



Chemlon® 230 G

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Uses	• Consumer Applications
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Molding Shrinkage ²	0.15 to 0.40	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	22900	psi	ISO 527-2
Tensile Strain (Yield)	3.0	%	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	1.23E+6	psi	ISO 178
Flexural Stress	32600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/1A
-40°F	4.3	ft·lb/in ²	
73°F	4.8	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed	401	°F	
Melting Temperature	428	°F	ASTM D789
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	22	%	ISO 4589-2

Processing Information

Injection	Nominal Value	Unit
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	455 to 473	°F
Middle Temperature	473 to 500	°F
Front Temperature	473 to 518	°F
Nozzle Temperature	473 to 518	°F
Processing (Melt) Temp	473 to 518	°F

Notes

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

² Dependent upon molding conditions particularly Mold temperature.