Chemlon® 60AL

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

Chemlon® 60AL is a UV stabilised, unfilled injection moulding grade of nylon 6

General Information			
Additive	UV stabilizer		
Features	Light stabilization		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.13	g/cm³	ISO 1183
Molding Shrinkage [1]	1.5 - 1.8	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.8	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2900	MPa	ISO 527-2
Tensile Stress	80.0	MPa	ISO 527-2
Tensile Strain (Break)	6.0	%	ISO 527-2
Flexural Modulus	2800	MPa	ISO 178
Flexural Stress (3.5% Strain)	70.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	7.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break		ISO 179/1eU
Notched Izod Impact	4.0	kJ/m²	ISO 180/A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	185	°C	ISO 75-2/B
1.8 MPa, not annealed	70.0	°C	ISO 75-2/A
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	ohms	IEC 60093
Volume Resistivity	1.0E+16	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	13	kV/mm	IEC 60243-1
Comparative Tracking Index	600	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.50 mm, Teknor Apex test result)	HB		UL 94
Oxygen Index	24	%	ISO 4589-2
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	

Rear Temperature	230 - 260	°C
Middle Temperature	230 - 260	°C
Front Temperature	230 - 260	°C
Processing (Melt) Temp	230 - 260	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Fast	
Back Pressure	Moderate	
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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