



Chemlon® 214 GH

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 14% Filler by Weight		
Additive	• Heat Stabilizer	• Lubricant	
Features	• Creep Resistant	• Good Toughness	• Lubricated
	• Good Dimensional Stability	• Heat Stabilized	
	• Good Processability	• High Strength	
Automotive Specifications	• GM GMP.PA6.006 Color: Black ¹		• GM GMP.PA6.006 Color: Natural ¹
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.23		ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.70	%	
Flow	0.50 to 1.0	%	
Water Absorption (24 hr, 73°F)	0.90	%	ISO 62
Water Absorption (Saturation, 73°F)	2.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	885000	psi	ISO 527
Tensile Stress	16000	psi	ISO 527
Tensile Strain (Yield)	3.0	%	ISO 527
Flexural Modulus	653000	psi	ISO 178/A
Flexural Stress	23900	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	1.5	ft-lb/in ²	ISO 179
Charpy Unnotched Impact Strength	17	ft-lb/in ²	ISO 179
Notched Izod Impact Strength	1.7	ft-lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	392	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	374	°F	ISO 75-2/A
Melting Temperature	428	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94

Processing Information

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

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Injection	Nominal Value	Unit
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
Mold Temperature	140 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

Notes

- ¹ Automotive site approvals apply for US manufactured compound only
- ² Typical properties: these are not to be construed as specifications.