

ASTAMID™ MB3G6HS

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3G6HS is a highly heat stabilised 30% glass fibre reinforced Polyamide 6 grade. ASTAMID™ MB3G6HS has been developed for structural applications within the automotive sector.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 30% filler by weight		
Additive		heat stabilizer		
Features		Thermal Stability		
Uses		Application in Automobile Field		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.36	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.40	--	%	ASTM D955
Water Absorption				
Saturated, 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, 3.20mm	220	--	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	210	--	°C	ASTM D648
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 - 90.0		°C
Drying Time	2.0		hr
Rear Temperature	255 - 265		°C
Middle Temperature	265 - 275		°C
Front Temperature	275 - 285		°C
Processing (Melt) Temp	260 - 290		°C
Mold Temperature	50.0 - 80.0		°C
Injection Pressure	60.0 - 130		MPa
Injection Rate	Moderate-Fast		
Back Pressure	0.100 - 0.500		MPa
Screw Speed	40 - 60		rpm
Clamp Tonnage	3.0 - 5.0		kN/cm ²

Injection instructions

Drying Time: > 12 hr for already open bag

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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