



# Chemlon® 215-10 MGH

Teknor Apex Company - Polyamide 6

## General Information

### Product Description

Chemlon® 215-10 MGH is a 15% mineral and 10% glass fiber reinforced, heat stabilized polyamide 6 (PA 6) designed for injection molding. This material has a wide processing window, exhibits a good surface appearance and dimensional stability, and is available globally.

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Heat Stabilizer		
Features	• Good Dimensional Stability • Good Processability	• Good Surface Finish • Good Thermal Stability	• High Tensile Strength
RoHS Compliance	• Contact Manufacturer		
Automotive Specifications	• STELLANTIS MS-DB-41 <sup>1</sup>		
Forms	• Pellets		
Processing Method	• Injection Molding		

## ASTM & ISO Properties <sup>2</sup>

Physical	Dry	Conditioned	Unit	Test Method
Density	1.33	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.90	--	%	
Flow	0.50	--	%	
Water Absorption (24 hr, 73°F)	1.7	--	%	ISO 62
Water Absorption				ISO 62
Saturation, 73°F	7.3	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	769000	558000	psi	ISO 527-2
Tensile Stress	15700	8560	psi	ISO 527-2
Tensile Strain (Break)	4.0	12	%	ISO 527-2
Flexural Modulus	876000	436000	psi	ISO 178
Flexural Stress	23100	10300	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
73°F	1.7	2.2	ft·lb/in <sup>2</sup>	
Charpy Unnotched Impact Strength	15	28	ft·lb/in <sup>2</sup>	ISO 179
Notched Izod Impact Strength				ISO 180
73°F	1.9	2.6	ft·lb/in <sup>2</sup>	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/B
66 psi, Unannealed	406	--	°F	
Deflection Temperature Under Load				ISO 75-2/A
264 psi, Unannealed	361	--	°F	
Melting Temperature	428	--	°F	ISO 11357
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.031 in)	HB	--		UL 94

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### Legal Statement

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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 purchaser assumes 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 others. There is no warranty of merchantability and there are no other warranties for the products described. For detailed Product Stewardship information, please contact us. Any product of Teknor Apex, including product names, shall not be used or tested in medical or food contact applications without the prior written acknowledgement of Teknor Apex as to the intended use. Please note that some products may not be available in one or more countries.

### Processing Information

Injection	Dry	Unit
Drying Temperature	176	°F
Suggested Max Moisture	0.15	%
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

<sup>1</sup> Automotive site approvals apply for US manufactured compound only

<sup>2</sup> Typical properties: these are not to be construed as specifications.