

Chemlon® 104 H

Polyamide 66

Teknor Apex Company (Chem Polymer)

Message:

Chemlon® 104 H 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 H are:

Flame Rated

Good Processability

Good Toughness

Heat Stabilizer

High Strength

Typical application of Chemlon® 104 H: Automotive

General Information			
Additive	Heat Stabilizer		
	Impact Modifier		
Features	General Purpose		
	Good Impact Resistance		
	Good Processability		
	Good Toughness		
	Heat Stabilized		
	High Strength		
	Impact Modified		
Appearance	Black		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.2 to 2.0	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	62.1	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	5.0	%	
Break	35	%	
Flexural Modulus	2280	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	
CLTE - Flow	7.1E-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)	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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