

# Chemlon® 140 MH

Polyamide 66

Teknor Apex Company (Chem Polymer)

## Message:

Chemlon® 140 MH is a Polyamide 66 (Nylon 66) material filled with 40% mineral. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Chemlon® 140 MH are:

- Flame Rated
- Fast Molding Cycle
- Heat Stabilizer
- Rigid
- Warp Resistant

Typical application of Chemlon® 140 MH: Automotive

General Information			
Filler / Reinforcement	Mineral,40% Filler by Weight		
Additive	Heat Stabilizer		
Features	Fast Molding Cycle		
	Heat Stabilized		
	High Rigidity		
	Low Warpage		
Appearance	Black		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.50	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.70 to 1.2	%	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	89.6	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	1.8	%	
Break	2.0	%	
Flexural Modulus	6550	MPa	ASTM D790
Flexural Strength	145	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	48	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	202	°C	ASTM D648

Melting Temperature	257	°C	
CLTE - Flow	4.6E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (3.00 mm)	15	kV/mm	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.810 mm)	HB		UL 94
Oxygen Index	27	%	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	
Mold Temperature	60.0 to 93.3	°C	
Injection Pressure	34.5 to 138	MPa	
Screw Speed	60 to 120	rpm	

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#### Recommended distributors for this material

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