Chemlon® 813CI

Polyamide 6/12 Copolymer

Teknor Apex Company (Chem Polymer)

Message:

813CI is an impact modified, 13% carbon fibre reinforced grade of PA612. It offers a combination of good mechanical strength, low density and low moisture absorption.

General Information			
Filler / Reinforcement	Carbon fiber reinforced material, 13% filler by weight		
Additive	Impact modifier		
Features	Impact modification Low density Low hygroscopicity Good strength		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.11	g/cm³	ISO 1183
Molding Shrinkage [1]	0.20 - 1.0	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	1.0	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress	150	MPa	ISO 527-2
Tensile Strain (Break)	4.5	%	ISO 527-2
Flexural Modulus	6750	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	10	kJ/m²	ISO 180/A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (1.8 MPa, Unannealed)	180	°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).

Recommended distributors for this material

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