Chemlon® MDFS2

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

MDFS2 is a 50% glass reinforced nylon 6 that offers excellent mechanical performance coupled with good surface finish.

General Information				
Filler / Reinforcement	Glass fiber reinforced material, 50% filler by weight			
Features	Good liquidity Excellent appearance			
Processing Method	Injection molding			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.56	--	g/cm³	ISO 1183
Molding Shrinkage [1]	0.40 - 1.0	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	1.5	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	13500	9500	MPa	ISO 527-2
Tensile Stress	220	145	MPa	ISO 527-2
Tensile Strain (Break)	3.0	5.0	%	ISO 527-2
Flexural Modulus	12400	9000	MPa	ISO 178
Flexural Stress	295	200	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Notched Izod Impact	12	--	kJ/m²	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	> 200	--	°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)	11	8.0	kV/mm	IEC 60243-1
Comparative Tracking Index	525	--	V	IEC 60112
Injection	**Dry**	**Unit**		
Drying Temperature	80.0		°C	
Drying Time	2.0		hr	
Rear Temperature	250 - 295		°C	

Middle Temperature	250 - 295	°C
Front Temperature	250 - 295	°C
Processing (Melt) Temp	275 - 300	°C
Mold Temperature	80.0 - 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).

Recommended distributors for this material

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