



Chemlon® 233 GH

Teknor Apex Company - Polyamide 6

General Information

Product Description

Chemlon® 233 GH is a 33% glass fiber reinforced, heat stabilized polyamide 6 (PA 6) designed for injection molding. This material has a wide processing window, provides a good surface appearance, 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 Processability • Good Surface Finish	• Good Thermal Stability • High Tensile Strength	
RoHS Compliance	• Contact Manufacturer		
Automotive Specifications	• GM GMP.PA6.009 Color: Black ¹		• GM GMP.PA6.009 Color: Natural ¹
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.38	--	g/cm ³	ISO 1183
Molding Shrinkage - Flow	1.0E-3	--	in/in	ISO 294-4
Molding Shrinkage - Across Flow	0.20	--	%	ISO 294-4
Water Absorption (24 hr, 73°F)	0.90	--	%	ISO 62
Water Absorption Saturation, 73°F	2.1	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1.77E+6	1.08E+6	psi	ISO 527
Tensile Stress	23200	14500	psi	ISO 527
Tensile Strain (Break)	3.0	6.0	%	ISO 527
Flexural Modulus	1.20E+6	900000	psi	ISO 178
Flexural Stress	33400	21000	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	3.3	4.8	ft·lb/in ²	ISO 179
Charpy Unnotched Impact Strength	25	32	ft·lb/in ²	ISO 179
Notched Izod Impact Strength 73°F	4.8	5.5	ft·lb/in ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed	424	--	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	> 392	--	°F	ISO 75-2/A
Melting Temperature	428	--	°F	
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.03 in)	HB	--		UL 94

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Legal Statement

Dry

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Processing Information

Injection	Dry	Unit
Drying Temperature	176	°F
Suggested Max Moisture	0.13	%
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.