



Chemlon® 904-15 GVNH BK032

Teknor Apex Company - Polyamide 66

General Information

Product Description

Chemlon® 904-15 GVNH is a halogen free flame retardant, 15% glass fiber reinforced polyamide 66 (PA 66) designed for injection molding. This material has low halogen content and is available globally.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant	• Heat Stabilizer	
Features	• Flame Retardant	• Low Halogen Content	
RoHS Compliance	• Contact Manufacturer		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.26	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	2.9	%	
Flow	0.50	%	
Water Absorption (24 hr, 73°F)	0.50	%	ISO 62
Water Absorption (Saturation, 73°F)	1.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.13E+6	psi	ISO 527
Tensile Stress (Break)	15200	psi	ISO 527
Tensile Strain (Break)	3.2	%	ISO 527
Flexural Modulus	769000	psi	ISO 178
Flexural Stress	21800	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	1.9	ft-lb/in ²	ISO 179
Charpy Unnotched Impact Strength	21	ft-lb/in ²	ISO 179
Notched Izod Impact Strength	1.9	ft-lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	491	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	455	°F	ISO 75-2/A
Melting Temperature	500	°F	ISO 11357
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.13 in)	V-0		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.