



Chemlon® MD3G

Teknor Apex Company - Polyamide 6

General Information

Product Description

MD3G is a general purpose, unfilled injection moulding grade of nylon 6. MD3G contains a nucleating agent to enable mouldings to be produced with short cycle times.

General

Material Status	• Commercial: Active
Availability	• Europe
Additive	• Nucleating Agent
Features	• Fast Molding Cycle • General Purpose • Nucleated
Uses	• General Purpose
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm ³	ISO 1183
Molding Shrinkage ²	1.2 to 2.0	--	%	Internal Method
Water Absorption				ISO 62
Equilibrium, 73°F, 50% RH	3.0	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	450000	145000	psi	ISO 527-1
Tensile Stress	10200	5800	psi	ISO 527-2
Tensile Strain (Yield)	5.0	25	%	ISO 527-2
Flexural Modulus	435000	145000	psi	ISO 178
Flexural Stress (3.5% Strain)	13100	4350	psi	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	4.8	> 24	ft·lb/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break	--		ISO 179/1eU
Notched Izod Impact Strength	1.4	--	ft·lb/in ²	ISO 180/A
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ISO 75-2/B
66 psi, Unannealed	374	--	°F	
Deflection Temperature Under Load				ISO 75-2/A
264 psi, Unannealed	203	--	°F	
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+15	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+17	1.0E+14	ohms·cm	IEC 60093
Electric Strength (0.118 in)	360	--	V/mil	IEC 60243-1
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Glow Wire Flammability Index				IEC 60695-2-12
0.06 in	1380	--	°F	
Oxygen Index	27	--	%	ISO 4589-2

Processing Information

Injection	Dry Unit
Drying Temperature	176 °F

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Injection	Dry	Unit
Drying Time	2.0	hr
Rear Temperature	464 to 500	°F
Middle Temperature	464 to 500	°F
Front Temperature	464 to 500	°F
Processing (Melt) Temp	464 to 500	°F
Mold Temperature	140 to 176	°F
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Injection Notes

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.

Notes

¹ Typical properties: these are not to be construed as specifications.

² 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).