Chemlon® MDMF31

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

MDMF31 is a 30% heat stabilised glass fibre and mineral reinforced grade of nylon 6.

General Information				
Filler / Reinforcement	Glass \mineral, 30% filler by weight			
Additive	heat stabilizer			
Features	Good strength Thermal Stability Medium hardness			
Processing Method	Injection molding			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.37	--	g/cm³	ISO 1183
Molding Shrinkage [1]	0.50 - 1.2	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.1	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	6500	3200	MPa	ISO 527-2
Tensile Stress	105	60.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	5.0	%	ISO 527-2
Flexural Modulus	6000	3000	MPa	ISO 178
Flexural Stress	150	85.0	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	6.0	12	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength	50	--	kJ/m²	ISO 179/1eU
Notched Izod Impact	4.0	--	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	160	--	°C	ISO 75-2/A
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+13	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	10	9.0	kV/mm	IEC 60243-1

Comparative Tracking Index	500	--	V	IEC 60112

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	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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