+135-3858-6433 (GuangDong)
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TEKNOR APEX

Chemlon® A30

Teknor Apex Company (Chem Polymer) - Polyamide 66

General Information

Product Description

A30 is an unfilled injection moulding grade of nylon 66. It contains a nucleating agent to enable mouldings to be produced with shorter cycle times

General	
Material Status	• Commercial: Active
Availability	• Europe
Additive	• Nucleating Agent
Features	• Nucleated
Processing Method	• Injection Molding

ASTM & ISO Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm³	ISO 1183
Molding Shrinkage [2]	1.1 to 1.7	--	%	Internal Method
Water Absorption				ISO 62
Equilibrium, 73°F, 50% RH	2.5	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	450000	276000	psi	ISO 527-2
Tensile Stress	12300	8700	psi	ISO 527-2
Flexural Modulus	435000	174000	psi	ISO 178
Flexural Stress	13800	5080	psi	ISO 178
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/B
66 psi, Unannealed	446	410	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	203	185	°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+15	ohms·cm	IEC 60093
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Flame Rating (0.06 in)	V-2	--		UL 94
Glow Wire Flammability Index				IEC 60695-2-12
0.06 in	1380	--	°F	
Oxygen Index	27	--	%	ISO 4589-2

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
Processing (Melt) Temp	518 to 554	°F
Mold Temperature	140 to 176	°F
Injection Rate	Fast	
Back Pressure	Low	

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Injection	Dry	Unit
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).