



Chemlon® 233 GV

Teknor Apex Company (Chem Polymer) - Polyamide 6

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.59		ASTM D792
Molding Shrinkage - Flow	1.5E-3 to 3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	21800	psi	ASTM D638
Tensile Elongation (Yield)	1.5	%	ASTM D638
Tensile Elongation (Break)	1.8	%	ASTM D638
Flexural Modulus	1.38E+6	psi	ASTM D790
Flexural Strength	29500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	407	°F	ASTM D648
Melting Temperature	425	°F	DSC
CLTE - Flow	2.8E-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)	380	V/mil	ASTM D149
Comparative Tracking Index (CTI)	300	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	V-0		UL 94
Oxygen Index	33	%	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	465 to 495	°F
Middle Temperature	505 to 535	°F
Front Temperature	505 to 545	°F
Nozzle Temperature	505 to 545	°F
Processing (Melt) Temp	505 to 545	°F