



Chemlon® 240 MH

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Mineral, 40% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Heat Stabilized	• Warp Resistant	
Automotive Specifications	• GM GMP.PA6.011 Color: Black ¹	• GM GMP.PA6.011 Color: Natural ¹	
Forms	• Pellets		

ASTM & ISO Properties ²

Physical	Nominal Value	Unit	Test Method
Density	1.51	g/cm ³	ISO 1183
Molding Shrinkage	0.60 to 1.0	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	12900	psi	ISO 527
Tensile Strain (Break)	4.0	%	ISO 527
Flexural Modulus	850000	psi	ISO 178/A
Flexural Stress	20700	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	> 1.9	ft-lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	> 178	°F	ISO 75-2/A
Melting Temperature	420	°F	
CLTE - Flow	3.1E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	280	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	23	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	425 to 455	°F
Middle Temperature	485 to 495	°F
Front Temperature	485 to 515	°F
Nozzle Temperature	485 to 515	°F
Processing (Melt) Temp	480 to 515	°F