



Chemlon® 430GHU BK400

Teknor Apex Company (Chem Polymer) - Polyamide 6

General Information

Product Description

430GHU BK400 is a 30% glass fibre reinforced Nylon 6 compound that contains 2% carbon black by weight for robust outdoor weathering performance.

General

Material Status	• Commercial: Active		
Availability	• Europe		
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Additive	• Carbon Black (2%)	• Heat Stabilizer	• UV Stabilizer
Features	• Heat Stabilized	• Light Stabilized	• Weather Resistant
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Molding Shrinkage ²	0.30 to 0.80	%	Internal Method
Water Absorption (Equilibrium, 73°F, 50% RH)	2.1	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.16E+6	psi	ISO 527-2
Tensile Stress	21800	psi	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	1.02E+6	psi	ISO 178
Flexural Stress	24700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength	3.8	ft-lb/in ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (66 psi, Unannealed)	> 392	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	392	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	20	hr
Rear Temperature	482 to 536	°F
Middle Temperature	482 to 536	°F
Front Temperature	482 to 536	°F
Processing (Melt) Temp	482 to 554	°F
Mold Temperature	140 to 176	°F
Injection Rate	Fast	
Back Pressure	Moderate	
Screw Speed	Moderate	

Injection Notes

No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.