

Chemlon® MDF4

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

MDF4 is a 15% glass fibre reinforced nylon 6 that offers improved mechanical performance coupled with good surface finish.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight		
Features		Excellent appearance		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.25	--	g/cm ³	ISO 1183
Molding Shrinkage ¹	1.0 - 1.6	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.5	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	5800	--	MPa	ISO 527-2
Tensile Stress (Break)	110	75.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	--	%	ISO 527-2
Flexural Modulus	5200	2700	MPa	ISO 178
Flexural Stress ²	170	90.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	8.0	30	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	30	--	kJ/m ²	ISO 179
Notched Izod Impact	7.5	--	kJ/m ²	ISO 180
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	190	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+14	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+14	ohms · cm	IEC 60093
Dielectric Strength (3.00 mm)	11	8.0	kV/mm	IEC 60243-1
Relative Permittivity	3.80	4.20		IEC 60250
Comparative Tracking Index	525	500	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Oxygen Index	22	--	%	ISO 4589-2

Injection	Dry	Unit
Drying Temperature	80.0 - 100	°C
Drying Time	2.0	hr
Rear Temperature	230 - 280	°C
Middle Temperature	230 - 280	°C
Front Temperature	230 - 280	°C
Processing (Melt) Temp	< 300	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Fast	
Screw Speed	50 - 200	rpm

Injection instructions

背压:低注射压力:高如果材料在空气中暴露的时间不超过3小时,则无需干燥.

NOTE

1. 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).
2. Break

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