

# Chemlon® E-66

Polyamide 66

Teknor Apex Company (Chem Polymer)

## Message:

Chemlon® E-66 is an economy range Nylon 66 injection moulding grade.  
It is available in natural or black versions.

General Information			
Appearance	Black		
	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage <sup>1</sup>	1.5 - 2.0	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.5	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2900	MPa	ISO 527-2
Tensile Stress (Yield)	80.0	MPa	ISO 527-2
Tensile Strain (Yield)	4.5	%	ISO 527-2
Flexural Modulus	2800	MPa	ISO 178
Flexural Stress	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	3.5	kJ/m <sup>2</sup>	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	90.0	°C	ISO 75-2/A
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°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	80.0 - 90.0	°C	
Injection Rate	Fast		
Screw Speed	50 - 200	rpm	
Injection instructions			

Back pressure: LowInjection pressure: HighThe material is supplied dry and ready to mould in sealed, moisture proof sacks. 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. Should drying become necessary, two hours at 80°C in a dehumidifying drier is recommended. The use of air circulating driers is not generally recommended, as longer drying times are often required, with greater potential for product oxidation and yellowing. Drying temperatures should not exceed 80°C.

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.

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection.All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519  
Phone: +86 13424755533  
Email: sales@su-jiao.com  
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

