Product Information

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Ultramid® B3WG3 Polyamide 6



Product Description

Ultramid B3WG3 is a 15% glass fiber reinforced, heat stabilized injection molding PA6 grade.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm³	1183		1.23
MECHANICAL Targila Madulus MPa	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa 23C	527	F 000	
	507	5,800	-
Tensile stress at break, MPa 23C	527	130	
	527	130	•
Tensile strain at break, % 23C	521	3.5	
Flexural Modulus, MPa	178	3.3	-
23C	170	5,400	
IMPACT	ISO Test Method	5,400 Dry	Conditioned
Izod Notched Impact, kJ/m ²	180	Dry	Conditioned
23C	180	5.6	_
Charpy Notched, kJ/m ²	179	5.0	-
-30C	179	6	
23C		7	•
Charpy Unnotched, kJ/m ²	179	, ,	•
23C	179	40	
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	190	
UL RATINGS	UL Test Method	Property Value	
Flammability Rating, 0.8mm	UL94	НВ	
Relative Temperature Index, 0.8mm	UL746B		
Electrical, C		130	
Flammability Rating, 1.5mm	UL94	НВ	
Relative Temperature Index, 1.5mm	UL746B		
Mechanical w/o Impact, C			130
Mechanical w/ Impact, C		85	
Electrical, C		130	
Flammability Rating, 3.0mm	UL94		HB
Relative Temperature Index, 3.0mm	UL746B		
Mechanical w/o Impact, C			130
Mechanical w/ Impact, C		85	
Electrical, C			130

Processing Guidelines

Material Handling

Ultramid® B3WG3



Max. Water content: 0.15%

Product is supplied in sealed containers and drying prior to molding is not required. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 80C (176F) is recommended. Drying time is dependent on moisture level, however 2-4 hours is generally sufficient. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF representative.

Typical Profile

Melt Temperature 250-290C (482-554F)
Mold Temperature 80-95C (176-203F)
Injection and Packing Pressure 35-125 bar (500-1500 psi)

Mold Temperatures

This product can be processed over a wide range of mold temperatures; however, for applications where aesthetics are critical, a mold surface temperature of 80-95C (176-203F) is recommended.

Pressures

Injection pressure controls the filling of the part and should be applied for 90% of ram travel. Packing pressure affects the final part and can be used effectively in controlling sink marks and shrinkage. It should be applied and maintained until the gate area is completely frozen off.

Back pressure can be utilized to provide uniform melt consistency and reduce trapped air and gas. Minimal back pressure should be utilized to prevent glass breakage. recommended to minimize glass fiber breakage.

Fill Rate

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing. Surface appearance is directly affected by injection rate.

Note

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