



Chemlon® 433 GH

Teknor Apex Company - Polyamide 6

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 33% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Good Dimensional Stability	• High Impact Resistance	
	• Heat Stabilized	• High Tensile Strength	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.39	g/cm ³	ISO 1183
Molding Shrinkage	0.10 to 0.30	%	ISO 2577
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	21000	psi	ISO 527
Tensile Strain (Break)	2.5	%	ISO 527
Flexural Modulus	1.23E+6	psi	ISO 178/A
Flexural Stress	27600	psi	ISO 178/A
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	3.1	ft-lb/in ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	383	°F	ISO 75-2/A
Melting Temperature	428	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Suggested Max Moisture	0.13	%
Processing (Melt) Temp	464 to 500	°F
Mold Temperature	171 to 190	°F

Injection Notes

Maximum peak injection pressure should not exceed 80% of the machine's maximum pressure capability. Start with a holding pressure that is half the peak injection pressure. Perform a rheology curve in order to determine appropriate injection rate.

Notes

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