

Chemlon® 66AH

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

66AH is a general purpose, heat stabilised unfilled injection moulding grade of nylon 66.

General Information			
Additive	heat stabilizer		
Features	Thermal Stability		
	General		
Uses	General		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage ¹	1.4 - 1.9	%	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	75.0	MPa	ISO 527-2
Flexural Modulus	2500	MPa	ISO 178
Flexural Stress	75.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	9.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break		ISO 179/1eU
Notched Izod Impact	6.0	kJ/m ²	ISO 180/A
Unnotched Izod Impact Strength	35	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	185	°C	ISO 75-2/B
1.8 MPa, not annealed	90.0	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms · cm	IEC 60093
Dielectric Strength (3.00 mm)	17	kV/mm	IEC 60243-1
Comparative Tracking Index	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm, Teknor Apex test result)	HB		UL 94
Oxygen Index	24	%	ISO 4589-2

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	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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