

ASTAMID™ MB3L

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3L is an Impact Modified, heat stabilised Polyamide 6 (PA 6 or Nylon 6).
Note: The letters "U", "W" or "UV" indicate UV stabilisation has been added [ie: ASTAMID™ MB3LU].

General Information			
Additive	Impact modifier		
	heat stabilizer		
Features	Impact modification		
	Thermal Stability		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/2.16 kg)	20	g/10 min	ASTM D1238
Water Absorption (equilibrium, 23°C, 50%)	2.5	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	2750	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	70.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2350	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	170	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	150	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	65.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 80.0	°C	
Drying Time	2.0	hr	
Rear Temperature	250 - 255	°C	
Middle Temperature	255 - 265	°C	
Front Temperature	265 - 270	°C	
Processing (Melt) Temp	255 - 265	°C	
Mold Temperature	50.0 - 80.0	°C	
Injection Pressure	60.0 - 120	MPa	
Injection Rate	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 (Opened Bag): > 12 hr		
NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	5.0 mm/min	
4.	1.3 mm/min	

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Recommended distributors for this material

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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