

Ultramid® A3EG3 BK00564

Polyamide 66



Product Description

Ultramid A3EG3 BK00564 is a 15% glass fiber reinforced, pigmented black, injection molding PA66 grade.

Applications

Typical applications include medium stiffness machinery components and housings, as well as electrically insulating parts.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.24	
Moisture, %	62		
(50% RH)		2.2	
(Saturation)		7	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile stress at break, MPa	527		
23C		122	-
Tensile strain at break, %	527		
23C		2.5	-
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C		5.5	-
Charpy Notched, kJ/m ²	179		
23C		5.5	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	260	-
HDT A, C	75	246	-
Coef. of Linear Thermal Expansion, Parallel, mm/mm C		0.33 X10-4	-
Coef. of Linear Thermal Expansion, Normal, mm/mm C		0.75 X10-4	-



Mold Temperatures

A mold temperature of 80-90 degC (176-194 degF) is recommended, but temperatures of as low as 45 degC (113 degF) and as high as 105 degC (221 degF) can be used where applicable.

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.

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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