



Chemlon® 225-15 MGH

Teknor Apex Company - Polyamide 6

General Information

Product Description

Chemlon® 225-15 MGH is a 25% mineral and 15% 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	• FORD WSK-M4D822-A ¹ • GM GMP.PA6.012 Color: Natural ¹	• GM GMW8752P-PA6-M25-GF15H ¹ • STELLANTIS MS-DB-41 CPN2927 Color: BK001 Black ¹	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.49	--	g/cm ³	ISO 1183
Molding Shrinkage - Flow	1.5E-3 to 4.0E-3	--	in/in	ISO 294-4
Molding Shrinkage - Across Flow	1.1	--	%	ISO 294-4
Water Absorption (24 hr)	0.50	--	%	ISO 62
Water Absorption Saturation, 73°F	1.7	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.57E+6	746000	psi	ISO 527
Tensile Stress	17800	10400	psi	ISO 527
Tensile Strain (Break)	2.5	7.4	%	ISO 527
Flexural Modulus	1.40E+6	669000	psi	ISO 178
Flexural Strength	26700	13900	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	2.1	3.9	ft-lb/in ²	ISO 179
Charpy Unnotched Impact Strength	21	28	ft-lb/in ²	ISO 179
Notched Izod Impact Strength 73°F	2.2	3.9	ft-lb/in ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed	415	--	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	401	--	°F	ISO 75-2/A
Melting Temperature	428	--	°F	ISO 11357
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.03 in)	HB	--		UL 94

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Processing Information

Injection	Dry	Unit
Drying Temperature	176	°F
Suggested Max Moisture	0.12	%
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

¹ Automotive site approvals apply for US manufactured compound only

² Typical properties: these are not to be construed as specifications.