

Chemlon® 253

Teknor Apex Company (Chem Polymer) - Polyamide 6

Friday, June 30, 2017

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Features	• Medium Impact Resistance		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11		ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.015 to 0.019	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	9500	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break)	50	%	ASTM D638
Flexural Modulus	320000	psi	ASTM D790
Flexural Strength	12000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F	2.5	ft-lb/in	
73°F	3.5	ft-lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	140	°F	
Melting Temperature	420	°F	DSC
CLTE - Flow	4.7E-5	in/in/°F	ASTM D696
RTI Elec			UL 746
0.03 in	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	
RTI Imp			UL 746
0.03 in	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	
RTI Str			UL 746
0.03 in	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms-cm	ASTM D257
Dielectric Strength (0.118 in)	300	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	21	%	ASTM D2863

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Revision Date: 12/11/2008

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Processing Information		
Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	425 to 455	°F
Middle Temperature	445 to 485	°F
Front Temperature	465 to 500	°F
Nozzle Temperature	465 to 510	°F
Processing (Melt) Temp	465 to 510	°F

Notes

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

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