Impact Strength	No Break	No Break		ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	225	205	°C	ISO 75-2/B
1.8 MPa, not annealed	90.0	80.0	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+14	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+15	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	18	12	kV/mm	IEC 60243-1
Relative Permittivity	3.80	4.30		IEC 60250
Dissipation Factor (1 MHz)	0.020	0.080		IEC 60250
Comparative Tracking Index	> 600	> 600	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.52 mm)	V-2	--		UL 94
Glow Wire Flammability Index (1.50 mm)	750	--	°C	IEC 60695-2-12

Oxygen Index	27	--	%	ISO 4589-2
Injection	Dry	Unit		
Drying Temperature	80.0 - 100		°C	
Drying Time	2.0		hr	
Rear Temperature	270 - 290		°C	
Middle Temperature	270 - 290		°C	
Front Temperature	270 - 290		°C	
Processing (Melt) Temp	< 300		°C	
Mold Temperature	60.0 - 80.0		°C	
Injection Rate	Fast			
Screw Speed	50 - 200		rpm	
Injection instructions				
No drying is necessary unless the material has been exposed to air for longer than three hours.Back Pressure: LowInjection Pressure: High				
NOTE				

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).

1.

2.

At conventional deflection

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