

Chemlon® 133 GH

Teknor Apex Company (Chem Polymer) - Polyamide 66

Wednesday, March 9, 2016

General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Additive	• Heat Stabilizer	• Lubricant	
Features	• Good Processability • Good Toughness	• Heat Stabilized • High Strength	• Lubricated
Automotive Specifications	• 3M 11-0003-5762-1 • CHRYSLER MS-DB-41 CPN1900 Color: BK001 Black • CHRYSLER MS-DB-41 CPN2224 Color: Non-matched Color	• FORD ESB-M4D133-A • FORD ESB-M4D89-A • FORD WSK-M4D663-A	• GM GMP.PA66.013 Color: Natural • GM GMW3038P-PA66-GF35H
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.15 to 0.40	%	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	176	MPa	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	8620	MPa	ASTM D790
Flexural Strength	276	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed	249	°C	ASTM D648
Melting Temperature	257	°C	
CLTE - Flow	5.0E-5	cm/cm/°C	ASTM D696
RTI Elec			UL 746
0.810 mm	130	°C	
1.50 mm	130	°C	
3.00 mm	130	°C	
RTI Imp			UL 746
0.810 mm	95.0	°C	
1.50 mm	110	°C	
3.00 mm	110	°C	
RTI Str			UL 746
0.810 mm	130	°C	
1.50 mm	130	°C	
3.00 mm	130	°C	

Revision Date: 12/11/2008

The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable but no guarantee of their accuracy is made. All products are sold upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses and purchasers assume all risks and liability for the results of use of the products, including use in accordance with seller's recommendations. Nothing in this bulletin constitutes permission or a recommendation to practice or use any invention covered by any patent owned by this company or by others. There is no warranty of merchantability and there are no other warranties for the products described.

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Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (3.00 mm)	16	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.810 mm)	HB		UL 94
Oxygen Index	25	%	ISO 4589-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	79.4	°C
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	246 to 257	°C
Middle Temperature	263 to 274	°C
Front Temperature	268 to 282	°C
Nozzle Temperature	268 to 282	°C
Processing (Melt) Temp	263 to 282	°C
Mold Temperature	60.0 to 93.3	°C
Injection Pressure	34.5 to 138	MPa
Screw Speed	60 to 120	rpm

Notes

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

Teknor Apex Company Corporate Headquarters

*In U.S. for Vinyls, TPEs, Colorants,
Engineered Thermoplastics (Chem Polymer)*

505 Central Avenue
Pawtucket, Rhode Island 02861 U.S.

Phone: 401-725-8000
Fax: 401-725-8095
Toll Free (U.S. only) 800-556-3864

www.teknorapex.com
info@teknorapex.com

Teknor Apex U.K. Ltd.

Tat Bank Road
Oldbury, West Midlands B69 4NH England

Phone: (44) 121-665-2100
Fax: (44) 121-544-5530

www.teknorapex.com
etpsales@teknorapex.co.uk

Teknor Apex (Suzhou) Advanced Polymer Compounds Co. Pte. Ltd.

No. 78 Ping Sheng Road
Suzhou Industrial Park
Jiangsu, China 215126

Phone: (86) 512-6287-1550
Fax: (86) 512-6288-8371

www.teknorapex.com
infotaap@teknorapex.com

Teknor Apex Asia Pacific PTE. LTD.

41 Shipyard Road
Singapore 628134

Phone: (65) 6265-2544
Fax: (65) 6265-1821

www.teknorapex.com
infotaap@teknorapex.com

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