

ASTAMID™ MB3M6

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3M6 is a 30% Mineral filled PA6. This grade is recommended for applications requiring good dimensional stability/ low warpage such as wheels and engine covers.

General Information				
Filler / Reinforcement		Mineral filler, 30% filler by weight		
Features		Good dimensional stability		
		Low warpage		
Uses		Application in Automobile Field		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.36	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow ¹	0.70	--	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	2.4	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ² (3.20 mm)	4600	1650	MPa	ASTM D638
Tensile Strength ³ (3.20 mm)	80.0	--	MPa	ASTM D638
Tensile Elongation ⁴ (Break, 3.20 mm)	4.0	--	%	ASTM D638
Flexural Modulus ⁵ (3.20 mm)	4000	1400	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength ⁶	9.0	24	kJ/m ²	ISO 179
Notched Izod Impact (3.20 mm)	50	130	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, unannealed, 3.20mm	195	--	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	65.0	--	°C	ASTM D648
Flammability	Dry	Conditioned		Test Method
Flame Rating (1.60 mm)	HB	--		UL 94
Injection	Dry	Unit		
Drying Temperature	80.0 - 85.0		°C	
Drying Time	2.0		hr	

Rear Temperature	250 - 260	°C
Middle Temperature	260 - 270	°C
Front Temperature	270 - 280	°C
Processing (Melt) Temp	270 - 280	°C
Mold Temperature	70.0 - 90.0	°C
Injection Pressure	80.0 - 130	MPa
Injection Rate	Moderate-Fast	
Back Pressure	0.100 - 0.500	MPa
Screw Speed	40 - 60	rpm
Clamp Tonnage	5.0 - 9.0	kN/cm ²

Injection instructions

Drying Time (Opened Bag): > 12 hr

NOTE

1. Constrained
2. 5.0 mm/min
3. 5.0 mm/min
4. 5.0 mm/min
5. 1.3 mm/min
6. 10x4.0 mm

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