



A TEKNO APEX COMPANY



Grade : **Chemlon™ 109**
Type : **Nylon 6/6**
Approval listing : **-**
Processing methods : **Injection Molding**
Filler / Reinforcement : **None**

PROPERTY	TEST METHOD	UNITS	DATA
Specific Gravity	ASTM D792	-	1.09
Linear Mold Shrinkage ⁽¹⁾	ASTM D955	%	1.8 – 2.4
Hardness Rockwell	ASTM D785	-	R105
Water Absorption @ 24 hrs	ASTM D570	%	1.2
Tensile Strength	ASTM D638	psi	7,500
Tensile Elongation at Break	ASTM D638	%	50
Tensile Elongation at Yield	ASTM D638	%	4.5
Flexural Modulus	ASTM D790	psi	250,000
Flexural Strength	ASTM D790	psi	7,000
Notched Izod Impact @ 23 °C	ASTM D256	ftlb/in	18
Notched Izod Impact @ -40 °C	ASTM D256	ftlb/in	4.5
Heat Deflection Temperature (264 psi)	ASTM D648	°F	145
Heat Deflection Temperature (66 psi)	ASTM D648	°F	•
Melting Point	ASTM D789	°F	495
Coef' Linear Thermal Expansion	ASTM D696	10 ⁻⁵ /K	•
Melt Flow Index	ASTM D1238	g/10 min	•
Dielectric Strength (3mm)	ASTM D149	KV/mm	10
Comparative Tracking Index		V	600
Volume resistivity	ASTM D257	Ohm cm	10 ¹³
Limiting Oxygen Index	ASTM D2863	%	21
UL 94 Flammability ⁽²⁾ (in thickness)		-	HB ⁽²⁾ (0.0295)
FMVSS-302		-	•

Grade : Chemlon™ 109

PROPERTY		UNITS	DATA
Relative Temp. Index elec'	@ 0.0295 in	°F	•
Relative Temp. Index mech w/imp	@ 0.0295 in	°F	•
Relative Temp. Index mech wo/imp	@ 0.0295 in	°F	•

PROCESSING:

Drying Temperature	°F	175
Rear Temperature	°F	465 - 495
Middle Temperature	°F	495 - 520
Front Temperature	°F	505 - 535
Nozzle Temperature	°F	505 - 540
Melt temperature	°F	505 - 540
Suggested Max. Moisture	%	0.2
Suggested Max. Regrind	%	25

(•) Not tested

(1) Is dependent upon molding conditions particularly Mold temperature.

(2) Chem Polymer measurement according to UL