Chemlon® 66A

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

66A is a general purpose unfilled injection moulding grade of nylon 66.

General Information				
Features	General			
Uses	General			
Forms	Particle			
Processing Method	Injection molding			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.13 - 1.15	--	g/cm³	ISO 1183
Molding Shrinkage [1]	1.4 - 1.9	--	%	Internal method
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	2700	1700	MPa	ISO 527-2
Tensile Stress (Yield)	75.0	55.0	MPa	ISO 527-2
Flexural Modulus	2500	750	MPa	ISO 178
Flexural Stress [2]	75.0	20.0	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	9.5 kJ/m²	No Break		ISO 179
Charpy Unnotched Impact Strength	No Break	No Break		ISO 179
Notched Izod Impact	5.0	9.0	kJ/m²	ISO 180
Unnotched Izod Impact Strength	35 kJ/m²	No Break		ISO 180
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	185	175	°C	ISO 75-2/B
1.8 MPa, not annealed	90.0	60.0	°C	ISO 75-2/A
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	17	11	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.60	--		IEC 60250
Dissipation Factor (1 MHz)	0.010	0.040		IEC 60250
Comparative Tracking Index	> 600	> 600	V	IEC 60112

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (Teknor Apex test result)	HB	--		UL 94
Oxygen Index	24	--	%	ISO 4589-2

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	< 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 dryer is recommended. Alternatively material may be dried for up to six hours in a hopper drier or an air circulating oven at a temperature not exceeding 80°C.

NOTE	
1.	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).
2.	At conventional deflection

Recommended distributors for this material

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