

ASTAMID™ MA3LK

Polyamide 66
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MA3LK is an impact toughened, heat stabilised Polyamide 66 grade designed for use in long flow path components requiring additional toughness and resistance to heat ageing.

General Information				
Additive		Impact modifier heat stabilizer		
Features		Impact modification Thermal Stability		
Uses		Application in Automobile Field		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.09	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.3	--	%	ASTM D955
Water Absorption (24 hr)	0.80	--	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	73.0	50.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	75	150	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2400	1000	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (3.20 mm)	250	500	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	59.0	--	°C	ASTM D648
CLTE - Flow	8.0E-4	--	cm/cm/°C	ASTM D696
Flammability	Dry	Conditioned	Test Method	
Flame Rating (1.60 mm)	HB	--	UL 94	
Injection	Dry	Unit		
Drying Temperature	75.0 - 85.0		°C	
Drying Time	2.0		hr	
Rear Temperature	240 - 260		°C	
Middle Temperature	250 - 270		°C	
Front Temperature	260 - 280		°C	

Processing (Melt) Temp	270 - 290	°C
Mold Temperature	50.0 - 80.0	°C
Injection Pressure	60.0 - 130	MPa
Injection Rate	Moderate	
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. 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

