



Chemlon® 120 GH

Teknor Apex Company - Polyamide 66

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Good Processability	• Heat Stabilized	
	• Good Toughness	• High Strength	
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.26		ASTM D792
Molding Shrinkage - Flow	3.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	18600	psi	ASTM D638
Tensile Elongation (Yield)	2.5	%	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	800000	psi	ASTM D790
Flexural Strength	27600	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.3	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	441	°F	
Melting Temperature	505 to 540	°F	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength	460	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94
Oxygen Index	25	%	ASTM D2863
FMVSS Flammability	PASSED		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	466 to 495	°F
Middle Temperature	495 to 520	°F
Front Temperature	505 to 536	°F
Nozzle Temperature	505 to 540	°F