

Chemlon® 212 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	• Lubricant	
Features	• General Purpose • Good Mold Release	• Heat Stabilized • Lubricated	• Medium Viscosity
Automotive Specifications	• GM GMP.PA6.008 Color: Black	• GM GMP.PA6.008 Color: Natural	
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13		ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.014 to 0.018	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (73°F)	11500	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break, 73°F)	50	%	ASTM D638
Flexural Modulus (73°F)	415000	psi	ASTM D790
Flexural Strength (73°F)	15000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.0	ft-lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	365	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	198	°F	ASTM D648
Melting Temperature	420	°F	
CLTE - Flow	3.4E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	360	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	V-2		UL 94
Oxygen Index	25 %		ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%

Revision Date: 12/11/2008

The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable but no guarantee of their accuracy is made. All products are sold upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses and purchasers assume all risks and liability for the results of use of the products, including use in accordance with seller's recommendations. Nothing in this bulletin constitutes permission or a recommendation to practice or use any invention covered by any patent owned by this company or by others. There is no warranty of merchantability and there are no other warranties for the products described.

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Injection	Nominal Value	Unit
Rear Temperature	425 to 455	°F
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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