



Chemlon® 102

Teknor Apex Company - Polyamide 66

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Nucleating Agent		
Features	• Nucleated		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage	1.0 to 1.6	%	ISO 2577
Water Absorption (24 hr, 73°F)	1.3	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	12900	psi	ISO 527
Tensile Strain (Break)	> 20	%	ISO 527
Flexural Modulus	450000	psi	ISO 178/A
Flexural Stress	17000	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	> 1.7	ft·lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	194	°F	ISO 75-2/A
Melting Temperature	495	°F	DSC
CLTE - Flow	3.9E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+18	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	430	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.030 in)	V-2		UL 94
Oxygen Index	27	%	ASTM D2863
FMVSS Flammability	PASSES		FMVSS 302

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	465 to 490	°F
Middle Temperature	495 to 520	°F
Front Temperature	505 to 535	°F
Nozzle Temperature	505 to 540	°F
Processing (Melt) Temp	505 to 540	°F