

# Chemlon® N66AN

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

N66AN is a fast cycling, general purpose unfilled injection moulding grade of nylon 66.

General Information				
Features		Fast molding cycle		
		General		
Uses		General		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage <sup>1</sup>	1.5 - 2.0	--	%	Internal method
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2800	1500	MPa	ISO 527-2
Tensile Stress (Yield)	80.0	60.0	MPa	ISO 527-2
Flexural Modulus	3000	1000	MPa	ISO 178
Flexural Stress <sup>2</sup>	95.0	35.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	7.0 kJ/m <sup>2</sup>	No Break		ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	220	200	°C	ISO 75-2/B
1.8 MPa, not annealed	90.0	75.0	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+15	1.0E+10	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+12	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	18	12	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	3.80	4.30		IEC 60250
Dissipation Factor (1 MHz)	0.020	0.080		IEC 60250
Comparative Tracking Index	> 600	> 600	V	IEC 60112
Injection	Dry	Unit		
Drying Temperature	80.0 - 100		°C	
Drying Time	2.0		hr	
Rear Temperature	270 - 290		°C	

Middle Temperature	270 - 290	°C
Front Temperature	270 - 290	°C
Processing (Melt) Temp	< 300	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Moderate	
Screw Speed	50 - 200	rpm

#### Injection instructions

Back Pressure: Low to medium Injection Pressure: Medium No drying is necessary unless the material has been exposed to air for longer than 3 hours.

#### NOTE

Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions. The range values stated were 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).

1.

2.

At conventional deflection

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