Chemlon® MDF863

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

MDF863 is a 15% glass fibre reinforced, highly impact modified, flame retarded nylon 6 - suitable for use in sub zero service environments. It contains a RoHS permissible Brominated Flame Retardant.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Additive	Impact modifier Flame retardancy 2		
Features	Impact modification Low temperature impact resistance Flame retardancy		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.36	g/cm³	ISO 1183
Molding Shrinkage [1]	0.80 - 1.6	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	1.6	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Stress	60.0	MPa	ISO 527-2
Flexural Modulus	2800	MPa	ISO 178
Flexural Stress	70.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	17	kJ/m²	ISO 180/A
Thermal	**Nominal Value**	**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	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	20	kV/mm	IEC 60243-1
Comparative Tracking Index	300	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
1.50 mm, Teknor Apex test result	V-1		UL 94
3.00 mm, Teknor Apex test result	V-0		UL 94

Glow Wire Flammability Index (1.50 mm)	960	°C	IEC 60695-2-12
Oxygen Index	30	%	ISO 4589-2

Additional Information
Due to the thermal sensitivity of flame retarded products steps should be taken to limit hold up time and temperature for the material. Additional care should be taken during any interruptions to routine production and during any purging procedures in order to minimise degradation of the product.

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	20	hr
Rear Temperature	245 - 280	°C
Middle Temperature	245 - 280	°C
Front Temperature	245 - 280	°C
Processing (Melt) Temp	245 - 280	°C
Mold Temperature	60.0 - 80.0	°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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