

# Chemlon® 212 H

Teknor Apex Company (Chem Polymer) - Polyamide 6

Wednesday, April 19, 2017

## General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Additive	• Heat Stabilizer	• Lubricant	
Features	• General Purpose • Good Mold Release	• Heat Stabilized • Lubricated	• Medium Viscosity
Automotive Specifications	• GM GMP.PA6.008 Color: Black	• GM GMP.PA6.008 Color: Natural	
Appearance	• Natural Color		
Forms	• Pellets		
Processing Method	• Injection Molding		

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4 to 1.8	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (23°C)	79.3	MPa	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break, 23°C)	50	%	ASTM D638
Flexural Modulus (23°C)	2860	MPa	ASTM D790
Flexural Strength (23°C)	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed	185	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed	92.2	°C	ASTM D648
Melting Temperature	216	°C	
CLTE - Flow	6.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (3.00 mm)	14	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	V-2		UL 94
Oxygen Index	25	%	ASTM D2863

Revision Date: 12/11/2008

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### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	79	°C
Suggested Max Moisture	0.20	%
Suggested Max Regrind	25	%
Rear Temperature	218 to 235	°C
Middle Temperature	229 to 252	°C
Front Temperature	241 to 260	°C
Nozzle Temperature	241 to 266	°C
Processing (Melt) Temp	241 to 266	°C

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

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