



Chemlon® 106 H

Teknor Apex Company - Polyamide 66

General Information

Product Description

Chemlon® 106H is an impact modified polyamide 66 (PA 66) designed for injection molding and extrusion. This toughened material offers strength and flexibility, even at low temperatures; and is available globally.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• Good Toughness	• Low Temperature Toughness	
RoHS Compliance	• Contact Manufacturer		
Automotive Specifications	• MERCEDES BENZ DBL 5410.00 ¹		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.11	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.6	--	%	
Flow	1.5	--	%	
Water Absorption (24 hr, 73°F)	1.3	--	%	ISO 62
Water Absorption				ISO 62
Saturation, 73°F	7.2	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	355000	128000	psi	ISO 527
Tensile Stress	8410	6530	psi	ISO 527
Tensile Strain (Break)	50	190	%	ISO 527
Flexural Modulus	290000	114000	psi	ISO 178
Flexural Stress	11600	3340	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
73°F	12	50	ft·lb/in ²	
Charpy Unnotched Impact Strength	No Break	No Break		ISO 179
Notched Izod Impact Strength				ISO 180
73°F	9.5	46	ft·lb/in ²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/B
66 psi, Unannealed	419	--	°F	
Deflection Temperature Under Load				ISO 75-2/A
264 psi, Unannealed	158	--	°F	
Melting Temperature	498	--	°F	ISO 11357
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.031 in)	HB	--		UL 94

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Processing Information		
Injection	Dry	Unit
Drying Temperature	176	°F
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	509 to 559	°F
Mold Temperature	171 to 190	°F

Injection Notes

Maximum peak injection pressure should not exceed 80% of the machine's maximum pressure capability. Start with a holding pressure that is half the peak injection pressure. Perform a rheology curve in order to determine appropriate injection rate.

Notes

¹ Automotive site approvals apply for US manufactured compound only

² Typical properties: these are not to be construed as specifications.