

Chemlon® MDS4

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

MDS4 is a 25% glass sphere filled nylon 6 that offers increased rigidity coupled with low distortion.

General Information				
Filler / Reinforcement		Glass beads, 25% filler by weight		
Features		Low shrinkage		
		Excellent appearance		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.32	--	g/cm ³	ISO 1183
Molding Shrinkage ¹	1.1 - 1.8	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.3	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3600	--	MPa	ISO 527-2
Tensile Stress	70.0	40.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	5.0	%	ISO 527-2
Flexural Modulus	3500	1200	MPa	ISO 178
Flexural Stress	105	40.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	7.0	33	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break	No Break		ISO 179/1eU
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	110	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+15	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+17	1.0E+14	ohms · cm	IEC 60093
Dielectric Strength (3.00 mm)	10	9.0	kV/mm	IEC 60243-1
Comparative Tracking Index	525	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Oxygen Index	23	--	%	ISO 4589-2

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	hr
Rear Temperature	245 - 280	°C
Middle Temperature	245 - 280	°C
Front Temperature	245 - 280	°C
Processing (Melt) Temp	245 - 280	°C
Mold Temperature	60.0 - 80.0	°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).

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