



Chemlon® 109

Teknor Apex Company - Polyamide 66

General Information

General	
Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Features	• High Impact Resistance
Automotive Specifications	• FORD ESA-M4D379-A ¹ • GM GMP.PA66.021 ¹ • STELLANTIS MS-DB-41 CPN2456 Color: 100% Color Match ¹
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ²

Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Molding Shrinkage - Flow	2.0 to 2.7	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	6530	psi	ISO 527
Tensile Strain (Break)	75	%	ISO 527
Flexural Modulus	261000	psi	ISO 178/A
Flexural Stress	7540	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	38	ft·lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	126	°F	ISO 75-2/A
Melting Temperature	500	°F	ISO 11357
RTI Elec (0.030 in)	149	°F	UL 746B
RTI Imp (0.030 in)	149	°F	UL 746B
RTI Str (0.030 in)	149	°F	UL 746B
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	250	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.030 in)	HB		UL 94
Oxygen Index	21	%	ASTM D2863
FMVSS Flammability	PASSES		FMVSS 302

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Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	465 to 495	°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

Notes

¹ Automotive site approvals apply for US manufactured compound only

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