



Chemlon® 66M8

Teknor Apex Company (Chem Polymer) - Polyamide 66

General Information

Product Description

66M8 is a 40% mineral filled injection moulding grade of nylon 66.

General

Material Status	• Commercial: Active
Availability	• Europe
Filler / Reinforcement	• Mineral, 40% Filler by Weight
Features	• Good Stiffness
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.45	--	g/cm ³	ISO 1183
Molding Shrinkage ²	1.0 to 1.4	--	%	Internal Method
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	827000	363000	psi	ISO 527-2
Tensile Stress	14500	8120	psi	ISO 527-2
Flexural Stress	23200	11200	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	4.3	4.8	ft·lb/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength	19 ft·lb/in ²	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature 66 psi, Unannealed	464	--	°F	ISO 75-2/B
Heat Deflection Temperature 264 psi, Unannealed	329	--	°F	ISO 75-2/A
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
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	--		
Oxygen Index	24	--	%	ISO 4589-2

Processing Information

Injection	Dry	Unit
Drying Temperature	176	°F
Drying Time	2.0	hr
Rear Temperature	527 to 563	°F
Middle Temperature	527 to 563	°F
Front Temperature	527 to 563	°F
Processing (Melt) Temp	536 to 563	°F
Mold Temperature	176 to 194	°F
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	