

Chemlon® 104-13 G

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

Chemlon® 104-13 G is a Polyamide 66 (Nylon 66) material filled with 13% glass fiber. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Chemlon® 104-13 G are:

Flame Rated

Impact Modified

General Information			
Filler / Reinforcement	Glass Fiber,13% Filler by Weight		
Additive	Impact Modifier		
Features	Impact Modified		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (285°C/2.16 kg)	20	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.40 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	96.5	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	5.0	%	
Break	7.0	%	
Flexural Modulus	3790	MPa	ASTM D790
Flexural Strength	134	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	215	°C	ASTM D648
Melting Temperature	257	°C	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms · cm	ASTM D257
Dielectric Strength (3.00 mm)	11	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	500	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.810 mm)	HB		UL 94
FMVSS Flammability	PASSES		FMVSS 302
Injection	Nominal Value	Unit	

Drying Temperature	79.4	°C
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	241 to 257	°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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Recommended distributors for this material

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