Chemlon® AS408

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

AS408 is a 40% glass-sphere filled, heat stabilised injection moulding grade of nylon 66. It has lower differential shrinkage and warpage and so is often suitable for use in applications requiring greater dimensional accuracy.

General Information	
Filler / Reinforcement	Glass beads, 40% filler by weight
Additive	heat stabilizer
Features	Low warpage Rigid, good Thermal Stability Low shrinkage
Processing Method	Injection molding

Physical	Dry	Conditioned	Unit	Test Method
Density	1.44	--	g/cm³	ISO 1183
Molding Shrinkage [1]	0.90 - 1.5	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	1.5	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	6300	3200	MPa	ISO 527-2
Tensile Stress	90.0	45.0	MPa	ISO 527-2
Flexural Modulus	5000	2300	MPa	ISO 178
Flexural Stress	155	75.0	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	5.0	8.0	kJ/m²	ISO 179/1eA
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	240	--	°C	ISO 75-2/B
1.8 MPa, not annealed	220	--	°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+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	15	13	kV/mm	IEC 60243-1
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Flame Rating (1.50 mm, Teknor Apex test result)	HB	--		UL 94

Glow Wire Flammability Index (1.50 mm)	650	--	°C	IEC 60695-2-12
Oxygen Index	27	--	%	ISO 4589-2

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	hr
Rear Temperature	275 - 295	°C
Middle Temperature	275 - 295	°C
Front Temperature	275 - 295	°C
Processing (Melt) Temp	280 - 295	°C
Mold Temperature	80.0 - 90.0	°C
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Injection instructions

No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.

NOTE

1.	Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are 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).

Recommended distributors for this material

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