

ASTAMID™ MB3EG6

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3EG6 is a 30% glass reinforced, heat stabilised Polyamide 6 (PA 6 or Nylon 6).
Note: The letters "U", "W" or "UV" indicate UV stabilisation has been added [ie: ASTAMID™ MA3EG5U].

General Information				
Filler / Reinforcement		Glass Fiber,30% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.36	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.40	--	%	ASTM D955
Water Absorption				
Saturation, 23°C	6.5	--	%	ASTM D570
Equilibrium, 23°C, 50% RH	2.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	9500	6200	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	185	115	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	4.0	8.0	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	8600	5000	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	270	190	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength ⁶	16	30	kJ/m ²	ISO 179
Notched Izod Impact (3.20 mm)	150	210	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed, 3.20 mm	220	--	°C	
1.8 MPa, Unannealed, 3.20 mm	210	--	°C	
CLTE - Flow	3.5E-5	--	cm/cm/°C	ASTM D696
Flammability	Dry	Conditioned		Test Method
Flame Rating (1.60 mm)	HB	--		UL 94

Injection	Dry	Unit
Drying Temperature	80.0 to 90.0	°C
Drying Time	2.0	hr
Rear Temperature	255 to 265	°C
Middle Temperature	265 to 275	°C
Front Temperature	275 to 285	°C
Processing (Melt) Temp	260 to 290	°C
Mold Temperature	50.0 to 80.0	°C
Injection Pressure	60.0 to 130	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.100 to 0.500	MPa
Screw Speed	40 to 60	rpm
Clamp Tonnage	3.0 to 5.0	kN/cm ²

NOTE

- | | |
|----|------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 5.0 mm/min |
| 4. | 1.3 mm/min |
| 5. | 1.3 mm/min |
| 6. | 4 mm |

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