+135-3858-6433 (GuangDong)
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TEKNOR APEX

Chemlon® N60A

Teknor Apex Company (Chem Polymer) - Polyamide 6

General Information

Product Description

N60A is a general purpose, unfilled, nucleated and lubricated injection moulding grade of nylon 6.

General

Material Status	• Commercial: Active		
Availability	• Europe	• North America	
Additive	• Lubricant	• Nucleating Agent	
Features	• General Purpose	• Lubricated	• Nucleated
Uses	• General Purpose		
Processing Method	• Injection Molding		

ASTM & ISO Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm³	ISO 1183
Molding Shrinkage [2]	1.2 to 2.0	--	%	Internal Method
Water Absorption				ISO 62
Equilibrium, 73°F, 50% RH	3.0	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	435000	145000	psi	ISO 527-2
Tensile Stress (Yield)	9860	5220	psi	ISO 527-2
Flexural Modulus	421000	116000	psi	ISO 178
Flexural Stress [3]	11600	3630	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	5.2	--	ft·lb/in²	ISO 179
Charpy Unnotched Impact Strength	No Break	No Break		ISO 179
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/B
66 psi, Unannealed	374	--	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	194	--	°F	
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+15	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+14	ohms·cm	IEC 60093
Electric Strength (0.118 in)	360	250	V/mil	IEC 60243-1
Relative Permittivity (1 MHz)	3.60	4.20		IEC 60250
Comparative Tracking Index	> 600	> 600	V	IEC 60112
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Glow Wire Flammability Index				IEC 60695-2-12
0.06 in	1380	--	°F	

Processing Information

Injection	Dry	Unit
Drying Temperature	176 to 212	°F
Drying Time	2.0	hr
Rear Temperature	446 to 500	°F
Middle Temperature	446 to 500	°F
Front Temperature	446 to 500	°F

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Injection	Dry	Unit
Processing (Melt) Temp	< 572	°F
Mold Temperature	104 to 176	°F
Injection Rate	Moderate	
Screw Speed	50 to 200	rpm

Injection Notes

Back pressure: Low
Injection pressure: Medium

No drying is necessary unless the materials has been exposed to air for longer than three hours.

Notes

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

[2] Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions. The range values stated were determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).

[3] At conventional deflection