TEKNOR APEX

Chemlon® 133 GH

Teknor Apex Company (Chem Polymer) - Polyamide 66

Friday, February 24, 2017

General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Additive	• Heat Stabilizer	• Lubricant	
Features	• Good Processability • Good Toughness	• Heat Stabilized • High Strength	• Lubricated
Automotive Specifications	• 3M 11-0003-5762-1 • CHRYSLER MS-DB-41 CPN1900 Color: BK001 Black • CHRYSLER MS-DB-41 CPN2224 Color: Non-matched Color	• FORD ESB-M4D133-A • FORD ESB-M4D89-A • FORD WSK-M4D663-A	• GM GMP.PA66.013 Color: Natural • GM GMW3038P-PA66-GF35H
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties [1]

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow	1.5E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength	25500	psi	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.25E+6	psi	ASTM D790
Flexural Strength	40000	psi	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (73°F)	2.0	ft·lb/in	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	480	°F	
Melting Temperature	495	°F	
CLTE - Flow	2.8E-5	in/in/°F	ASTM D696
RTI Elec			UL 746
0.03 in	266	°F	
0.06 in	266	°F	
0.12 in	266	°F	
RTI Imp			UL 746
0.03 in	203	°F	
0.06 in	230	°F	
0.12 in	230	°F	
RTI Str			UL 746
0.03 in	266	°F	
0.06 in	266	°F	
0.12 in	266	°F	

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Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	410	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.03 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	475 to 495	°F
Middle Temperature	505 to 525	°F
Front Temperature	515 to 540	°F
Nozzle Temperature	515 to 540	°F
Processing (Melt) Temp	505 to 540	°F
Mold Temperature	140 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

Notes

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

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