

Chemlon® MDF4L

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

MDF4L is a 15% glass fibre reinforced, UV stabilised nylon 6 that offers improved mechanical performance, coupled with good surface finish and weathering resistance. The stabiliser package is colourless in the natural compound.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight		
Additive		UV stabilizer		
Features		Light stabilization		
		Good weather resistance		
		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	100	70.0	MPa	ISO 527-2
Tensile Strain (Yield)	3.0	--	%	ISO 527-2
Flexural Modulus	5200	2700	MPa	ISO 178
Flexural Stress	165	85.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	8.0	30	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	30	--	kJ/m ²	ISO 179/1eU
Notched Izod Impact	6.5	--	kJ/m ²	ISO 180/A
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

Comparative Tracking Index	525	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Oxygen Index	22	--	%	ISO 4589-2
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	2.0		hr	
Rear Temperature	230 - 280		°C	
Middle Temperature	230 - 280		°C	
Front Temperature	230 - 280		°C	
Processing (Melt) Temp	240 - 290		°C	
Mold Temperature	60.0 - 90.0		°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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