

Chemlon® MDF606

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

MDF606 is a 30% glass fibre reinforced, impact modified nylon 6 that offers good rigidity and toughness over a wide temperature range. The grade is also stabilised for good weathering performance in outdoor applications.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
	Good weather resistance		
	Thermal stability, good		
	Good toughness		
	Medium hardness		
Uses	Outdoor application		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Molding Shrinkage ¹	0.70 - 1.4	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	1.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	120	MPa	ISO 527-2
Tensile Strain (Break)	6.0	%	ISO 527-2
Flexural Modulus	6700	MPa	ISO 178
Flexural Stress ²	165	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	18	kJ/m ²	ISO 179
Notched Izod Impact	14	kJ/m ²	ISO 180
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
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm, Teknor Apex test result)	HB		UL 94
Oxygen Index	22	%	ISO 4589-2
Injection	Nominal Value	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	< 300	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Fast	
Screw Speed	50 - 200	rpm
Injection instructions		
Back pressure: LowInjection pressure: HighNo drying is necessary unless the materials has been exposed to air for longer than three hours.		
NOTE		

Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions.The range values stated were 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).

1.

2.

At conventional deflection

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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