



Chemlon® 280 H

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Heat Stabilizer	• Impact Modifier	
Features	• Good Flexibility • Good Impact Resistance • Good Processability	• Good Toughness • Heat Stabilized • High Strength	• Impact Modified
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	6530	psi	ISO 527
Tensile Strain (Break)	75	%	ISO 527
Flexural Modulus	247000	psi	ISO 178/A
Flexural Stress	8700	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	29	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact Strength			ISO 180
-40°F	9.5	ft·lb/in ²	
73°F	31	ft·lb/in ²	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed	113	°F	
Melting Temperature	428	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.031 in)	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.