



Chemlon® 140 MH

Teknor Apex Company - Polyamide 66

General Information

Product Description

This is a 40% mineral filled polyamide 66.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Mineral, 40% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Fast Molding Cycle • Heat Stabilized	• High Rigidity • Low Warpage	
Automotive Specifications	• GM GMP.PA66.007 Color: Black ¹	• GM GMP.PA66.007 Color: Natural ¹	
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.5	%	
Flow	0.70 to 1.2	%	
Water Absorption (24 hr, 73°F)	0.80	%	ISO 62
Water Absorption (Saturation, 73°F)	1.4	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.22E+6	psi	ISO 527
Tensile Stress	13100	psi	ISO 527
Tensile Strain (Break)	2.0	%	ISO 527
Flexural Modulus	1.13E+6	psi	ISO 178/A
Flexural Stress	21800	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.7	ft·lb/in ²	ISO 179
Charpy Unnotched Impact Strength	14	ft·lb/in ²	ISO 179
Notched Izod Impact Strength (73°F)	1.7	ft·lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	464	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	392	°F	ISO 75-2/A
Melting Temperature	495	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F

Chemlon® 140 MH

Teknor Apex Company - Polyamide 66

Injection	Nominal Value	Unit
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	465 to 490	°F
Middle Temperature	495 to 525	°F
Front Temperature	505 to 540	°F
Nozzle Temperature	505 to 535	°F
Processing (Melt) Temp	505 to 535	°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.