



Chemlon® 504-13 GH

Teknor Apex Company - Polyamide 66

General Information

Product Description

Chemlon® 504-13 GH is a general purpose polyamide 66 (PA 66) designed for injection molding.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• General Purpose		
RoHS Compliance	• Contact Manufacturer		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.0	%	
Flow	0.30 to 0.50	%	
Water Absorption (24 hr, 73°F)	0.70	%	ISO 62
Water Absorption (Saturation, 73°F)	2.1	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	696000	psi	ISO 527
Tensile Stress (Break)	14500	psi	ISO 527
Tensile Strain (Break)	5.0	%	ISO 527
Flexural Modulus	580000	psi	ISO 178/A
Flexural Stress	20300	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	3.3	ft-lb/in ²	ISO 179
Charpy Unnotched Impact Strength	No Break		ISO 179
Notched Izod Impact Strength (73°F)	3.3	ft-lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	446	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	410	°F	ISO 75-2/A
Melting Temperature	495	°F	ISO 11357
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.031 in)	HB		UL 94

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Processing Information

Injection	Nominal Value	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 Typical properties: these are not to be construed as specifications.