



Chemlon® 340 G

Teknor Apex Company (Chem Polymer) - Polyamide 610

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42		ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/5.0 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.0E-3 to 3.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	24000	psi	ASTM D638
Tensile Elongation (Yield)	2.5	%	ASTM D638
Tensile Elongation (Break)	2.7	%	ASTM D638
Flexural Modulus	1.33E+6	psi	ASTM D790
Flexural Strength	35000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	3.0	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed	412	°F	ASTM D648
Melting Temperature	433	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	25	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	455 to 485	°F
Middle Temperature	475 to 515	°F
Front Temperature	495 to 525	°F
Nozzle Temperature	485 to 535	°F
Processing (Melt) Temp	485 to 530	°F

Notes

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