



Chemlon® 133 GHR

Teknor Apex Company - Polyamide 66

General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Additive	• Heat Stabilizer	• Lubricant	
Features	• Good Processability • Good Toughness	• Heat Stabilized • High Strength	• Hydrolysis Resistant • Lubricated
Automotive Specifications	• GM GMP.PA66.054 Color: Black ¹	• GM GMP.PA66.054 Color: Natural ¹	
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Nominal Value	Unit	Test Method
Density	1.38	g/cm ³	ISO 1183
Molding Shrinkage	0.15 to 0.40	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	25400	psi	ISO 527
Tensile Strain (Break)	3.0	%	ISO 527
Flexural Modulus	1.25E+6	psi	ISO 178/A
Flexural Stress	39200	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	3.6	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact Strength (73°F)	3.8	ft·lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	468	°F	ISO 75-2/A
Melting Temperature	500	°F	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	410	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	25	%	ASTM D2863

Processing Information

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	505 to 530	°F
Front Temperature	505 to 545	°F

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Injection	Nominal Value	Unit
Nozzle Temperature	505 to 545	°F
Processing (Melt) Temp	505 to 540	°F
Mold Temperature	140 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

Notes

- ¹ Automotive site approvals apply for US manufactured compound only
- ² Typical properties: these are not to be construed as specifications.