



Chemlon® 104 H

Teknor Apex Company (Chem Polymer) - Polyamide 66

General Information			
General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• General Purpose • Good Impact Resistance • Good Processability	• Good Toughness • Heat Stabilized • High Strength	• Impact Modified
Automotive Specifications	• CHRYSLER MS-DB41 CPN3955 Color: NT001 Natural • CHRYSLER MS-DB41 Type PA CPN1826 Color: BK001 Black • FORD ESA-M4D267-A • FORD ESA-M4D387-A • FORD ESB-M4D178-A2 • FORD ESK-M4D178-A2 • FORD WSB-M4D706-A • FORD WSB-M4D706-A2 • FORD WSK-M4D706-A • FORD WSK-M4D706-A2 • GM GMP.PA66.015 • GM GMP.PA66.063		
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		
ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10		ASTM D792
Molding Shrinkage - Flow	0.012 to 0.020	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	9000	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break)	35	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	10500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F	2.6	ft-lb/in	
73°F	4.5	ft-lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	415	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	175	°F	ASTM D648
Melting Temperature	495	°F	
CLTE - Flow	0.000039	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohm-cm	ASTM D257
Dielectric Strength (0.118 in)	430	V/mil	ASTM D149

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Flammability	Nominal Value	Unit	Test Method
Flame Rating - UL (0.0319 in)	HB		UL 94
Oxygen Index	22	%	ASTM D2863
UL	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI)	600	V	UL 746

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.