

Ultramid® B35EG3

PA6-GF15

BASF

Glass fibre reinforced injection moulding grade e.g. for internal gas pressure applications such as steering column switch, automobile mirror housings and wheels of mountain bikes.

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	40 / *	cm³/10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	5800 / 3500	MPa	ISO 527
Stress at Break	130 / 70	MPa	ISO 527
Strain at Break	4 / 18	%	ISO 527
Tensile Creep Modulus, 1h	* / 2500	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	* / 2100	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	60 / 105	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	55 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	9 / 25	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	8 / -	kJ/m²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	190 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	215 / *	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	210 / *	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	32.5 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	75 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.6 / *	mm	-
UL recognition	yes / *	-	-
Oxygen index	22.5 / *	%	ISO 4589-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	3.8 / 7	-	IEC 62631-2-1
Dissipation Factor, 100Hz	250 / 2400	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	250 / 2400	E-4	IEC 62631-2-1
Volume Resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E10	Ohm	IEC 62631-3-2
Comparative tracking index	- / 550	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	8 / *	%	Sim. to ISO 62
Humidity absorption	2.6 / *	%	Sim. to ISO 62
Density	1230 / -	kg/m³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	170 / *	cm³/g	ISO 307, 1157, 1628

Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Ejection temperature	150	°C	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294

Ultramid® B35EG3
PA6-GF15

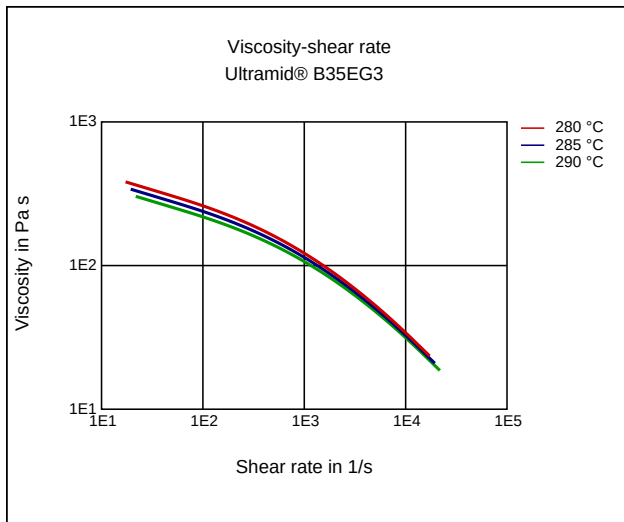
BASF

Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

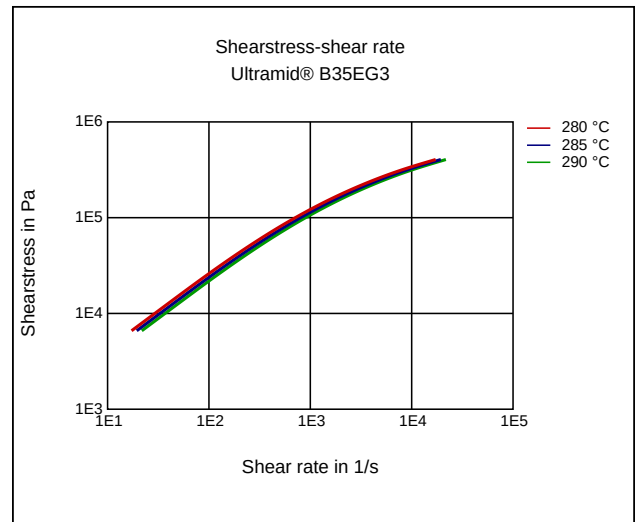
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 90	°C	-

Diagrams

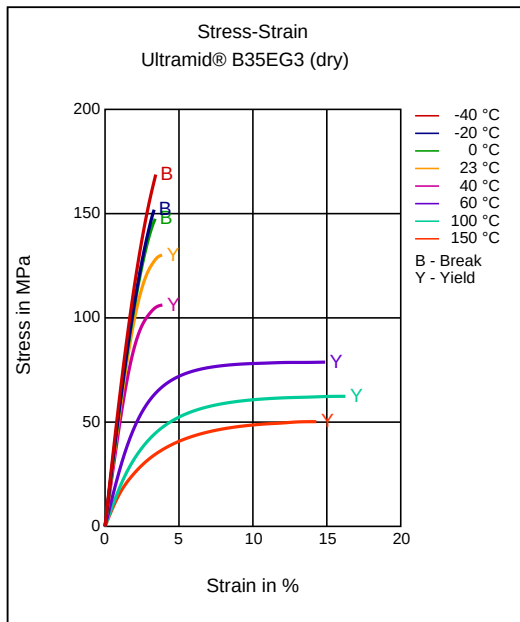
Viscosity-shear rate



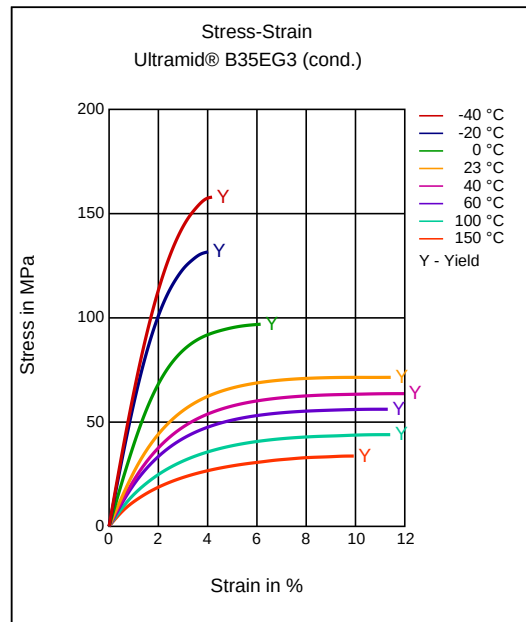
Shearstress-shear rate



Stress-strain



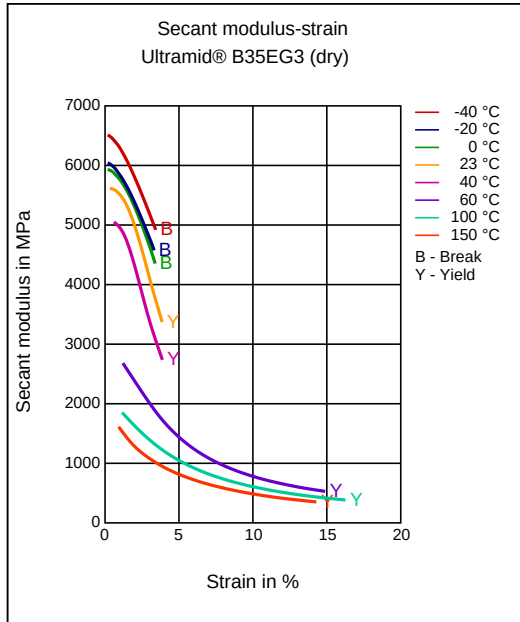
Stress-strain



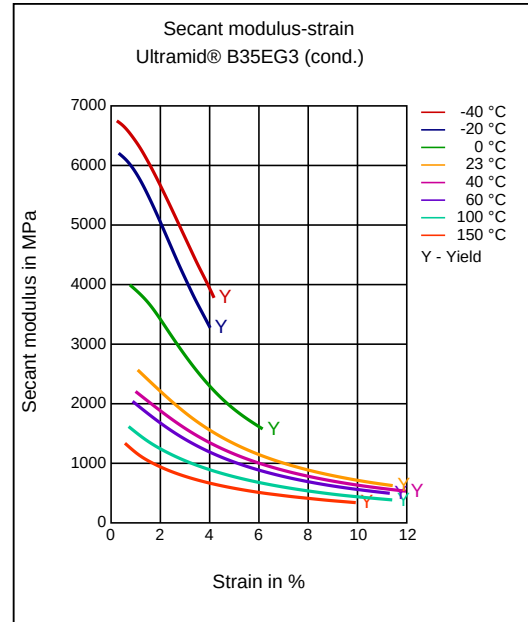
Ultramid® B35EG3
PA6-GF15

BASF

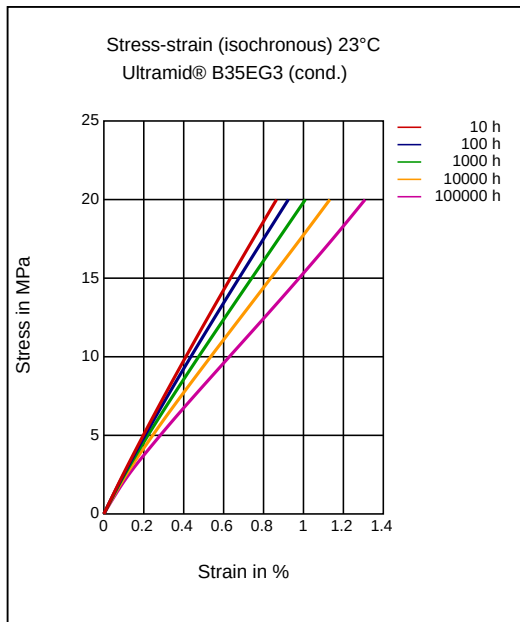
Secant modulus-strain



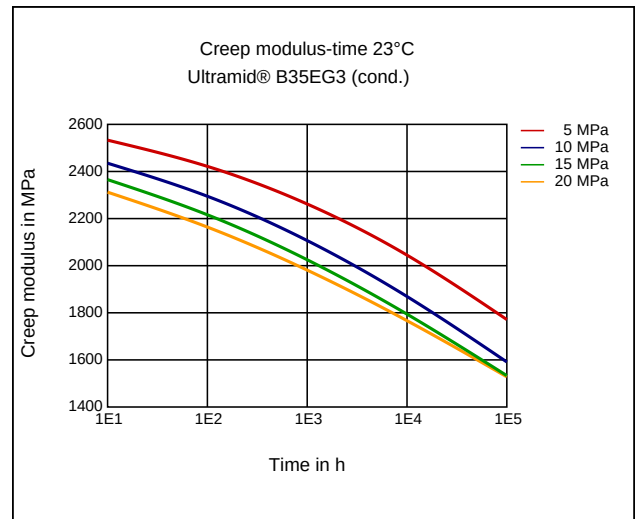
Secant modulus-strain



Stress-strain (isochronous) 23 °C



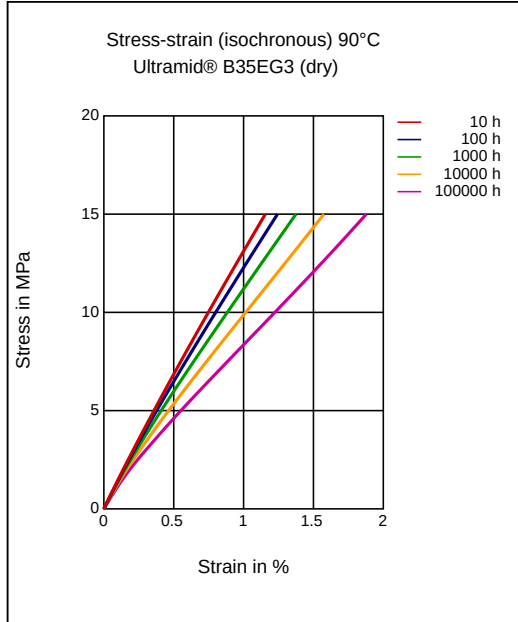
Creep modulus-time 23 °C



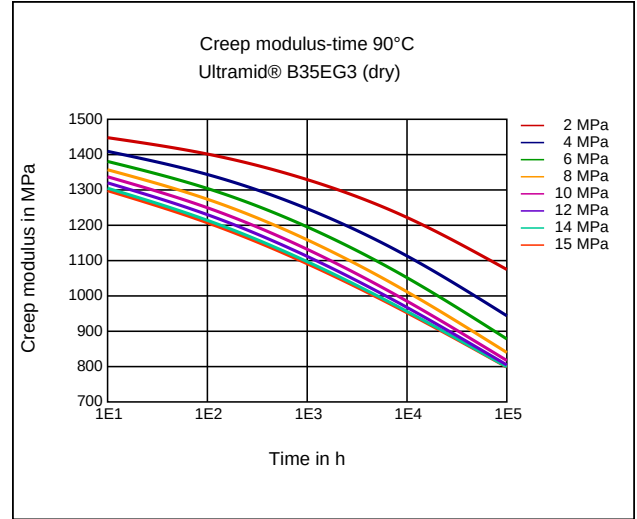
Ultramid® B35EG3
PA6-GF15

BASF

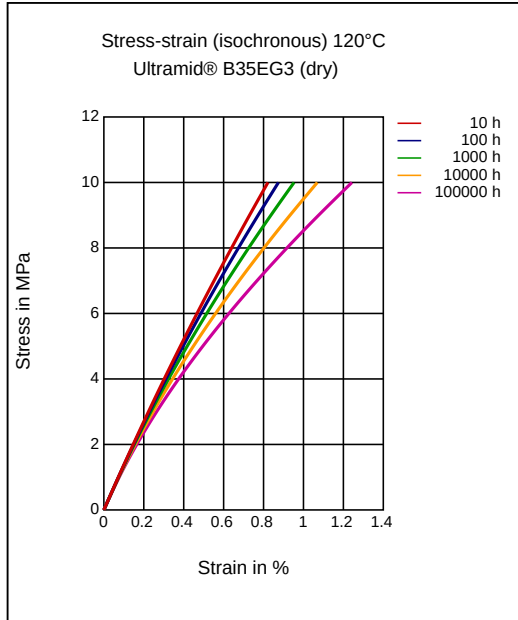
Stress-strain (isochronous) 90 °C



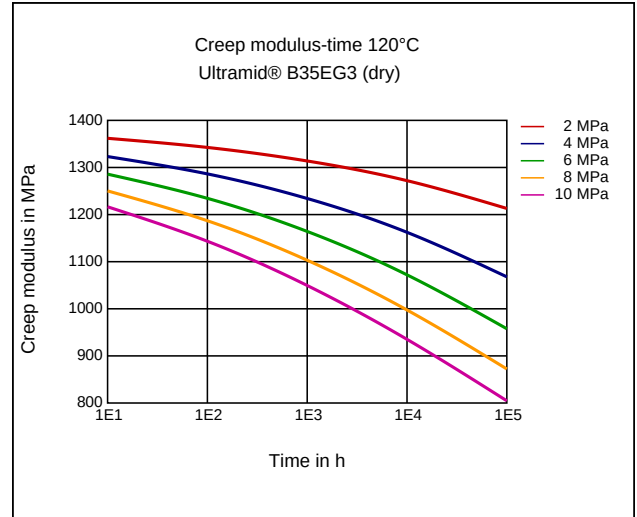
Creep modulus-time 90 °C



Stress-strain (isochronous) 120 °C



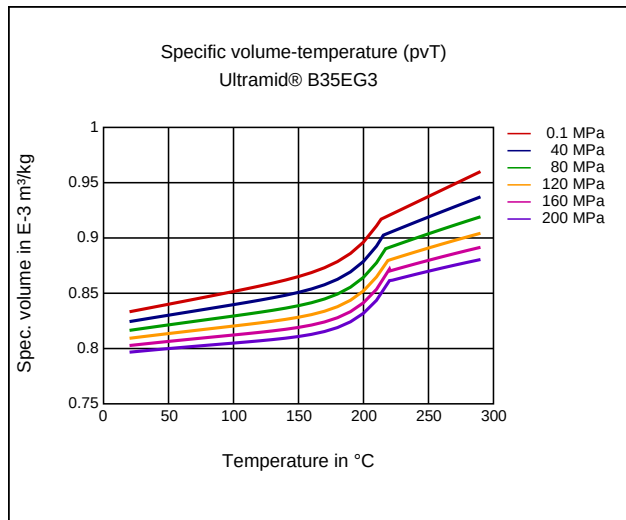
Creep modulus-time 120 °C



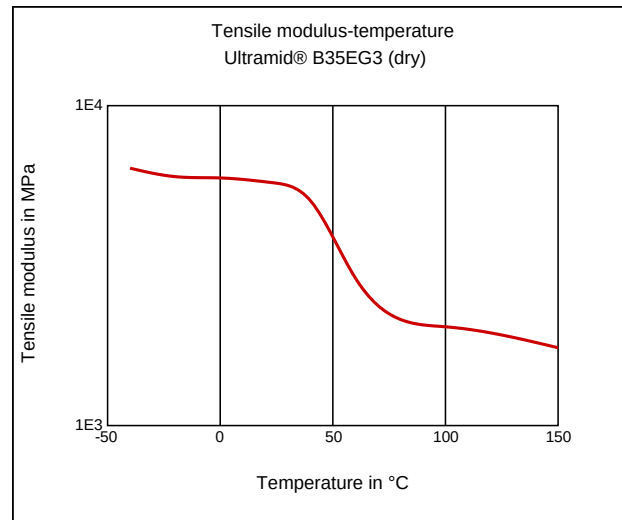
Ultramid® B35EG3 PA6-GF15

BASF

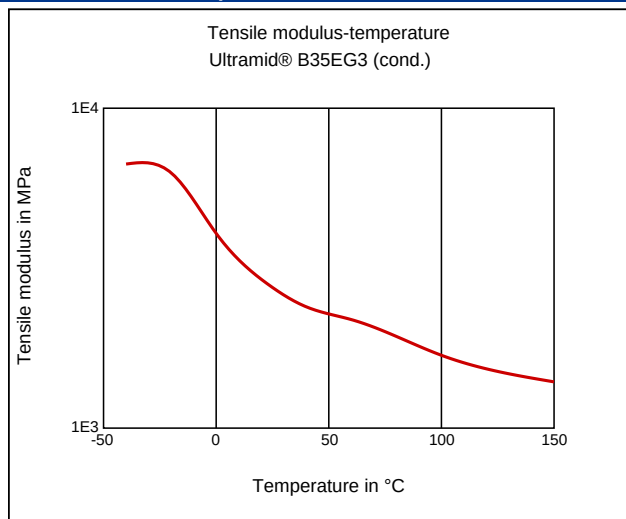
Specific volume-temperature (pvT)



Tensile Modulus-Temperature



Tensile Modulus-Temperature



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Lubricants, Release agent

Special Characteristics

Heat aging stabilized

Injection Molding

PREPROCESSING

Pre/Post-processing, max. allowed water content: .15 %

Pre/Post-processing, Pre-drying, Temperature: 80 °C

Pre/Post-processing, Pre-drying, Time: 4 h

PROCESSING

injection molding, Melt temperature, range: 270 - 290 °C

injection molding, Melt temperature, recommended: 280 °C

injection molding, Mold temperature, range: 80 - 90 °C

injection molding, Mold temperature, recommended: 80 °C

Ultramid® B35EG3
PA6-GF15

BASF

injection molding, Dwell time, thermoplastics: 10 min

Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass) (23°C)