

Chemlon® 225-15 MGH

Teknor Apex Company - Polyamide 6

Saturday, September 14, 2024

General Information

Product Description

Chemlon® 225-15 MGH is a 25% mineral and 15% glass fiber reinforced, heat stabilized polyamide 6 (PA 6) designed for injection molding. This material has a wide processing window, exhibits a good surface appearance and dimensional stability, and is available globally.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Heat Stabilizer		
Features	• Good Dimensional Stability • Good Processability	• Good Surface Finish • Good Thermal Stability	• High Tensile Strength
RoHS Compliance	• Contact Manufacturer		
Automotive Specifications	• CHRYSLER MS-DB-41 CPN2927 Color: BK001 Black ¹ • FORD WSK-M4D822-A ¹	• GM GMP.PA6.012 Color: Natural ¹ • GM GMW8752P-PA6-M25- GF15H ¹	
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.49	--	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.15 to 0.40	--	%	ISO 294-4
Molding Shrinkage - Across Flow	1.1	--	%	ISO 294-4
Water Absorption (24 hr)	0.90	--	%	ISO 62
Water Absorption Saturation, 23°C	1.7	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	10800	5140	MPa	ISO 527
Tensile Stress	123	72.0	MPa	ISO 527
Tensile Strain (Break)	2.5	7.4	%	ISO 527
Flexural Modulus	9640	4610	MPa	ISO 178
Flexural Strength	184	96.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	4.4	8.2	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	44	58	kJ/m ²	ISO 179
Notched Izod Impact Strength 23°C	4.7	8.3	kJ/m ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed	213	--	°C	ISO 75-2/B
Deflection Temperature Under Load 1.8 MPa, Unannealed	205	--	°C	ISO 75-2/A
Melting Temperature	220	--	°C	ISO 11357
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.8 mm)	HB	--		UL 94

Revision Date: 7/30/2024

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Legal Statement

Dry

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Processing Information

Injection	Dry Unit
Drying Temperature	80 °C
Suggested Max Moisture	0.12 %
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

¹ Automotive site approvals apply for US manufactured compound only

² Typical properties: these are not to be construed as specifications.

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