

Chemlon® 230 GH

Teknor Apex Company (Chem Polymer) - Polyamide 6

Friday, June 30, 2017

General Information

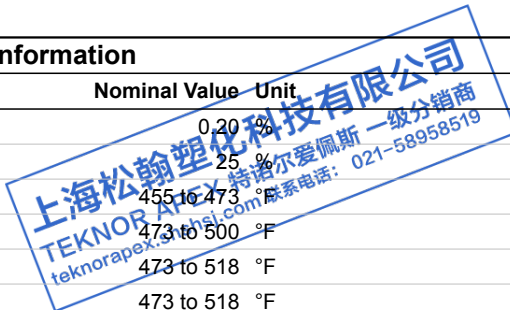
General	
Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Uses	• Automotive Applications
Automotive Specifications	• GM GMP.PA6.054 Color: Black • GM GMP.PA6.054 Color: Natural
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Molding Shrinkage ²	0.15 to 0.40	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	22900	psi	ISO 527-2
Tensile Strain (Yield)	3.0	%	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	1.23E+6	psi	ISO 178
Flexural Stress	32600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/1A
-40°F	4.3	ft-lb/in ²	
73°F	4.8	ft-lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	401	°F	ISO 75-2/A
Melting Temperature	428	°F	ASTM D789
CLTE - Flow	2.9E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ISO 1325
Dielectric Strength (0.118 in)	280	V/mil	ASTM D149
Comparative Tracking Index	> 600	V	Internal Method
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	22	%	ISO 4589-2
FMVSS Flammability	Passed		FMVSS 302

Processing Information

Injection	Nominal Value	Unit
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	455 to 473	°F
Middle Temperature	473 to 500	°F
Front Temperature	473 to 518	°F
Nozzle Temperature	473 to 518	°F
Processing (Melt) Temp	473 to 518	°F



Revision Date: 3/9/2017

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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Notes

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

² Dependent upon molding conditions particularly Mold temperature.

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