

# Chemlon® 225-15 MGH

Teknor Apex Company (Chem Polymer) - Polyamide 6

Monday, March 19, 2018

## General Information

General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight	• Mineral, 25% Filler by Weight	
Additive	• Heat Stabilizer		
Features	• Good Dimensional Stability • Good Processability • Good Toughness	• Heat Stabilized • High Rigidity • High Strength	• Low Warpage
Automotive Specifications	• CHRYSLER MS-DB-41 CPN2927 Color: BK001 Black • FORD WSK-M4D822-A	• GM GMP.PA6.012 Color: Natural • GM GMW8752P-PA6-M25-GF15H	
Appearance	• Black	• Natural Color	
Forms	• Pellets		
Processing Method	• Injection Molding		

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.50		ASTM D792
Molding Shrinkage - Flow	1.5E-3 to 4.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	18500	psi	ASTM D638
Tensile Elongation (Yield)	2.5	%	ASTM D638
Tensile Elongation (Break)	2.5	%	ASTM D638
Flexural Modulus	1.10E+6	psi	ASTM D790
Flexural Strength	27500	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F)	1.6	ft-lb/in	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	415	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed	401	°F	ASTM D648
Melting Temperature	420	°F	
CLTE - Flow	3.1E-5	in/in/°F	ASTM D696
RTI Elec			UL 746
0.03 in	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	
RTI Imp			UL 746
0.03 in	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	

Revision Date: 12/11/2008

The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable but no guarantee of their accuracy is made. All products are sold upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses and purchasers assume all risks and liability for the results of use of the products, including use in accordance with seller's recommendations. Nothing in this bulletin constitutes permission or a recommendation to practice or use any invention covered by any patent owned by this company or by others. There is no warranty of merchantability and there are no other warranties for the products described.

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Thermal	Nominal Value	Unit	Test Method
RTI Str			UL 746
0.03 in	149	°F	
0.06 in	149	°F	
0.12 in	149	°F	

  

Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Dielectric Strength (0.118 in)	300	V/mil	ASTM D149
Comparative Tracking Index (CTI)	500	V	UL 746

  

Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 in)	HB		UL 94
Oxygen Index	24	%	ASTM D2863

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Suggested Max Moisture	0.20	%
Suggested Max Re grind	25	%
Rear Temperature	425 to 455	°F
Middle Temperature	475 to 495	°F
Front Temperature	475 to 515	°F
Nozzle Temperature	475 to 515	°F
Processing (Melt) Temp	480 to 510	°F
Mold Temperature	140 to 200	°F
Injection Pressure	5000 to 20000	psi
Screw Speed	60 to 120	rpm

### Notes

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

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