Chemlon® 235G

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

235G is a 35% glass fibre reinforced nylon 6 that offers a balance between mechanical performance, surface finish and mould release characteristics.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 35% filler by weight		
Processing Method		Injection molding		
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.41	--	g/cm³	ISO 1183
Molding Shrinkage [1]	0.70 - 1.2	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	1.9	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	10000	8000	MPa	ISO 527-2
Tensile Stress	180	120	MPa	ISO 527-2
Tensile Strain (Break)	4.0	6.0	%	ISO 527-2
Flexural Modulus	9200	4500	MPa	ISO 178
Flexural Stress	260	140	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	17	37	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength	55	--	kJ/m²	ISO 179/1eU
Notched Izod Impact	14	--	kJ/m²	ISO 180/A
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	> 200	--	°C	ISO 75-2/B
1.8 MPa, not annealed	> 200	--	°C	ISO 75-2/A
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	11	8.0	kV/mm	IEC 60243-1
Relative Permittivity	3.80	4.20		IEC 60250
Comparative Tracking Index	500	--	V	IEC 60112
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Flame Rating (1.50 mm, Teknor Apex test result)	HB	--		UL 94

Oxygen Index	24	--	%	ISO 4589-2
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	20		hr	
Rear Temperature	250 - 280		°C	
Middle Temperature	250 - 280		°C	
Front Temperature	250 - 280		°C	
Processing (Melt) Temp	250 - 290		°C	
Mold Temperature	70.0 - 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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