

Chemlon® 66M8

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

66M8 is a 40% mineral filled injection moulding grade of nylon 66.

General Information				
Filler / Reinforcement		Mineral filler, 40% filler by weight		
Features		Rigid, good		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.45	--	g/cm ³	ISO 1183
Molding Shrinkage ¹	1.0 - 1.4	--	%	Internal method
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5700	2500	MPa	ISO 527-2
Tensile Stress	100	56.0	MPa	ISO 527-2
Flexural Stress	160	77.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	9.0	10	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	40 kJ/m ²	No Break		ISO 179/1eU
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	165	--	°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
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
Oxygen Index	24	--	%	ISO 4589-2
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	2.0		hr	
Rear Temperature	275 - 295		°C	
Middle Temperature	275 - 295		°C	
Front Temperature	275 - 295		°C	

Processing (Melt) Temp	280 - 295	°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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