



Chemlon® 204-13 GVNH

Teknor Apex Company - Polyamide 6

General Information

Product Description

Chemlon® 204-13 GVNH is a flame retardant, 15% glass fiber reinforced polyamide 6 (PA 6) designed for injection molding. This material has low halogen content and is available globally.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant	• Heat Stabilizer	
Features	• Flame Retardant	• Low Halogen Content	
RoHS Compliance	• Contact Manufacturer		
Automotive Specifications	• GM GMW16801 ¹	• GM GMW16801P-PA6-GF15-T1 ¹	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.31	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.3	--	%	
Flow	0.20 to 0.35	--	%	
Water Absorption (24 hr, 73°F)	0.70	--	%	ISO 62
Water Absorption				ISO 62
Saturation, 73°F	2.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	841000	469000	psi	ISO 527-2
Tensile Stress	13200	8120	psi	ISO 527-2
Tensile Strain (Break)	3.5	16	%	ISO 527-2
Flexural Modulus	827000	376000	psi	ISO 178
Flexural Stress	18900	9140	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
73°F	1.4	4.7	ft·lb/in ²	
Charpy Unnotched Impact Strength	20	32	ft·lb/in ²	ISO 179
Notched Izod Impact Strength				ISO 180
73°F	1.7	4.8	ft·lb/in ²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/B
66 psi, Unannealed	396	--	°F	
Deflection Temperature Under Load				ISO 75-2/A
264 psi, Unannealed	365	--	°F	
Melting Temperature (DSC)	428	--	°F	ISO 11357
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.13 in, BLACK)	V-0	--		UL 94

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Processing Information		
Injection	Dry	Unit
Drying Temperature	176	°F
Suggested Max Moisture	0.17	%
Processing (Melt) Temp	464 to 500	°F
Mold Temperature	171 to 190	°F

Injection Notes
Maximum peak injection pressure should not exceed 80% of the machine's maximum pressure capability. Start with a holding pressure that is half the peak injection pressure. Perform a rheology curve in order to determine appropriate injection rate.

Notes

¹ Automotive site approvals apply for US manufactured compound only

² Typical properties: these are not to be construed as specifications.