+135-3858-6433 (GuangDong)
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TEKNOR APEX

Chemlon® 66GF4H

Teknor Apex Company (Chem Polymer) - Polyamide 66

General Information

Product Description

66GF4H is a 20% glass fibre reinforced, heat stabilised nylon 66 that offers good mechanical performance coupled with good surface finish and flow.

General			
Material Status	• Commercial: Active		
Availability	• Europe		
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Good Flow	• Good Surface Finish	• Heat Stabilized
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.30	--	g/cm³	ISO 1183
Molding Shrinkage [2]	0.70 to 1.4	--	%	Internal Method
Water Absorption				ISO 62
Equilibrium, 73°F, 50% RH	2.0	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	870000	580000	psi	ISO 527-2
Tensile Stress	18900	14500	psi	ISO 527-2
Tensile Strain (Break)	5.0	10	%	ISO 527-2
Flexural Modulus	870000	580000	psi	ISO 178
Flexural Stress	24700	13100	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Unnotched Impact Strength	19 ft·lb/in²	No Break		ISO 179/1eU
Notched Izod Impact Strength	2.9	7.1	ft·lb/in²	ISO 180/A
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/B
66 psi, Unannealed	> 464	--	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	446	--	°F	
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+13	ohms·cm	IEC 60093
Electric Strength (0.118 in)	410	--	V/mil	IEC 60243-1
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Flame Rating				UL 94
0.06 in, Teknor Apex test result	HB	--		

Processing Information

Injection	Dry	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

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Injection	Dry	Unit
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.

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).