

Chemlon® 104-13 GH

Teknor Apex Company (Chem Polymer) - Polyamide 66

Tuesday, December 19, 2017

General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 13% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Good Dimensional Stability • Good Impact Resistance	• Good Processability • Good Toughness	• Heat Stabilized • High Strength
Automotive Specifications	• CHRYSLER MS-DB-41 CPN1987 Color: BK001 Black • FORD ESA-M4D189-A	• GM GMP.PA66.057 Color: Black • GM GMP.PA66.057 Color: Natural	
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / 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
Water Absorption (24 hr)	1.2	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	96.5	MPa	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break)	7.0	%	ASTM D638
Flexural Modulus	3790	MPa	ASTM D790
Flexural Strength	134	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	69	J/m	
23°C	130	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	215	°C	ASTM D648
Melting Temperature	257	°C	
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 (0.8 mm)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	79	°C
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%

Revision Date: 12/11/2008

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Injection	Nominal Value	Unit
Rear Temperature	241 to 257	°C
Middle Temperature	263 to 274	°C
Front Temperature	263 to 282	°C
Nozzle Temperature	263 to 279	°C
Processing (Melt) Temp	263 to 279	°C
Mold Temperature	60 to 93	°C
Injection Pressure	34.5 to 138	MPa
Screw Speed	60 to 120	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

Teknor Apex Company Corporate Headquarters

*In U.S. for Vinyls, TPEs, Colorants,
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