

Chemlon® 280

Teknor Apex Company (Chem Polymer) - Polyamide 6

Friday, March 17, 2017

General Information

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.8 to 2.3	%	ASTM D955
Water Absorption (24 hr)	0.80	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	41.4	MPa	ASTM D638
Tensile Elongation (Yield)	7.0	%	ASTM D638
Tensile Elongation (Break)	150	%	ASTM D638
Flexural Modulus	1620	MPa	ASTM D790
Flexural Strength	55.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	290	J/m	
23°C	1200	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed	135	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed	51.7	°C	ASTM D648
Melting Temperature	217	°C	DSC
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+18	ohms·cm	ASTM D257
Dielectric Strength (3.00 mm)	10	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	500	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.8 mm)	HB		UL 94
Oxygen Index	20	%	ASTM D2863

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	79	°C
Suggested Max Moisture	0.20	%
Rear Temperature	218 to 235	°C
Middle Temperature	241 to 257	°C
Front Temperature	246 to 268	°C
Nozzle Temperature	246 to 268	°C
Processing (Melt) Temp	249 to 266	°C

Revision Date: 12/11/2008

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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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