

# Chemlon® 104 H

Teknor Apex Company (Chem Polymer) - Polyamide 66

Wednesday, September 21, 2016

## General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• General Purpose	• Good Toughness	• Impact Modified
	• Good Impact Resistance	• Heat Stabilized	
	• Good Processability	• High Strength	
Automotive Specifications	<ul style="list-style-type: none"> <li>• CHRYSLER MS-DB-41 CPN3955 Color: NT001 Natural</li> <li>• CHRYSLER MS-DB-41 Type PA CPN1826 Color: BK001 Black</li> <li>• FORD ESA-M4D267-A</li> <li>• FORD ESA-M4D387-A</li> <li>• FORD ESB-M4D178-A2</li> <li>• FORD ESK-M4D178-A2</li> <li>• FORD WSB-M4D706-A</li> <li>• FORD WSB-M4D706-A2</li> <li>• FORD WSK-M4D706-A</li> <li>• FORD WSK-M4D706-A2</li> <li>• FORD WSS-M4D706-B1</li> <li>• GM GMP.PA66.015 Color: Natural</li> <li>• GM GMW16447P-PA66-T2</li> </ul>		
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10		ASTM D792
Molding Shrinkage - Flow	0.012 to 0.020	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	9000	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break)	35	%	ASTM D638
Flexural Modulus	330000	psi	ASTM D790
Flexural Strength	10500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F	2.6	ft-lb/in	
73°F	4.5	ft-lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	415	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	175	°F	ASTM D648
Melting Temperature	495	°F	
CLTE - Flow	3.9E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms-cm	ASTM D257
Dielectric Strength (0.118 in)	430	V/mil	ASTM D149

Revision Date: 12/11/2008

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Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI)	600	V	UL 746

  

Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	22	%	ASTM D2863

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	465 to 490	°F
Middle Temperature	495 to 525	°F
Front Temperature	505 to 540	°F
Nozzle Temperature	505 to 535	°F
Processing (Melt) Temp	505 to 535	°F

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

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