

Chemlon® 280 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 Flexibility • Good Impact Resistance • Good Processability	• Good Toughness • Heat Stabilized • High Strength	• Impact Modified
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.08		ASTM D792
Molding Shrinkage - Flow	0.016	in/in	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	8200	psi	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	225000	psi	ASTM D790
Flexural Strength	8500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	18	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	149	°F	ASTM D648
Melting Temperature	428	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150 to 180	°F
Suggested Max Moisture	0.20	%
Rear Temperature	470	°F
Middle Temperature	450	°F
Front Temperature	440	°F
Nozzle Temperature	450	°F
Mold Temperature	70 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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Revision Date: 12/11/2008

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