

# Chemlon® 280

Teknor Apex Company (Chem Polymer) - Polyamide 6

Friday, June 30, 2017

## General Information

### General

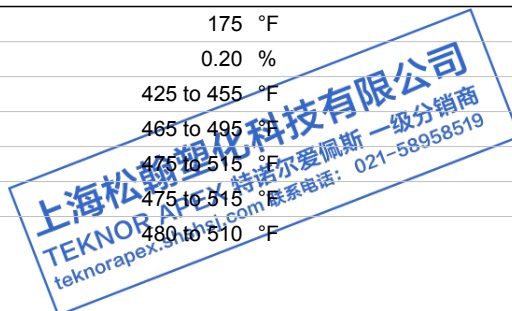
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07		ASTM D792
Molding Shrinkage - Flow	0.018 to 0.023	in/in	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	6000	psi	ASTM D638
Tensile Elongation (Yield)	7.0	%	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	235000	psi	ASTM D790
Flexural Strength	8000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°F	5.5	ft-lb/in	
73°F	22	ft-lb/in	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	275	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	125	°F	ASTM D648
Melting Temperature	422	°F	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+18	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	250	V/mil	ASTM D149
Comparative Tracking Index (CTI)	500	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	20	%	ASTM D2863

## Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Rear Temperature	425 to 455	°F
Middle Temperature	465 to 495	°F
Front Temperature	475 to 515	°F
Nozzle Temperature	475 to 515	°F
Processing (Melt) Temp	480 to 510	°F



### Notes

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

Revision Date: 12/11/2008

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## Teknor Apex Company (Chem Polymer) - Polyamide 6

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