



Chemlon® 280

Teknor Apex Company - Polyamide 6

General Information			
Product Description			
Impact modified nylon 6			
General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Impact Modifier		
Features	• General Purpose		
RoHS Compliance	• Contact Manufacturer		
Forms	• Pellets		
Processing Method	• Injection Molding		
Resin ID (ISO 1043)	• PA6		

ASTM & ISO Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density	1.07	g/cm³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.8	%	
Flow	1.9	%	
Water Absorption (24 hr, 73°F)	1.1	%	ISO 62
Water Absorption (Saturation, 73°F)	2.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	276000	psi	ISO 527-1
Tensile Stress (Break)	5800	psi	ISO 527
Tensile Strain (Break)	80	%	ISO 527
Flexural Modulus	218000	psi	ISO 178/A
Flexural Stress	7250	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	40	ft-lb/in²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break		ISO 179
Notched Izod Impact Strength (73°F)	36	ft-lb/in²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	239	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed	113	°F	ISO 75-2/A
Melting Temperature	428	°F	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+18	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	250	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	20	%	ASTM D2863

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Processing Information		
Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Rear Temperature	425 to 455	°F
Middle Temperature	465 to 495	°F
Front Temperature	475 to 515	°F
Nozzle Temperature	475 to 515	°F
Processing (Melt) Temp	480 to 510	°F

Notes

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