

Chemlon® 212 H

Teknor Apex Company (Chem Polymer) - Polyamide 6

Friday, March 18, 2016

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		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13		ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.014 to 0.018	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (73°F)	11500	psi	ASTM D638
Tensile Elongation (Yield)	5.0	%	ASTM D638
Tensile Elongation (Break, 73°F)	50	%	ASTM D638
Flexural Modulus (73°F)	415000	psi	ASTM D790
Flexural Strength (73°F)	15000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.0	ft-lb/in	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 (66 psi, Unannealed)	365	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	198	°F	ASTM D648
Melting Temperature	420	°F	
CLTE - Flow	3.4E-5	in/in/°F	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	360	V/mil	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.0319 in)	V-2		UL 94
Oxygen Index	25	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%

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Injection	Nominal Value	Unit
Rear Temperature	425 to 455	°F
Middle Temperature	445 to 485	°F
Front Temperature	465 to 500	°F
Nozzle Temperature	465 to 510	°F
Processing (Melt) Temp	465 to 510	°F

Notes

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

Teknor Apex Company Corporate Headquarters

*In U.S. for Vinyls, TPEs, Colorants,
Engineered Thermoplastics (Chem Polymer)*
505 Central Avenue
Pawtucket, Rhode Island 02861 U.S.

Phone: 401-725-8000
Fax: 401-725-8095
Toll Free (U.S. only) 800-556-3864

www.teknorapex.com
info@teknorapex.com

Teknor Apex U.K. Ltd.

Tat Bank Road
Oldbury, West Midlands B69 4NH England

Phone: (44) 121-665-2100
Fax: (44) 121-544-5530

www.teknorapex.com
etpsales@teknorapex.co.uk

Teknor Apex (Suzhou) Advanced Polymer Compounds Co. Pte. Ltd.

No. 78 Ping Sheng Road
Suzhou Industrial Park
Jiangsu, China 215126

Phone: (86) 512-6287-1550
Fax: (86) 512-6288-8371

www.teknorapex.com
infotaap@teknorapex.com

Teknor Apex Asia Pacific PTE. LTD.

41 Shipyard Road
Singapore 628134

Phone: (65) 6265-2544
Fax: (65) 6265-1821

www.teknorapex.com
infotaap@teknorapex.com

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