

ASTAMID™ MA3ZK

Polyamide 66
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MA3ZK is a "super tough" impact modified, heat stabilised grade of Polyamide 66. ASTAMID™ MA3ZK is designed for use in applications requiring extreme impact toughness.

General Information				
Additive	Heat Stabilizer			
	Impact Modifier			
Features	Heat Stabilized			
	Impact Modified			
	Ultra High Impact Resistance			

Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.06	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.2	--	%	ASTM D955
Water Absorption				ISO 62
23°C, 24 hr	2.3	--	%	
Equilibrium, 23°C, 50% RH	7.2	--	%	

Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	1850	900	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	50.0	40.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	25	> 50	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	1800	850	MPa	ASTM D790

Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (3.20 mm)	900 J/m	No Break		ASTM D256

Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed, 3.20 mm	128	--	°C	
1.8 MPa, Unannealed, 3.20 mm	62.0	--	°C	
CLTE - Flow	8.5E-4	--	cm/cm/°C	ASTM D696

Flammability	Dry	Conditioned	Test Method	
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Flame Rating (1.60 mm)	HB	--	UL 94
Injection	Dry	Unit	
Drying Temperature	75.0 to 85.0		°C
Drying Time	2.0		hr
Rear Temperature	220 to 240		°C
Middle Temperature	240 to 260		°C
Front Temperature	250 to 270		°C
Processing (Melt) Temp	250 to 280		°C
Mold Temperature	50.0 to 80.0		°C
Injection Pressure	60.0 to 130		MPa
Injection Rate	Moderate		
Back Pressure	0.100 to 0.500		MPa
Screw Speed	40 to 60		rpm
Clamp Tonnage	3.0 to 5.0		kN/cm ²

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

