

# Chemlon® E-6

Polyamide 6

Teknor Apex Company (Chem Polymer)

## Message:

Chemlon® E-6 is an economy range Nylon 6 injection moulding grade.  
It is available in natural or black versions.

General Information			
Appearance	Black		
	Natural color		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage <sup>1</sup>	1.2 - 2.0	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.7	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-2
Tensile Stress (Yield)	70.0	MPa	ISO 527-2
Tensile Strain (Yield)	5.0	%	ISO 527-2
Flexural Modulus	2700	MPa	ISO 178
Flexural Stress	95.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	3.5	kJ/m <sup>2</sup>	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	> 180	°C	ISO 75-2/B
1.8 MPa, not annealed	85.0	°C	ISO 75-2/A
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	< 300	°C	
Mold Temperature	80.0 - 90.0	°C	
Injection Rate	Fast		
Screw Speed	50 - 200	rpm	
Injection instructions			

Back pressure: LowInjection pressure: HighThe material is supplied dry and ready to mould in sealed, moisture proof sacks. 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. Should drying become necessary, two hours at 80°C in a dehumidifying drier is recommended. The use of air circulating driers is not generally recommended, as longer drying times are often required, with greater potential for product oxidation and yellowing. Drying temperatures should not exceed 80°C.

NOTE

- Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions.The range values stated were 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).
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