



Chemlon® 135 GH

Teknor Apex Company - Polyamide 66

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber		
Automotive Specifications	• FMVSS 302 ¹ • STELLANTIS MS-DB-41 CPN2224 Color: Non-matched Color ¹		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.40		ASTM D792
Molding Shrinkage - Flow	1.5E-3 to 3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.85	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	28000	psi	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.33E+6	psi	ASTM D790
Flexural Strength	40000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	487	°F	ASTM D648
Melting Temperature	495	°F	
CLTE - Flow	2.8E-5	in/in/°F	ASTM D696
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
Dielectric Constant (1 MHz)	3.90		ASTM D150
Dissipation Factor (1 MHz)	0.020		ASTM D150
Comparative Tracking Index (CTI)	600	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	25	%	ASTM D2863

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Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	475 to 495	°F
Middle Temperature	505 to 535	°F
Front Temperature	515 to 545	°F
Nozzle Temperature	515 to 545	°F
Processing (Melt) Temp	510 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.