Chemlon® MD3G

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

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 Information				
Additive	Nucleating agent			
Features	Nucleated Fast molding cycle General			
Uses	General			
Processing Method	Injection molding			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.13	--	g/cm³	ISO 1183
Molding Shrinkage [1]	1.2 - 2.0	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	3.0	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	3100	1000	MPa	ISO 527-2
Tensile Stress	70.0	40.0	MPa	ISO 527-2
Tensile Strain (Yield)	5.0	25	%	ISO 527-2
Flexural Modulus	3000	1000	MPa	ISO 178
Flexural Stress (3.5% Strain)	90.0	30.0	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	10	> 50	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength	No Break	--		ISO 179/1eU
Notched Izod Impact	3.0	--	kJ/m²	ISO 180/A
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	190	--	°C	ISO 75-2/B
1.8 MPa, not annealed	95.0	--	°C	ISO 75-2/A
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
Dielectric Strength (3.00 mm)	14	--	kV/mm	IEC 60243-1

Comparative Tracking Index	600	--	V	IEC 60112

Flammability	Dry	Conditioned	Unit	Test Method
Glow Wire Flammability Index (1.50 mm)	750	--	°C	IEC 60695-2-12
Oxygen Index	27	--	%	ISO 4589-2

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	2.0	hr
Rear Temperature	240 - 260	°C
Middle Temperature	240 - 260	°C
Front Temperature	240 - 260	°C
Processing (Melt) Temp	240 - 260	°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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