

Chemlon® 233 GH

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
Additive	• Heat Stabilizer • Lubricant
Features	• Good Dimensional Stability • Good Toughness • Good Impact Resistance • Heat Stabilized • Lubricated • Good Processability • High Strength
Automotive Specifications	• GM GMP.PA6.009 Color: Black • GM GMP.PA6.009 Color: Natural
Appearance	• Black • Natural Color
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

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
Water Absorption (73°F, 24 hr)	0.90	%	ASTM D570
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
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 73°F, Injection Molded)	119		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	413	°F	ASTM D648
Melting Temperature	420	°F	
CLTE - Flow (-22 to 302°F)	1.1E-5	in/in/°F	ASTM E831
CLTE - Transverse (-22 to 302°F)	4.0E-5	in/in/°F	ASTM E831
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	

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Revision Date: 1/12/2017

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Thermal	Nominal Value	Unit	Test Method
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	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	22	%	ASTM D2863

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 510	°F
Mold Temperature	140 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

Notes

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

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