

Chemlon® 230 GH

Teknor Apex Company (Chem Polymer) - Polyamide 6

Monday, November 7, 2016

General Information

General	
Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight
Uses	• Automotive Applications
Automotive Specifications	• GM GMP.PA6.054 Color: Black • GM GMP.PA6.054 Color: Natural
Forms	• Pellets
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Molding Shrinkage ²	0.15 to 0.40	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	158	MPa	ISO 527-2
Tensile Strain (Yield)	3.0	%	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	8100	MPa	ISO 178
Flexural Stress	225	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/1A
-40°C	9.0	kJ/m ²	
23°C	11	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	200	°C	ISO 75-2/A
Melting Temperature	220	°C	ASTM D789
CLTE - Flow	5.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	ISO 1325
Dielectric Strength (3.00 mm)	11	kV/mm	ASTM D149
Comparative Tracking Index	> 600	V	Internal Method
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94
Oxygen Index	22	%	ISO 4589-2
FMVSS Flammability	Passed		FMVSS 302

Processing Information

Injection	Nominal Value	Unit
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	235 to 245	°C
Middle Temperature	245 to 260	°C
Front Temperature	245 to 270	°C
Nozzle Temperature	245 to 270	°C
Processing (Melt) Temp	245 to 270	°C

Revision Date: 3/12/2010

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Notes

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

² Dependent upon molding conditions particularly Mold temperature.

**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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