

Chemlon® 412 H

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

Chemlon® 412 H is a Polyamide 6 (Nylon 6) material. It is available in Asia Pacific, Europe, or North America for injection molding. Primary attribute of Chemlon® 412 H: Flame Rated.
Typical application of Chemlon® 412 H: Automotive

General Information			
Uses	Automotive Applications		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4 to 1.8	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	75.8	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	5.0	%	
Break	40	%	
Flexural Modulus	2790	MPa	ASTM D790
Flexural Strength	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	182	°C	
1.8 MPa, Unannealed	90.6	°C	
Melting Temperature	216	°C	
CLTE - Flow	6.2E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength (3.00 mm)	14	kV/mm	ASTM D149
Comparative Tracking Index (CTI)	600	V	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.810 mm)	V-2		UL 94
Oxygen Index	25	%	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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Recommended distributors for this material

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