



Chemlon® 214 G

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 14% Filler by Weight
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 0.010	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	16500	psi	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	625000	psi	ASTM D790
Flexural Strength	23500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.2	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	400	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	370	°F	ASTM D648
Melting Temperature	420	°F	DSC
CLTE - Flow	3.1E-5	in/in/°F	ASTM D696
RTI Elec			UL 746B
0.03 in	221	°F	
0.06 in	221	°F	
0.12 in	221	°F	
RTI Imp			UL 746B
0.03 in	167	°F	
0.06 in	167	°F	
0.12 in	167	°F	
RTI Str			UL 746B
0.03 in	221	°F	
0.06 in	221	°F	
0.12 in	221	°F	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	280	V/mil	ASTM D149
Comparative Tracking Index (CTI)	500	V	UL 746A
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	22	%	ASTM D2863
FMVSS Flammability	PASSES		FMVSS 302

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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	465 to 495	°F
Front Temperature	475 to 515	°F
Nozzle Temperature	475 to 515	°F
Processing (Melt) Temp	480 to 510	°F

Notes

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