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TEKNOR APEX

Chemlon® E-66

Teknor Apex Company (Chem Polymer) - Polyamide 66

General Information

Product Description

Chemlon® E-66 is an economy range Nylon 66 injection moulding grade.
It is available in natural or black versions.

General

Material Status	• Commercial: Active	
Availability	• Europe	• North America
Appearance	• Black	• Natural Color
Processing Method	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm³	ISO 1183
Molding Shrinkage [2]	1.5 to 2.0	%	Internal Method
Water Absorption (Equilibrium, 73°F, 50% RH)	2.5	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	421000	psi	ISO 527-2
Tensile Stress (Yield)	11600	psi	ISO 527-2
Tensile Strain (Yield)	4.5	%	ISO 527-2
Flexural Modulus	406000	psi	ISO 178
Flexural Stress	16000	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact Strength	1.7	ft·lb/in²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (66 psi, Unannealed)	428	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	194	°F	ISO 75-2/A

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	< 572	°F
Mold Temperature	176 to 194	°F
Injection Rate	Fast	
Screw Speed	50 to 200	rpm

Injection Notes

Back pressure: Low
Injection pressure: High

The material is supplied dry and ready to mould in sealed, moisture proof sacks. 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. Should drying become necessary, two hours at 80°C in a dehumidifying drier is recommended. The use of air circulating driers is not generally recommended, as longer drying times are often required, with greater potential for product oxidation and yellowing. Drying temperatures should not exceed 80°C.