

Ultramid® B3GM35 BK30564

PA6-(MD+GF)40

BASF

A glass-fibre and mineral reinforced injection moulding grade for industrial articles having medium rigidity and high dimensional stability, used e.g. for engine covers, handles, mountings, etc.

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	-
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	8300 / 4300	MPa	ISO 527
Stress at Break	125 / 70	MPa	ISO 527
Strain at Break	2.8 / 7.5	%	ISO 527
Tensile Creep Modulus, 1h	* / 2800	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	* / 1850	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	50 / 70	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	50 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	6 / 8	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	4 / -	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)	210 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	33 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	76 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	3.9 / 6.2	-	IEC 62631-2-1
Dissipation Factor, 100Hz	200 / 2000	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	200 / 2000	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	- / 400	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	5.7 / *	%	Sim. to ISO 62
Humidity absorption	1.7 / *	%	Sim. to ISO 62
Density	1480 / -	kg/m³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	135 / *	cm³/g	ISO 307, 1157, 1628

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

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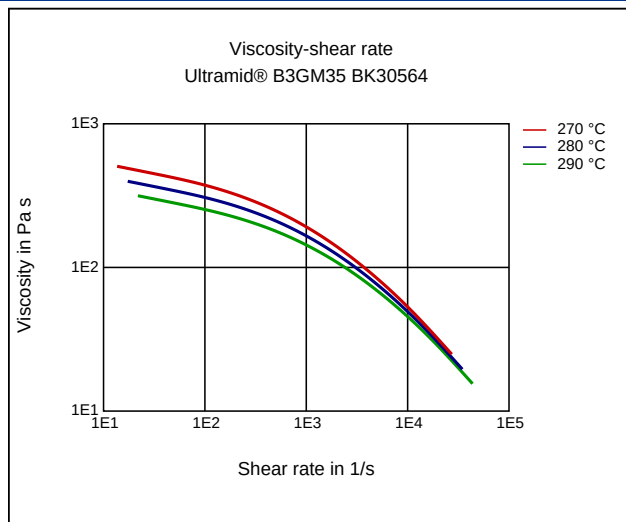
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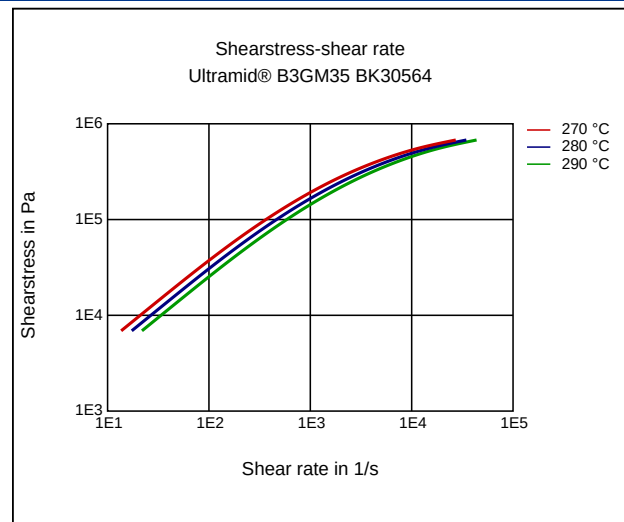
Processing humidity	≤0.15	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 90	°C	-

Diagrams

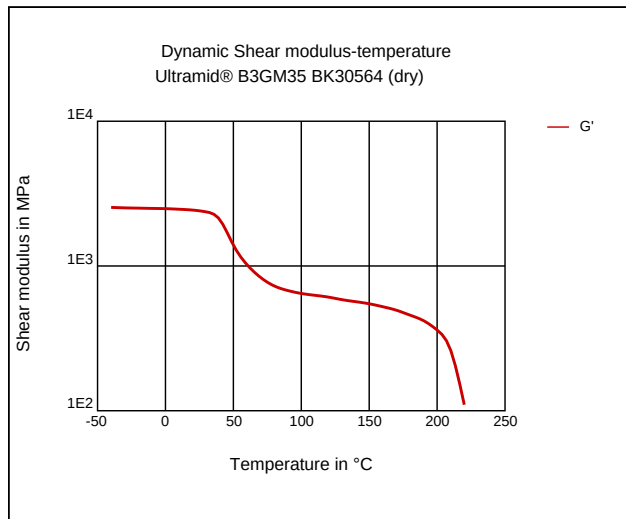
Viscosity-shear rate



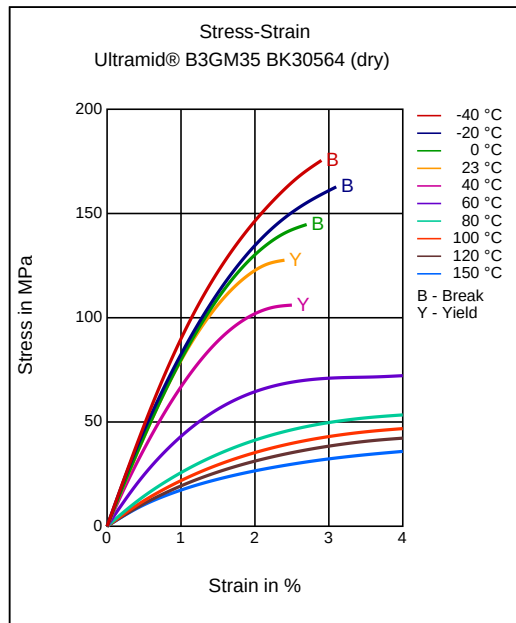
Shearstress-shear rate



Dynamic Shear modulus-temperature



Stress-strain

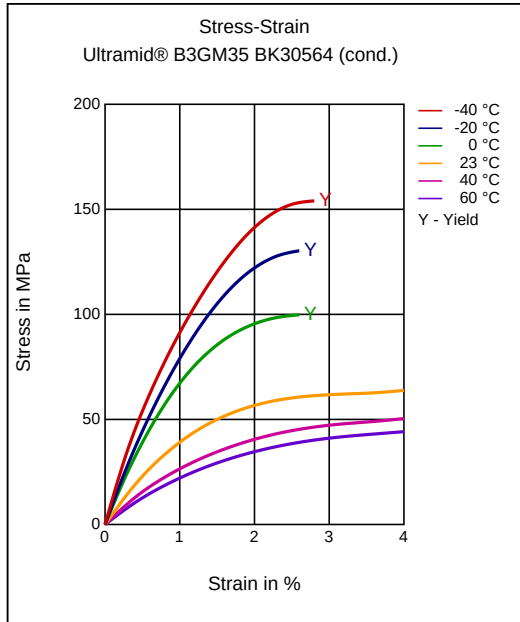


Ultramid® B3GM35 BK30564

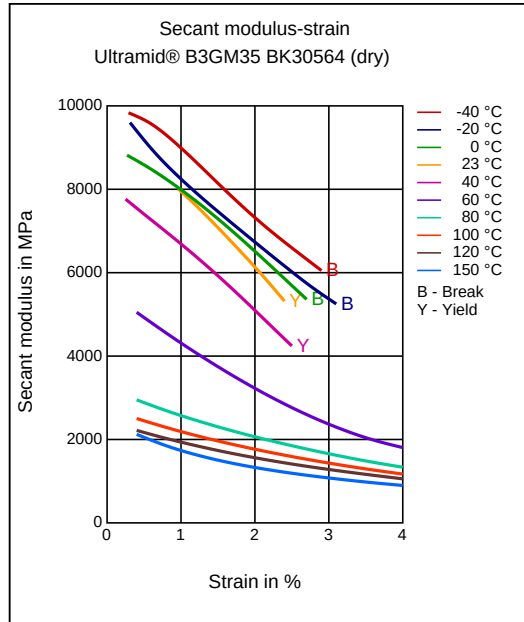
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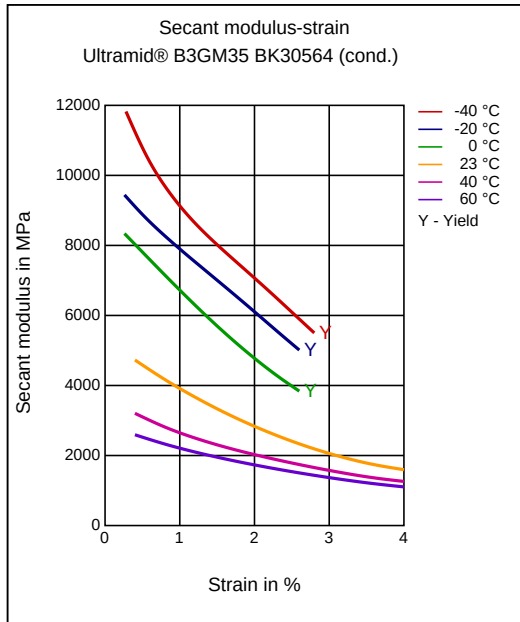
Stress-strain



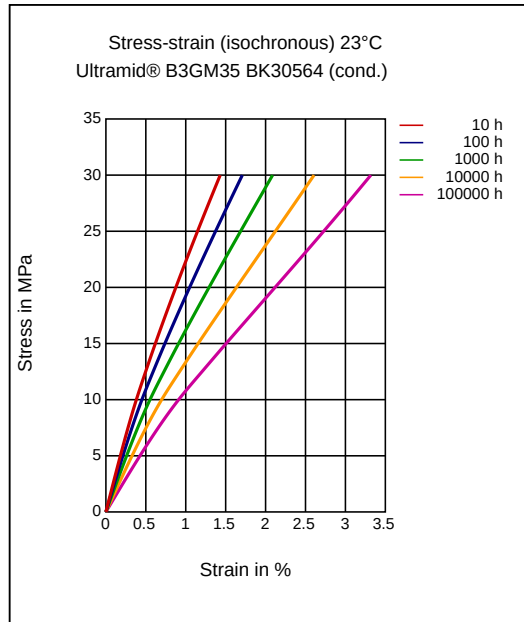
Secant modulus-strain



Secant modulus-strain



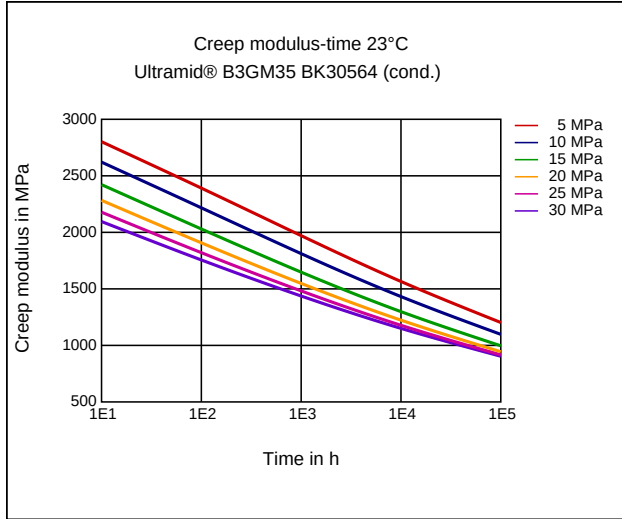
Stress-strain (isochronous) 23 °C



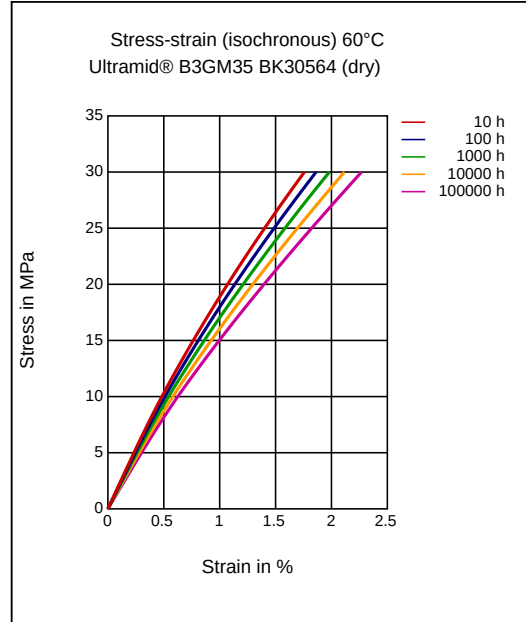
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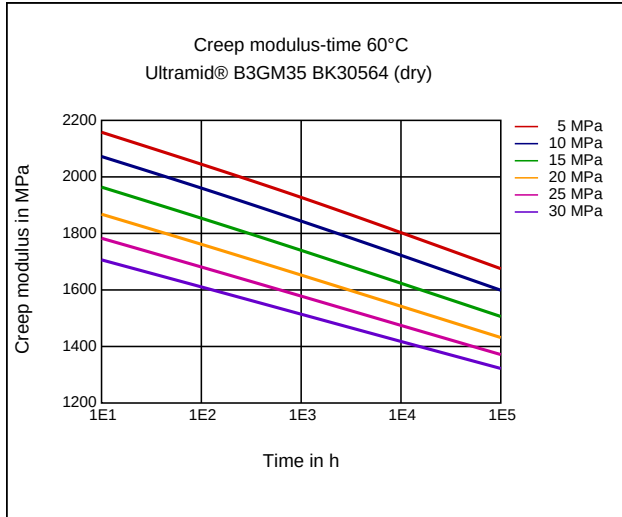
Creep modulus-time 23°C



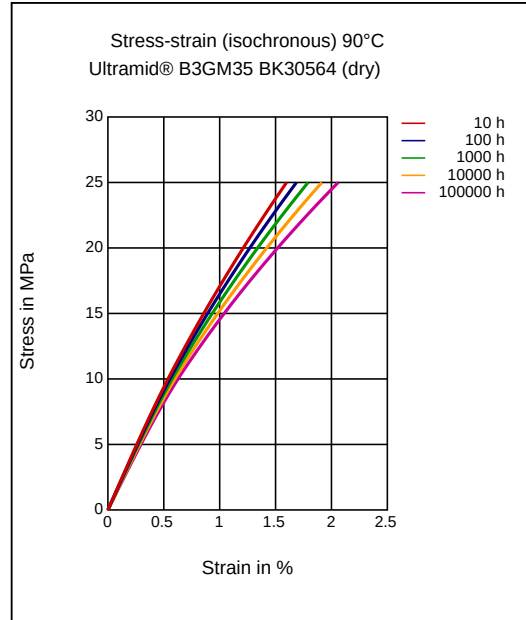
Stress-strain (isochronous) 60°C



Creep modulus-time 60°C



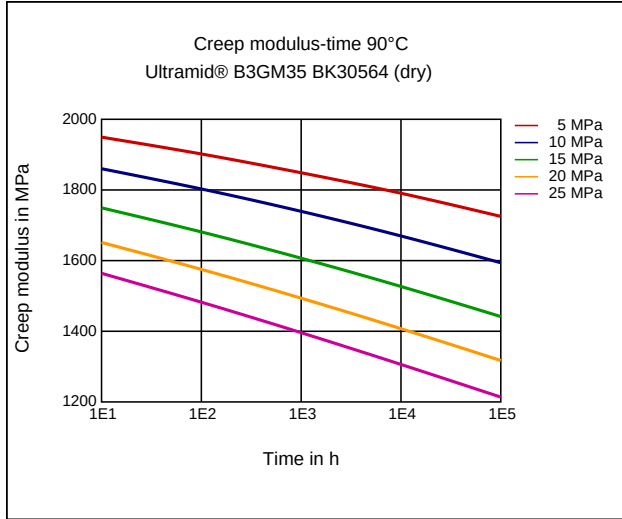
Stress-strain (isochronous) 90°C



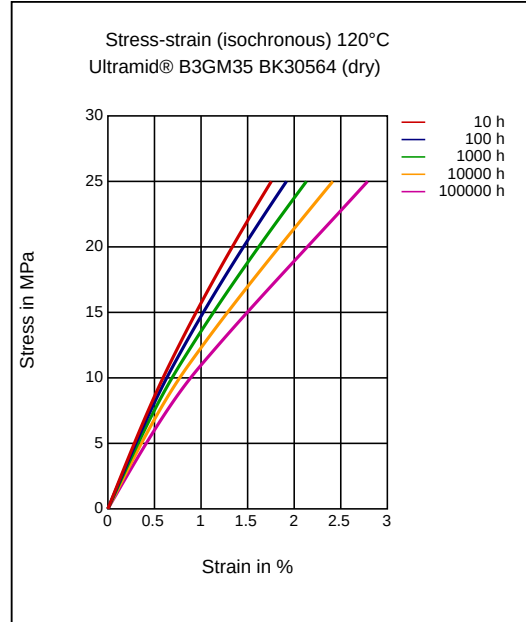
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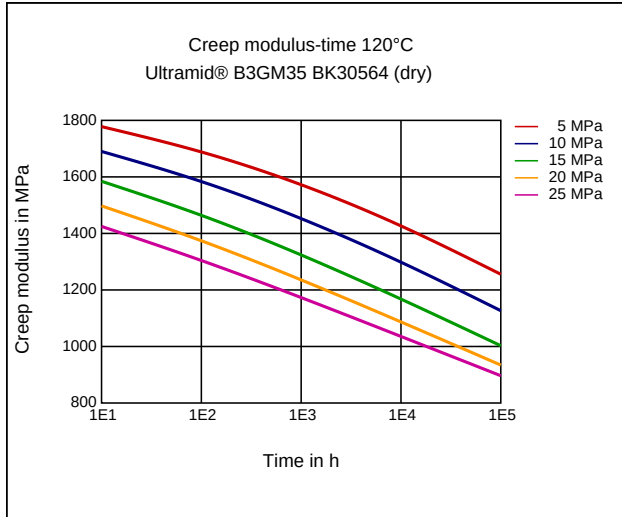
Creep modulus-time 90 °C



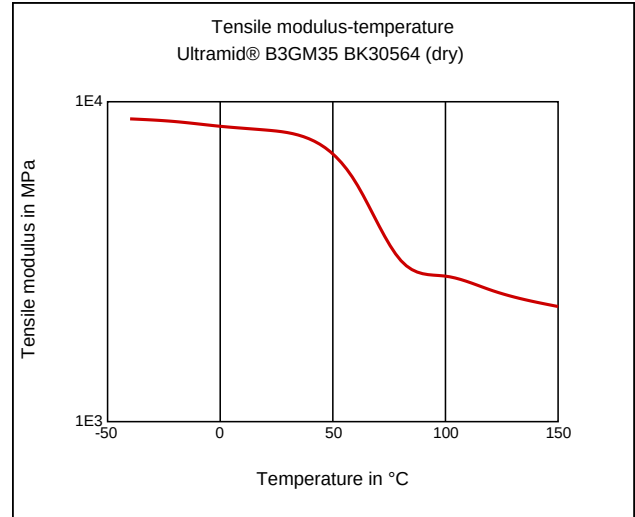
Stress-strain (isochronous) 120 °C



Creep modulus-time 120 °C



Tensile Modulus-Temperature

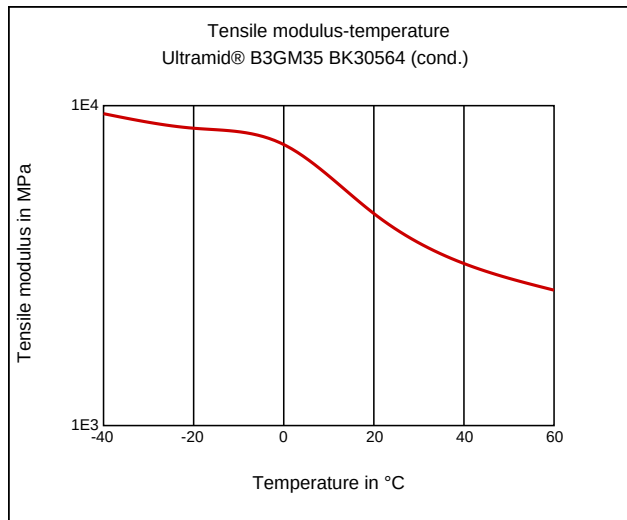


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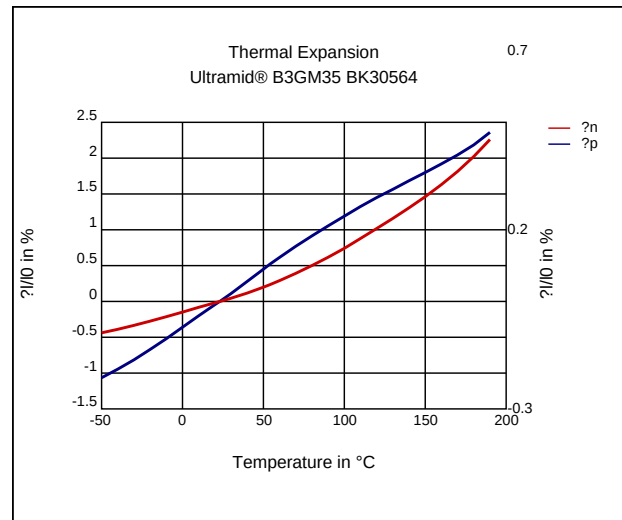
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Tensile Modulus-Temperature



Coeff. of linear thermal expansion, normal



Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

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

injection molding, Dwell time, thermoplastics: 10 min

Chemical Media Resistance

Acids

✓ Acetic Acid (5% by mass) (23 °C)