



Chemlon® 66AT

Teknor Apex Company (Chem Polymer) - Polyamide 66

General Information

Product Description

66AT is an unfilled, modified nylon 66 that offers good low temperature impact strength and toughness, coupled with reasonable rigidity.

General

Material Status	• Commercial: Active
Availability	• Europe
Additive	• Impact Modifier
Features	• Impact Modified • Low Temperature Impact Resistance • Low Temperature Toughness • Medium Rigidity
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.12	g/cm ³	ISO 1183
Molding Shrinkage ²	1.5 to 2.5	%	Internal Method
Water Absorption (Equilibrium, 73°F, 50% RH)	2.4	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	377000	psi	ISO 527-2
Tensile Stress	10900	psi	ISO 527-2
Tensile Strain (Break)	25	%	ISO 527-2
Flexural Modulus	363000	psi	ISO 178
Flexural Stress	10900	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	2.9	ft-lb/in ²	ISO 180/A
Flammability	Nominal Value	Unit	Test Method
Oxygen Index	23	%	ISO 4589-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	2.0	hr
Rear Temperature	518 to 554	°F
Middle Temperature	518 to 554	°F
Front Temperature	518 to 554	°F
Processing (Melt) Temp	518 to 554	°F
Mold Temperature	176 to 194	°F
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Injection Notes

No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.