

# Chemlon® 233 G

Teknor Apex Company (Chem Polymer) - Polyamide 6

Friday, June 30, 2017

## General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.39		ASTM D792
Molding Shrinkage - Flow	2.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	24500	psi	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	1.20E+6	psi	ASTM D790
Flexural Strength	35000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.7	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	413	°F	ASTM D648
Melting Temperature	420	°F	DSC
CLTE - Flow	2.9E-5	in/in/°F	ASTM D696
RTI Elec			UL 746
0.03 in	221	°F	
0.06 in	221	°F	
0.12 in	221	°F	
RTI Imp			UL 746
0.03 in	221	°F	
0.06 in	221	°F	
0.12 in	221	°F	
RTI Str			UL 746
0.03 in	221	°F	
0.06 in	221	°F	
0.12 in	221	°F	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	280	V/mil	ASTM D149
Comparative Tracking Index (CTI)	500		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	22	%	ASTM D2863

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Revision Date: 5/10/2012

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### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	425 to 455	°F
Middle Temperature	485 to 505	°F
Front Temperature	485 to 515	°F
Nozzle Temperature	485 to 515	°F
Processing (Melt) Temp	480 to 515	°F

### Notes

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

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