

Chemlon® 104 HU

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

Chemlon® 104 HU is a Polyamide 66 (Nylon 66) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Chemlon® 104 HU are:

- Flame Rated
- Good Toughness
- Good UV Resistance
- Heat Stabilizer
- Impact Modified

General Information			
Additive	Heat Stabilizer		
	Impact Modifier		
	Lubricant		
	UV Stabilizer		
Features	Good Toughness		
	Good UV Resistance		
	Heat Stabilized		
	Impact Modified		
	Lubricated		
	Medium Viscosity		
Appearance	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.0 to 1.7	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	64.1	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	3.5	%	
Break	20	%	
Flexural Modulus	2280	MPa	ASTM D790
Flexural Strength	74.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	110	J/m	

23°C	170	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	202	°C	
1.8 MPa, Unannealed	76.7	°C	
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
Dielectric Strength (3.00 mm)	17	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.810 mm)	HB		UL 94
Oxygen Index	22	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Suggested Max Moisture	0.20	%	
Suggested Max Regrind	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	

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