

Chemlon® 104

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

Chemlon® 104 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 are:

Flame Rated

Impact Resistant

Typical application of Chemlon® 104: Automotive

General Information			
Features	General Purpose		
	Medium Impact Resistance		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.2 to 2.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	62.1	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	5.0	%	
Break	35	%	
Flexural Modulus	2210	MPa	ASTM D790
Flexural Strength	72.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	140	J/m	
23°C	240	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	213	°C	
1.8 MPa, Unannealed	79.4	°C	
Melting Temperature	257	°C	DSC
CLTE - Flow	7.1E-5	cm/cm/°C	ASTM D696
RTI Elec			UL 746
0.810 mm	65.0	°C	
1.50 mm	65.0	°C	
3.00 mm	65.0	°C	
RTI Imp			UL 746

0.810 mm	65.0	°C	
1.50 mm	65.0	°C	
3.00 mm	65.0	°C	
RTI Str			UL 746
0.810 mm	65.0	°C	
1.50 mm	65.0	°C	
3.00 mm	65.0	°C	
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
Comparative Tracking Index (CTI)	600	V	UL 746
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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