

Ultramid® B3G10 SI

Polyamide 6

BASF Corporation

Message:

Glass fibre-reinforced injection moulding grade, with excellent surface quality especially suitable for the production of visible parts with very high stiffness. Optimum surface quality is generally obtained at a very high injection speed.

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 50% filler by weight		
Features		Excellent appearance		
		Rigidity, high		
		Oil resistance		
Agency Ratings		EC 1907/2006 (REACH)		
RoHS Compliance		RoHS compliance		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.57	--	g/cm ³	ISO 1183
Apparent Density	0.70	--	g/cm ³	
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	12.0	--	cm ³ /10min	ISO 1133
Viscosity Number (96% H ₂ SO ₄)	135	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	16500	10800	MPa	ISO 527-2
Tensile Stress (Break)	235	160	MPa	ISO 527-2
Tensile Strain (Break)	3.0	5.0	%	ISO 527-2
Flexural Modulus	13500	9500	MPa	ISO 178
Flexural Stress	340	230	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	16	--	kJ/m ²	ISO 179/1eA
23°C	20	25	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	85	--	kJ/m ²	ISO 179/1eU
23°C	95	100	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, not annealed	215	--	°C	ISO 75-2/B
1.8 MPa, not annealed	200	--	°C	ISO 75-2/A
Additional Information	Dry	Conditioned		
Polymer Abbreviation	PA6-GF50	--		
Screw Speed			mm/sec	
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0		hr	
Suggested Max Moisture	0.15		%	
Hopper Temperature	80.0		°C	
Rear Temperature	270		°C	
Middle Temperature	280		°C	
Front Temperature	290		°C	
Nozzle Temperature	290		°C	
Processing (Melt) Temp	280 - 300		°C	
Mold Temperature	80.0 - 90.0		°C	
Injection instructions				
Residence Time : <10 min				

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