

# Chemlon® 204-13 GVNH

## Teknor Apex Company - Polyamide 6

Saturday, September 14, 2024

### General Information

#### Product Description

Chemlon® 204-13 GVNH is a flame retardant, 15% glass fiber reinforced polyamide 6 (PA 6) designed for injection molding. This material has low halogen content and is available globally.

#### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Flame Retardant	• Heat Stabilizer	
Features	• Flame Retardant	• Low Halogen Content	
RoHS Compliance	• Contact Manufacturer		
Automotive Specifications	• GM GMW16801 <sup>1</sup>	• GM GMW16801P-PA6-GF15-T1 <sup>1</sup>	
Forms	• Pellets		
Processing Method	• Injection Molding		

### ASTM & ISO Properties<sup>2</sup>

Physical	Dry	Conditioned	Unit	Test Method
Density	1.31	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.3	--	%	
Flow	0.20 to 0.35	--	%	
Water Absorption (24 hr, 23°C)	0.70	--	%	ISO 62
Water Absorption Saturation, 23°C	2.1	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5800	3230	MPa	ISO 527-2
Tensile Stress	91.0	56.0	MPa	ISO 527-2
Tensile Strain (Break)	3.5	16	%	ISO 527-2
Flexural Modulus	5700	2590	MPa	ISO 178
Flexural Stress	130	63.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	3.0	9.8	kJ/m <sup>2</sup>	
Charpy Unnotched Impact Strength	42	67	kJ/m <sup>2</sup>	ISO 179
Notched Izod Impact Strength				ISO 180
23°C	3.5	10	kJ/m <sup>2</sup>	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/B
0.45 MPa, Unannealed	202	--	°C	
Deflection Temperature Under Load				ISO 75-2/A
1.8 MPa, Unannealed	185	--	°C	
Melting Temperature (DSC)	220	--	°C	ISO 11357
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (3.2 mm, BLACK)	V-0	--		UL 94

Revision Date: 8/1/2024

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### Legal Statement

Dry

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### Processing Information

Injection	Dry Unit
Drying Temperature	80 °C
Suggested Max Moisture	0.17 %
Processing (Melt) Temp	240 to 260 °C
Mold Temperature	77 to 88 °C

### Injection Notes

Maximum peak injection pressure should not exceed 80% of the machine's maximum pressure capability. Start with a holding pressure that is half the peak injection pressure. Perform a rheology curve in order to determine appropriate injection rate.

### Notes

<sup>1</sup> Automotive site approvals apply for US manufactured compound only

<sup>2</sup> Typical properties: these are not to be construed as specifications.

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