



Chemlon® 253 U

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Impact Modifier	• UV Stabilizer	
Features	• General Purpose	• Impact Modified	
	• Good Toughness	• Medium Viscosity	
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.10		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (73°F)	9000	psi	ASTM D638
Tensile Elongation (Break, 73°F)	50	%	ASTM D638
Flexural Modulus (73°F)	325000	psi	ASTM D790
Flexural Strength (73°F)	12500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	2.5	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	130	°F	ASTM D648
Melting Temperature	410	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating	HB		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150 to 180	°F
Suggested Max Moisture	0.20	%
Rear Temperature	470	°F
Middle Temperature	450	°F
Front Temperature	440	°F
Nozzle Temperature	450	°F
Mold Temperature	70 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

Notes

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