

Chemlon® 109-14 GH

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

Chemlon 109-14 GH is an impact modified, 14% glass fibre filled, heat stabilised injection moulding grade of nylon 66. It is formulated to offer an excellent balance between impact strength and rigidity.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 14% filler by weight		
Additive	Impact modifier heat stabilizer		
Features	Impact modification Rigid, good Thermal Stability Good toughness		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Water Absorption (Equilibrium, 23°C, 50% RH)	1.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4700	MPa	ISO 527-2
Tensile Stress	105	MPa	ISO 527-2
Tensile Strain (Break)	4.0	%	ISO 527-2
Flexural Modulus	4000	MPa	ISO 178
Flexural Stress	130	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	14	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	75	kJ/m ²	ISO 179/1eU
Notched Izod Impact	13	kJ/m ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	> 240	°C	ISO 75-2/B
1.8 MPa, not annealed	230	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms · cm	IEC 60093
Comparative Tracking Index	500	V	IEC 60112
Injection	Nominal Value	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.

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