

# Chemlon® MDF603

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

MDF603 is a 15% glass fibre reinforced, impact modified nylon 6 that offers good rigidity and toughness over a wide temperature range.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
	Good toughness		
	Medium hardness		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.20	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage <sup>1</sup>	0.80 - 1.6	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.2	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4400	MPa	ISO 527-2
Tensile Stress	90.0	MPa	ISO 527-2
Tensile Strain (Break)	9.0	%	ISO 527-2
Flexural Modulus	3600	MPa	ISO 178
Flexural Stress	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	15	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Izod Impact	12	kJ/m <sup>2</sup>	ISO 180/A
Unnotched Izod Impact Strength	> 45	kJ/m <sup>2</sup>	ISO 180
Thermal	Nominal Value	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
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm, Teknor Apex test result)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	20	hr	
Rear Temperature	250 - 280	°C	
Middle Temperature	250 - 280	°C	

Front Temperature	250 - 280	°C
Processing (Melt) Temp	250 - 290	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Fast	
Back Pressure	Moderate	
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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