

Chemlon® 66GF4H

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

66GF4H is a 20% glass fibre reinforced, heat stabilised nylon 66 that offers good mechanical performance coupled with good surface finish and flow.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 20% filler by weight		
Additive		heat stabilizer		
Features		Good liquidity		
		Thermal Stability		
		Excellent appearance		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.30	--	g/cm ³	ISO 1183
Molding Shrinkage ¹	0.70 - 1.4	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.0	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	6000	4000	MPa	ISO 527-2
Tensile Stress	130	100	MPa	ISO 527-2
Tensile Strain (Break)	5.0	10	%	ISO 527-2
Flexural Modulus	6000	4000	MPa	ISO 178
Flexural Stress	170	90.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Unnotched Impact Strength	40 kJ/m ²	No Break		ISO 179/1eU
Notched Izod Impact	6.0	15	kJ/m ²	ISO 180/A
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	230	--	°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+13	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	16	--	kV/mm	IEC 60243-1
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method

Flame Rating (1.50 mm, Teknor Apex test result)	HB	--	UL 94
Injection	Dry	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	270 - 290		°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).

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