



Chemlon® 275 H

Teknor Apex Company - Polyamide 6

General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Automotive Specifications	• FORD ESB-M4D423-A2 ¹ • FORD ESF-M4D423-A ¹ • FORD ESF-M4D426-A ¹ • GM GMP.PA6.003 Color: Black ¹ • GM GMP.PA6.004 ¹ • PACKARD M-2170 ¹ • STELLANTIS MS-DB-41 Type PA CPN2785 Color: BK001 Black ¹		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ²

Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	3.0	g/10 min	ISO 1133
Molding Shrinkage	1.5 to 2.4	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	6530	psi	ISO 527
Tensile Strain (Break)	> 200	%	ISO 527
Flexural Modulus	109000	psi	ISO 178/A
Flexural Stress	3920	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	36	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	122	°F	ISO 75-2/A
Melting Temperature	419	°F	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	330	V/mil	ASTM D149
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.031 in)	HB		UL 94
FMVSS Flammability	PASSES		FMVSS 302

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Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.15	%
Suggested Max Regrind	25	%
Rear Temperature	420 to 455	°F
Middle Temperature	445 to 485	°F
Front Temperature	465 to 490	°F
Nozzle Temperature	465 to 490	°F
Processing (Melt) Temp	465 to 490	°F

Notes

¹ Automotive site approvals apply for US manufactured compound only

² Typical properties: these are not to be construed as specifications.