

Chemlon® 830GHI

Polyamide 6/12 Copolymer

Teknor Apex Company (Chem Polymer)

Message:

830GHI is an impact modified, 30% glass fibre reinforced, heat stabilised grade of PA612. It offers good mechanical strength and low moisture absorption.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Impact modifier heat stabilizer		
Features	Impact modification Low hygroscopicity Good strength Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ISO 1183
Molding Shrinkage ¹	1.0 - 1.2	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	0.80	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	133	MPa	ISO 527-2
Tensile Strain (Break)	4.0	%	ISO 527-2
Flexural Modulus	6750	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	15	kJ/m ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	175	°C	ISO 75-2/A
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Rear Temperature	240 - 280	°C	
Middle Temperature	240 - 280	°C	
Front Temperature	240 - 280	°C	
Processing (Melt) Temp	240 - 280	°C	
Mold Temperature	80.0 - 90.0	°C	
Injection Rate	Fast		
Back Pressure	Low		

Screw Speed	Moderate
Injection instructions	
No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.	
NOTE	

1.	Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).
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