

Chemlon® 253 H

Teknor Apex Company (Chem Polymer) - Polyamide 6

Friday, June 30, 2017

General Information

| General | | | |
|---------------------------|----------------------|-------------------------------|---------------------------------|
| Material Status | • Commercial: Active | | |
| Availability | • Asia Pacific | • Europe | • North America |
| Additive | • Heat Stabilizer | • Impact Modifier | |
| Features | • Good Toughness | • Impact Modified | |
| | • Heat Stabilized | • Medium Viscosity | |
| Automotive Specifications | • FORD ESB-M4D178-A2 | • GM GMP.PA6.005 Color: Black | • GM GMP.PA6.005 Color: Natural |
| Appearance | • Black | • Natural Color | |
| Forms | • Pellets | | |
| Processing Method | • Injection Molding | | |

ASTM & ISO Properties ¹

| Physical | Nominal Value | Unit | Test Method |
|--|----------------|----------|-------------|
| Specific Gravity | 1.11 | | 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 | |
| CLTE - Flow | 4.7E-5 | in/in/°F | ASTM D696 |
| 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 |

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 |

Revision Date: 12/11/2008

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| Injection | Nominal Value | Unit |
|------------------------|---------------|------|
| 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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