

# Chemlon® 214 G

Teknor Apex Company (Chem Polymer) - Polyamide 6

Thursday, December 22, 2016

## General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 14% Filler by Weight		
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.50 to 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	114	MPa	ASTM D638
Tensile Elongation (Yield)	3.0	%	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus	4310	MPa	ASTM D790
Flexural Strength	162	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed	204	°C	ASTM D648
Deflection Temperature Under Load 1.8 MPa, Unannealed	188	°C	ASTM D648
Melting Temperature	216	°C	DSC
CLTE - Flow	5.5E-5	cm/cm/°C	ASTM D696
RTI Elec			UL 746
0.8 mm	105	°C	
1.5 mm	105	°C	
3.0 mm	105	°C	
RTI Imp			UL 746
0.8 mm	75.0	°C	
1.5 mm	75.0	°C	
3.0 mm	75.0	°C	
RTI Str			UL 746
0.8 mm	105	°C	
1.5 mm	105	°C	
3.0 mm	105	°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (3.00 mm)	11	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	22	%	ASTM D2863
FMVSS Flammability	PASSES		FMVSS 302

Revision Date: 4/28/2010

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### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	79	°C
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
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

### Notes

<sup>1</sup> 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](http://www.teknorapex.com)  
[info@teknorapex.com](mailto: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](http://www.teknorapex.com)  
[etpsales@teknorapex.co.uk](mailto: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](http://www.teknorapex.com)  
[infotaap@teknorapex.com](mailto: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](http://www.teknorapex.com)  
[infotaap@teknorapex.com](mailto:infotaap@teknorapex.com)

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