



Chemlon® 113 GH

Teknor Apex Company - Polyamide 66

General Information

Product Description

Chemlon® 113 GH is a 13% glass fiber reinforced, heat stabilized polyamide 66 (PA 66) designed for injection molding. This high tensile strength material has a wide processing window, provides a good surface appearance, and is available globally.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Heat Stabilizer		
Features	• Good Processability • Good Surface Finish	• Good Thermal Stability • High Tensile Strength	
RoHS Compliance	• Contact Manufacturer		
Automotive Specifications	• FORD ESA-M4D349-A ¹ • GM GMP.PA66.020 Color: Black ¹ • GM GMP.PA66.020 Color: Natural ¹ • GM GMW3038P-PA66-GF15H Color: Black ¹ • STELLANTIS MS-DB-41 CPN2239 Color: BK001 Black ¹ • STELLANTIS MS-DB-41 CPN3794 Color: Non-matched Color ¹ • STELLANTIS MS-DB-41 CPN4061 Color: 100% Color Match ¹		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.22	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.4	--	%	
Flow	0.49	--	%	
Water Absorption (24 hr, 73°F)	1.1	--	%	ISO 62
Water Absorption Saturation, 73°F	2.6	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.06E+6	603000	psi	ISO 527-1
Tensile Stress	17300	11600	psi	ISO 527-2
Tensile Strain (Break)	3.0	10	%	ISO 527-2
Flexural Modulus	674000	494000	psi	ISO 178
Flexural Stress	24700	14500	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	2.4	2.9	ft-lb/in ²	ISO 179
Charpy Unnotched Impact Strength	12	19	ft-lb/in ²	ISO 179
Notched Izod Impact Strength	2.4	2.9	ft-lb/in ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/B
66 psi, Unannealed	482	--	°F	
Deflection Temperature Under Load				ISO 75-2/A
264 psi, Unannealed	437	--	°F	
Melting Temperature	495	--	°F	

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Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity	1.0E+15	--	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	460	--	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	--	V	UL 746A
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.03 in)	HB	--		UL 94
Oxygen Index	25	--	%	ASTM D2863

Processing Information		
Injection	Dry	Unit
Drying Temperature	176	°F
Suggested Max Moisture	0.17	%
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.