



Chemlon® 104 HU

Teknor Apex Company - Polyamide 66

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Heat Stabilizer • Impact Modifier	• Lubricant • UV Stabilizer	
Features	• Good Toughness • Heat Stabilized	• Impact Modified • Lubricated	• Medium Viscosity • UV Resistant
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm ³	ISO 1183
Molding Shrinkage	1.5 to 2.0	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	8990	psi	ISO 527
Tensile Strain (Break)	10	%	ISO 527
Flexural Modulus	326000	psi	ISO 178/A
Flexural Stress	12300	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	5.7	ft-lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	140	°F	ISO 75-2/A
Melting Temperature	500	°F	
CLTE - Flow	3.9E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	430	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	22	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	491 to 527	°F
Middle Temperature	509 to 554	°F
Front Temperature	491 to 563	°F
Nozzle Temperature	509 to 545	°F
Processing (Melt) Temp	505 to 535	°F