+135-3858-6433 (GuangDong)
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TEKNOR APEX

Chemlon® MDF2

Teknor Apex Company - Polyamide 6

General Information

Product Description

MDF2 is a heat stabilised 30% glass fibre reinforced nylon 6 that offers good mechanical performance coupled with good surface finish.

General		
Material Status	• Commercial: Active	
Availability	• Europe	
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight	
Additive	• Heat Stabilizer	
Features	• Good Surface Finish	• Heat Stabilized
Processing Method	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.37	--	g/cm³	ISO 1183
Molding Shrinkage [2]	0.70 to 1.2	--	%	Internal Method
Water Absorption				ISO 62
Equilibrium, 73°F, 50% RH	1.9	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	1.23E+6	--	psi	ISO 527-1
Tensile Stress	26100	14500	psi	ISO 527-2
Tensile Strain (Break)	4.0	7.0	%	ISO 527-2
Flexural Modulus	1.09E+6	580000	psi	ISO 178
Flexural Stress	33400	14500	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	7.1	--	ft·lb/in²	ISO 179/1eA
Charpy Unnotched Impact Strength	26	--	ft·lb/in²	ISO 179/1eU
Notched Izod Impact Strength	6.2	--	ft·lb/in²	ISO 180/A
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Deflection Temperature Under Load				ISO 75-2/B
66 psi, Unannealed	> 392	--	°F	
Deflection Temperature Under Load				ISO 75-2/A
264 psi, Unannealed	> 392	--	°F	
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+15	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+17	--	ohms·cm	IEC 60093
Electric Strength (0.118 in)	280	200	V/mil	IEC 60243-1
Relative Permittivity	3.80	4.20		IEC 60250
Dissipation Factor (1 MHz)	0.020	0.080		IEC 60250
Comparative Tracking Index	500	--	V	IEC 60112
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Flame Rating (0.06 in)	HB	--		UL 94
Oxygen Index	22	--	%	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 536	°F
Middle Temperature	464 to 536	°F
Front Temperature	464 to 536	°F
Processing (Melt) Temp	482 to 554	°F
Mold Temperature	140 to 194	°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).