

Chemlon® 253 H

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

Chemlon® 253 H is a Polyamide 6 (Nylon 6) material. It is available in Asia Pacific, Europe, or North America for injection molding.

Important attributes of Chemlon® 253 H are:

Flame Rated

Good Toughness

Heat Stabilizer

Impact Modified

Medium Viscosity

Typical application of Chemlon® 253 H: Automotive

General Information			
Additive	Heat Stabilizer		
	Impact Modifier		
Features	Good Toughness		
	Heat Stabilized		
	Impact Modified		
	Medium Viscosity		
Appearance	Black		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.11	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.5 to 1.9	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	65.5	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	5.0	%	
Break	50	%	
Flexural Modulus	2210	MPa	ASTM D790
Flexural Strength	82.7	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C	130	J/m	
23°C	190	J/m	

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	60.0	°C	ASTM D648
Melting Temperature	216	°C	
CLTE - Flow	8.5E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+13	ohms·cm	ASTM D257
Dielectric Strength (3.00 mm)	12	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.810 mm)	HB		UL 94
Oxygen Index	21	%	ASTM D2863
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Suggested Max Moisture	0.20	%	
Suggested Max Regrind	25	%	
Rear Temperature	218 to 235	°C	
Middle Temperature	229 to 252	°C	
Front Temperature	241 to 260	°C	
Nozzle Temperature	241 to 266	°C	
Processing (Melt) Temp	241 to 266	°C	

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