



Chemlon® 225 G

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 25% Filler by Weight
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm ³	ISO 1183
Molding Shrinkage	0.30 to 0.50	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	21500	psi	ISO 527
Tensile Strain (Yield)	3.0	%	ISO 527
Tensile Strain (Break)	3.0	%	ISO 527
Flexural Modulus	975000	psi	ISO 178/A
Flexural Stress	30000	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	2.9	ft-lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	385	°F	ISO 75-2/A
Melting Temperature	421	°F	ISO 11357
CLTE - Flow	2.9E-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)	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

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