



Chemlon® 220 G

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight		
Features	• Good Processability	• Good Toughness	• High Strength
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.33		ASTM D792
Molding Shrinkage - Flow	5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	19000	psi	ASTM D638
Tensile Elongation (Yield)	3.5	%	ASTM D638
Flexural Modulus	825000	psi	ASTM D790
Flexural Strength (Yield)	28000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.7	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed	400	°F	
Melting Temperature	420	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150 to 180	°F
Suggested Max Moisture	0.20	%
Rear Temperature	520	°F
Middle Temperature	510	°F
Front Temperature	480	°F
Nozzle Temperature	480	°F
Mold Temperature	140 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

Notes

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