

Chemlon® 904-15 GVNH BK032

Teknor Apex Company - Polyamide 66

Saturday, September 14, 2024

General Information

Product Description

Chemlon® 904-15 GVNH is a halogen free flame retardant, 15% glass fiber reinforced polyamide 66 (PA 66) designed for injection molding. This material has low halogen content and is available globally.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant • Heat Stabilizer		
Features	• Flame Retardant • Low Halogen Content		
RoHS Compliance	• Contact Manufacturer		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density	1.26	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	2.9	%	
Flow	0.50	%	
Water Absorption (24 hr, 23°C)	0.50	%	ISO 62
Water Absorption (Saturation, 23°C)	1.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7800	MPa	ISO 527
Tensile Stress (Break)	105	MPa	ISO 527
Tensile Strain (Break)	3.2	%	ISO 527
Flexural Modulus	5300	MPa	ISO 178
Flexural Stress	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	45	kJ/m ²	ISO 179
Notched Izod Impact Strength	4.0	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
0.45 MPa, Unannealed	255	°C	
Deflection Temperature Under Load			ISO 75-2/A
1.8 MPa, Unannealed	235	°C	
Melting Temperature	260	°C	ISO 11357
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.2 mm)	V-0		UL 94

Legal Statement

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 purchaser assumes 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 others. There is no warranty of merchantability and there are no other warranties for the products described. For detailed Product Stewardship information, please contact us. Any product of Teknor Apex, including product names, shall not be used or tested in medical or food contact applications without the prior written acknowledgement of Teknor Apex as to the intended use. Please note that some products may not be available in one or more countries.

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	80	°C
Suggested Max Moisture	0.17	%
Processing (Melt) Temp	265 to 293	°C
Mold Temperature	77 to 88	°C

Injection Notes

Maximum peak injection pressure should not exceed 80% of the machine's maximum pressure capability. Start with a holding pressure that is half the peak injection pressure. Perform a rheology curve in order to determine appropriate injection rate.

Notes

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

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