



Chemlon® 206 G

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 6.0% Filler by Weight
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18		ASTM D792
Molding Shrinkage - Flow	8.0E-3 to 0.013	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	13500	psi	ASTM D638
Tensile Elongation (Yield)	4.0	%	ASTM D638
Tensile Elongation (Break)	5.0	%	ASTM D638
Flexural Modulus	480000	psi	ASTM D790
Flexural Strength	18500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	355	°F	ASTM D648
Melting Temperature	420	°F	DSC
CLTE - Flow	3.1E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+18	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	280	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	24	%	ASTM D2863
FMVSS Flammability	PASSES		FMVSS 302

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	425 to 455	°F
Middle Temperature	485 to 495	°F
Front Temperature	485 to 510	°F
Nozzle Temperature	485 to 510	°F
Processing (Melt) Temp	480 to 510	°F