



Chemlon® 225-15 MG

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight • Mineral, 25% Filler by Weight		
Automotive Specifications	• FORD ESB-M4D353-A3 ¹		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.52		ASTM D792
Molding Shrinkage - Flow	1.5E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	18500	psi	ASTM D638
Tensile Elongation (Yield)	2.5	%	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength	27500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.6	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	401	°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	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	
RTI Imp			UL 746B
0.03 in	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	
RTI Str			UL 746B
0.03 in	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	300	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	24	%	ASTM D2863

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

Notes

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