

Chemlon® 133 GH

Teknor Apex Company (Chem Polymer) - Polyamide 66

Monday, February 4, 2019

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 ¹ • CHRYSLER MS-DB-41 CPN1900 Color: BK001 Black ¹ • CHRYSLER MS-DB-41 CPN2224 Color: Non-matched Color ¹	• FORD ESB-M4D133-A ¹ • FORD ESB-M4D89-A ¹ • FORD WSK-M4D663-A ¹	• GM GMP.PA66.013 Color: Natural ¹ • GM GMW3038P-PA66-GF35H ¹
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties²

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.38		ASTM D792
Molding Shrinkage - Flow	1.5E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	25500	psi	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.25E+6	psi	ASTM D790
Flexural Strength	40000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	480	°F	ASTM D648
Melting Temperature	495	°F	
CLTE - Flow	2.8E-5	in/in/°F	ASTM D696
RTI Elec			UL 746
0.03 in	266	°F	
0.06 in	266	°F	
0.12 in	266	°F	
RTI Imp			UL 746
0.03 in	203	°F	
0.06 in	230	°F	
0.12 in	230	°F	
RTI Str			UL 746
0.03 in	266	°F	
0.06 in	266	°F	
0.12 in	266	°F	

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 (0.118 in)	410	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746

Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	25	%	ISO 4589-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	475 to 495	°F
Middle Temperature	505 to 525	°F
Front Temperature	515 to 540	°F
Nozzle Temperature	515 to 540	°F
Processing (Melt) Temp	505 to 540	°F
Mold Temperature	140 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

Notes

¹ Automotive site approvals apply for US manufactured compound only

² Typical properties: these are not to be construed as specifications.

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