



Chemlon® 100 L

Teknor Apex Company (Chem Polymer) - Polyamide 66

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Lubricant		
Features	• General Purpose	• Lubricated	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14		ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.015 to 0.022	in/in	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	12000	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	405000	psi	ASTM D790
Flexural Strength	15800	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	425	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	190	°F	ASTM D648
Melting Temperature	495	°F	DSC
CLTE - Flow	3.9E-5	in/in/°F	ASTM D696
RTI Elec			UL 746
0.03 in	239	°F	
0.06 in	239	°F	
0.12 in	239	°F	
RTI Imp			UL 746
0.03 in	167	°F	
0.06 in	167	°F	
0.12 in	185	°F	
RTI Str			UL 746
0.03 in	203	°F	
0.06 in	203	°F	
0.12 in	203	°F	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms-cm	ASTM D257
Dielectric Strength (0.118 in)	460	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	V-2		UL 94

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Flammability	Nominal Value	Unit	Test Method
Oxygen Index	27	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	465 to 490	°F
Middle Temperature	495 to 525	°F
Front Temperature	505 to 540	°F
Nozzle Temperature	505 to 535	°F
Processing (Melt) Temp	505 to 535	°F

Notes

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