

Chemlon® 215-10 MGH

Teknor Apex Company - Polyamide 6

Saturday, September 14, 2024

General Information

Product Description

Chemlon® 215-10 MGH is a 15% mineral and 10% 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 ¹		
Forms	• Pellets		
Processing Method	• Injection Molding		

ASTM & ISO Properties ²

Physical	Dry	Conditioned	Unit	Test Method
Density	1.33	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	0.90	--	%	
Flow	0.50	--	%	
Water Absorption (24 hr, 23°C)	1.7	--	%	ISO 62
Water Absorption Saturation, 23°C	7.3	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5300	3850	MPa	ISO 527-2
Tensile Stress	108	59.0	MPa	ISO 527-2
Tensile Strain (Break)	4.0	12	%	ISO 527-2
Flexural Modulus	6040	3000	MPa	ISO 178
Flexural Stress	159	71.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
23°C	3.6	4.7	kJ/m ²	
Charpy Unnotched Impact Strength	32	59	kJ/m ²	ISO 179
Notched Izod Impact Strength				ISO 180
23°C	3.9	5.5	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/B
0.45 MPa, Unannealed	208	--	°C	
Deflection Temperature Under Load				ISO 75-2/A
1.8 MPa, Unannealed	183	--	°C	
Melting Temperature	220	--	°C	ISO 11357
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (0.8 mm)	HB	--		UL 94

Revision Date: 2/13/2023

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Legal Statement

Dry

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Processing Information

Injection	Dry Unit
Drying Temperature	80 °C
Suggested Max Moisture	0.15 %
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.

Teknor Apex Company Corporate Headquarters	Teknor Apex B.V.	Teknor Apex (Suzhou) Advanced Polymer Compounds Co. Pte. Ltd.	Teknor Apex Asia Pacific PTE. LTD.
<i>In U.S. for Vinyls, TPEs, Colorants,</i>	Brightlands Chemelot Campus Umonderbaan 22	No. 78 Ping Sheng Road	41 Shipyard Road
<i>Engineered Thermoplastics (Chem Polymer)</i> 505 Central Avenue Pawtucket, Rhode Island 02861 U.S.	6167 RD Geleen, Netherlands	Suzhou Industrial Park Jiangsu, China 215126	Singapore 628134
Phone: 401-725-8000 Fax: 401-725-8095 Toll Free (U.S. only) 800-556-3864	Phone: +31 46 7020 950 Fax: +31 46 7020 990 www.teknorapex.com tpe@teknorapex.com	Phone: (86) 512-6287-1550 Fax: (86) 512-6288-8371 www.teknorapex.com infotaap@teknorapex.com	Phone: (65) 6265-2544 Fax: (65) 6265-1821 www.teknorapex.com infotaap@teknorapex.com
www.teknorapex.com info@teknorapex.com			

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