



Chemlon® 253

Teknor Apex Company - Polyamide 6

General Information

Product Description

Impact modified polyamide 6.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Impact Modifier		
Features	• Medium Impact Resistance		
RoHS Compliance	• Contact Manufacturer		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.013 to 0.020	in/in	ISO 294-4
Molding Shrinkage - Across Flow	0.016	in/in	ISO 294-4
Water Absorption (24 hr, 73°F)	0.88	%	ISO 62
Water Absorption (Saturation, 73°F)	2.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	392000	psi	ISO 527-1
Tensile Stress (Break)	8700	psi	ISO 527-2
Tensile Strain (Break)	50	%	ISO 527-2
Flexural Modulus	334000	psi	ISO 178/A
Flexural Stress	12300	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	6.2	ft-lb/in ²	ISO 179
Charpy Unnotched Impact Strength	No Break		ISO 179
Notched Izod Impact Strength (73°F)	6.7	ft-lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	293	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	140	°F	ISO 75-2/A
Melting Temperature	428	°F	DSC
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94

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Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	425 to 455	°F
Middle Temperature	445 to 485	°F
Front Temperature	465 to 500	°F
Nozzle Temperature	465 to 510	°F
Processing (Melt) Temp	465 to 510	°F

Notes

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