

Chemlon® 813CI

Teknor Apex Company (Chem Polymer) - Polyamide 6/12 Copolymer

Friday, June 30, 2017

General Information

Product Description

813CI is an impact modified, 13% carbon fibre reinforced grade of PA612. It offers a combination of good mechanical strength, low density and low moisture absorption.

General

Material Status	• Commercial: Active
Availability	• Europe
Filler / Reinforcement	• Carbon Fiber, 13% Filler by Weight
Additive	• Impact Modifier
Features	• Good Strength • Impact Modified • Low Density • Low Moisture Absorption
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm ³	ISO 1183
Molding Shrinkage ²	0.20 to 1.0	%	Internal Method
Water Absorption (Equilibrium, 73°F, 50% RH)	1.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	21800	psi	ISO 527-2
Tensile Strain (Break)	4.5	%	ISO 527-2
Flexural Modulus	979000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	4.8	ft-lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	356	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	2.0	hr
Rear Temperature	464 to 536	°F
Middle Temperature	464 to 536	°F
Front Temperature	464 to 536	°F
Processing (Melt) Temp	464 to 536	°F
Mold Temperature	176 to 194	°F
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Injection Notes

No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.

Notes

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

² Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).

Revision Date: 3/20/2014



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