

Ultramid® B3WG10

PA6-GF50

BASF

Glass fibre reinforced and heat ageing resistance injection moulding grade for industrial parts requiring very high rigidity.

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	22 / *	cm³/10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	16000 / 11000	MPa	ISO 527
Stress at Break	235 / 160	MPa	ISO 527
Strain at Break	3 / 5.5	%	ISO 527
Tensile Creep Modulus, 1h	* / 9600	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	* / 7400	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	100 / 110	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	90 / 98	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	22 / 30	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	16 / 13.3	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)	215 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	220 / *	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	220 / *	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	15 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	73 / *	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 / *	-	-
Burning Behav. at thickness h	HB / *	class	UL 94
Thickness tested	0.8 / *	mm	-
UL recognition	yes / *	-	-
Oxygen index	22.5 / *	%	ISO 4589-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	4.2 / 6.1	-	IEC 62631-2-1
Dissipation Factor, 100Hz	140 / 1400	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	140 / 1400	E-4	IEC 62631-2-1
Volume Resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E10	Ohm	IEC 62631-3-2
Electric Strength	40 / 31	kV/mm	IEC 60243-1
Comparative tracking index	- / 450	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	4.8 / *	%	Sim. to ISO 62
Humidity absorption	1.5 / *	%	Sim. to ISO 62
Density	1550 / -	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	300	°C	ISO 294

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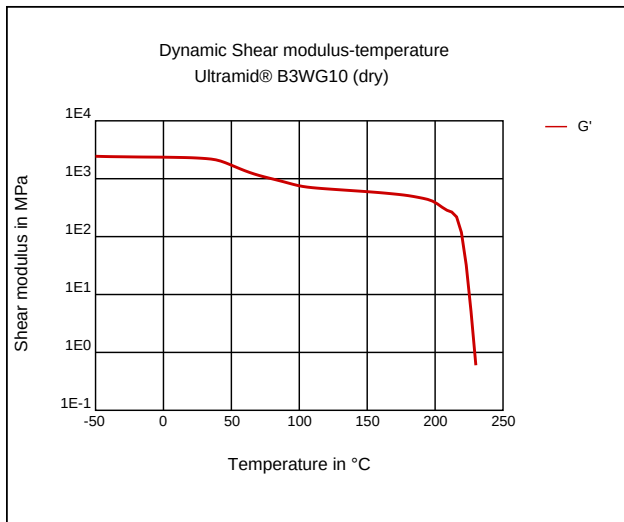
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Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

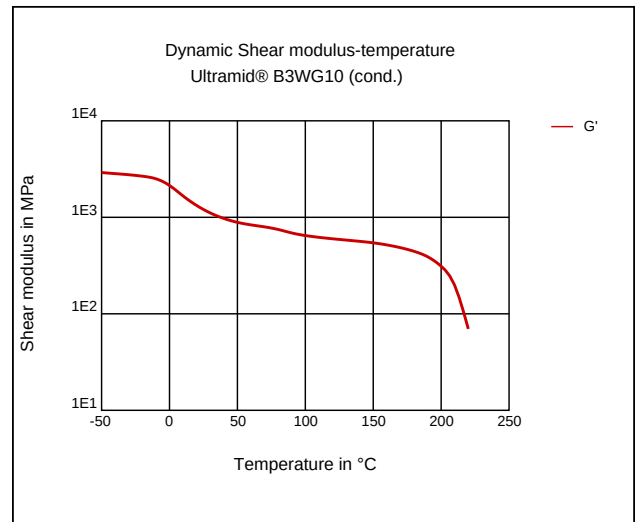
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 90	°C	-

Diagrams

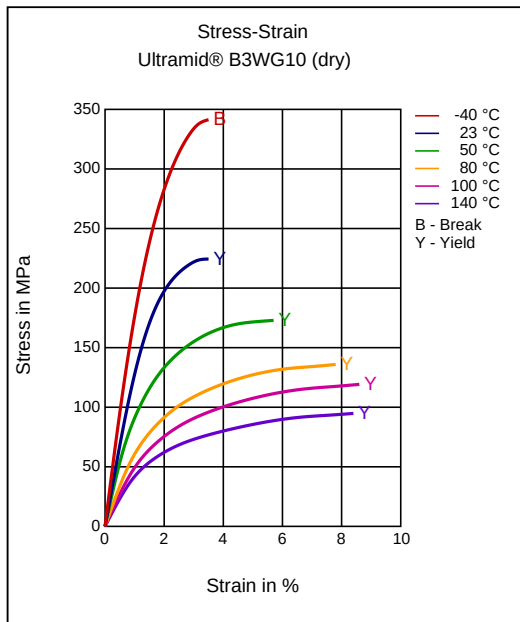
Dynamic Shear modulus-temperature



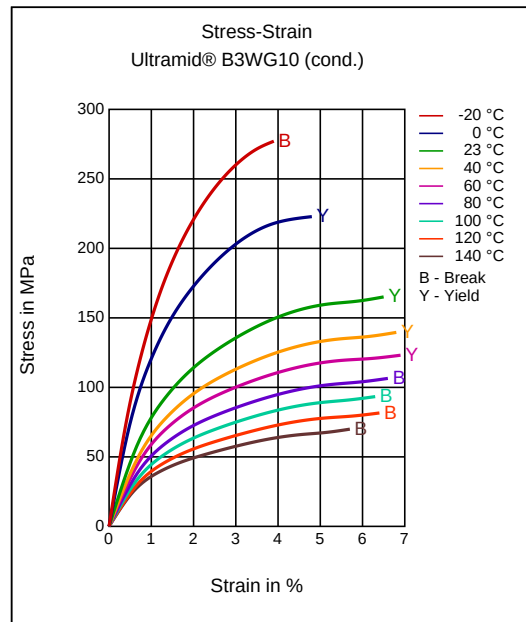
Dynamic Shear modulus-temperature



Stress-strain



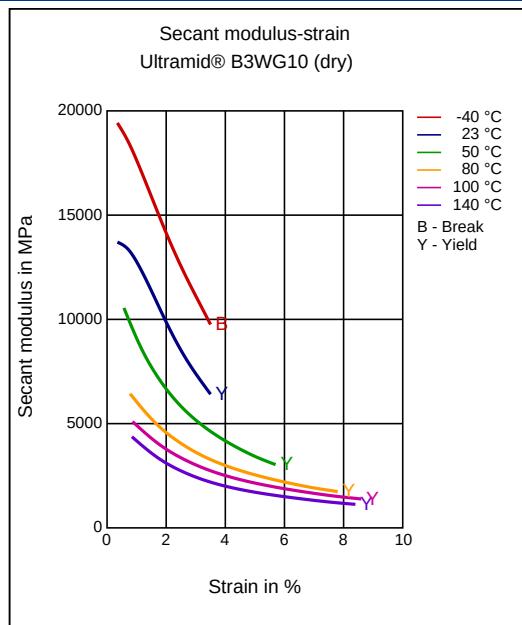
Stress-strain



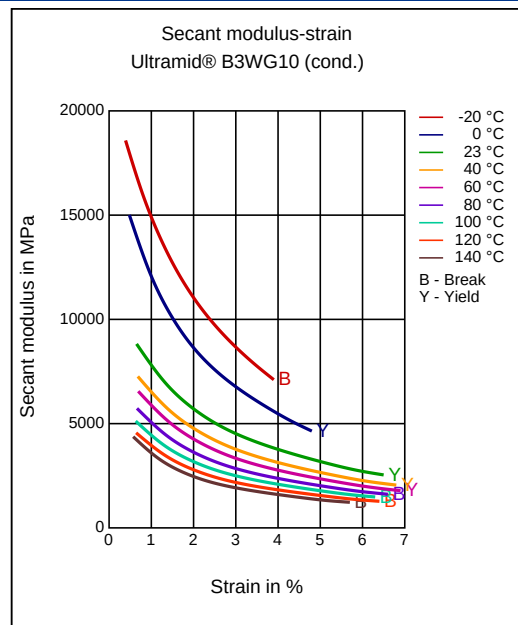
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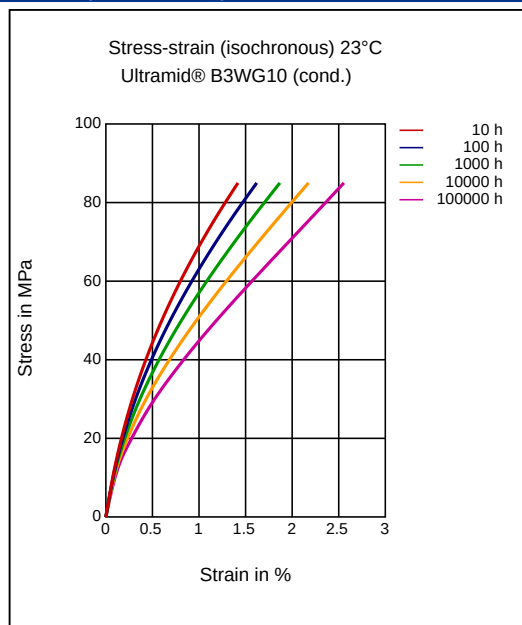
Secant modulus-strain



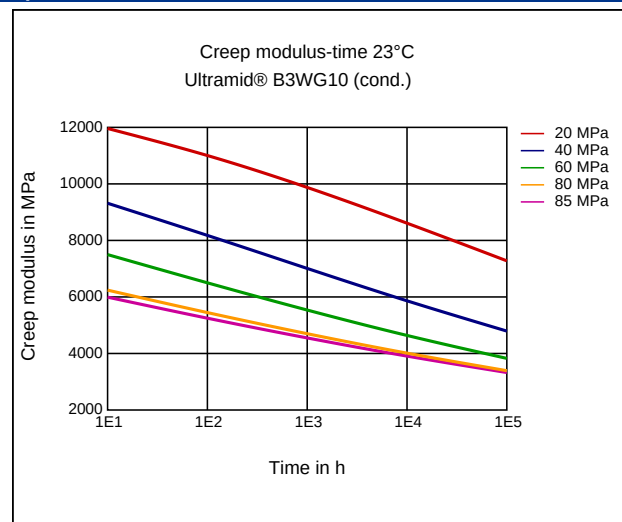
Secant modulus-strain



Stress-strain (isochronous) 23 °C



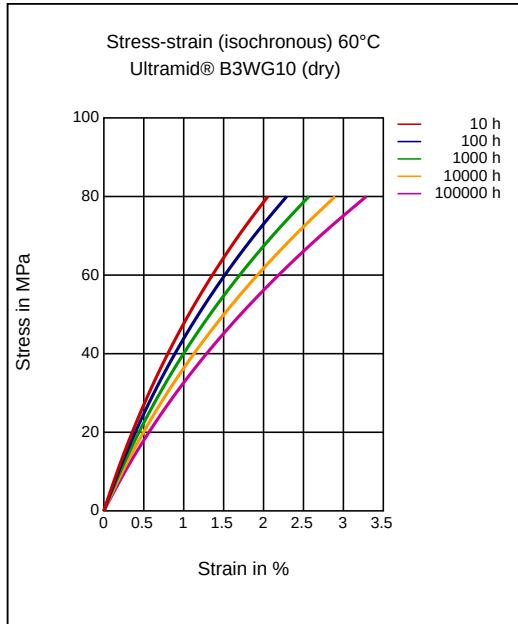
Creep modulus-time 23 °C



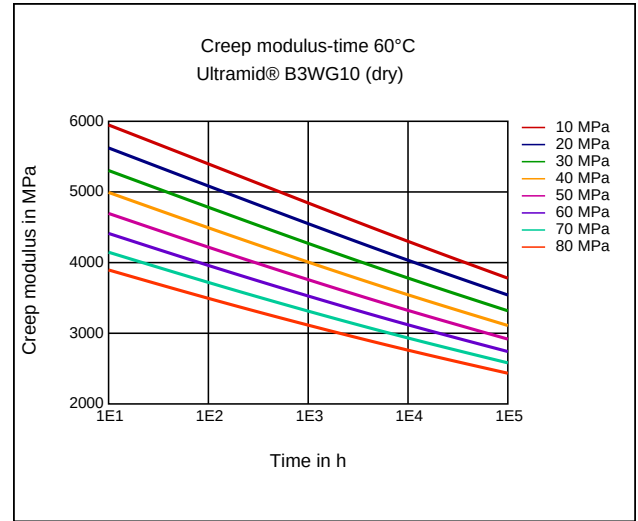
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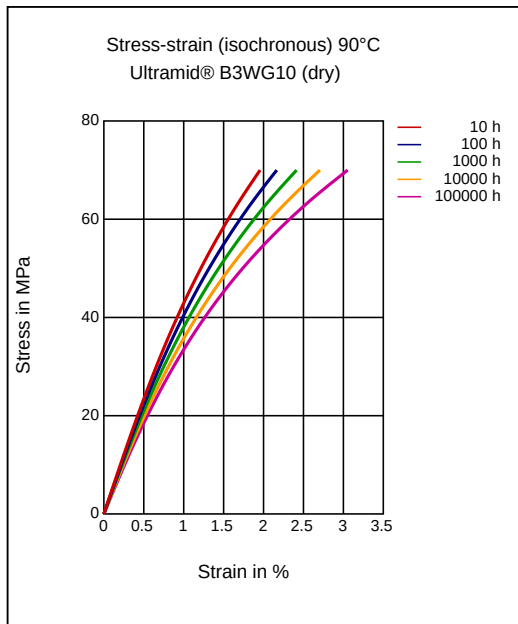
Stress-strain (isochronous) 60°C



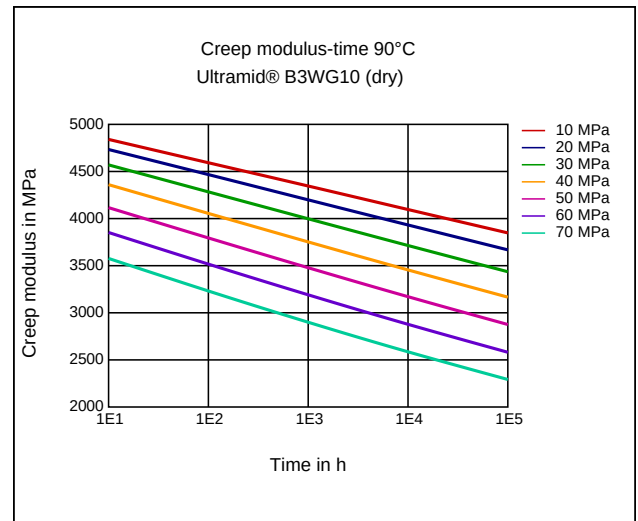
Creep modulus-time 60°C



Stress-strain (isochronous) 90°C



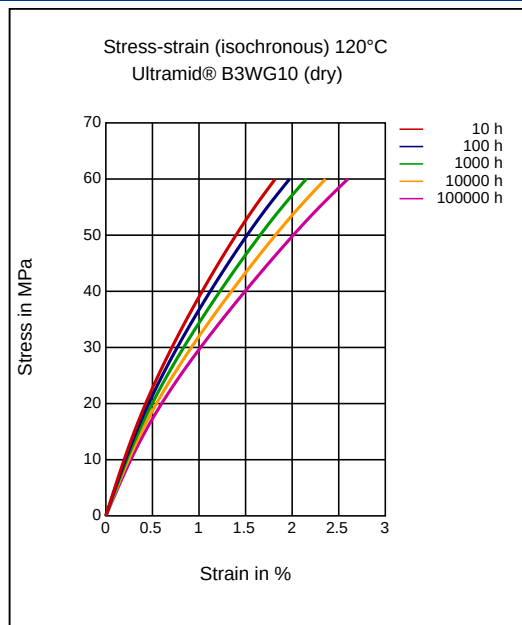
Creep modulus-time 90°C



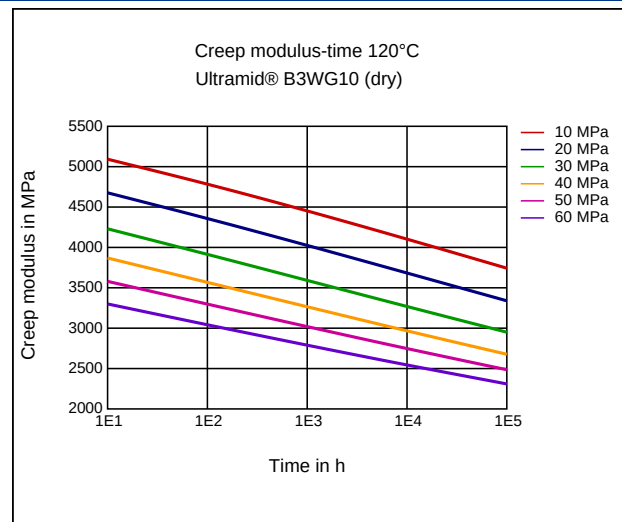
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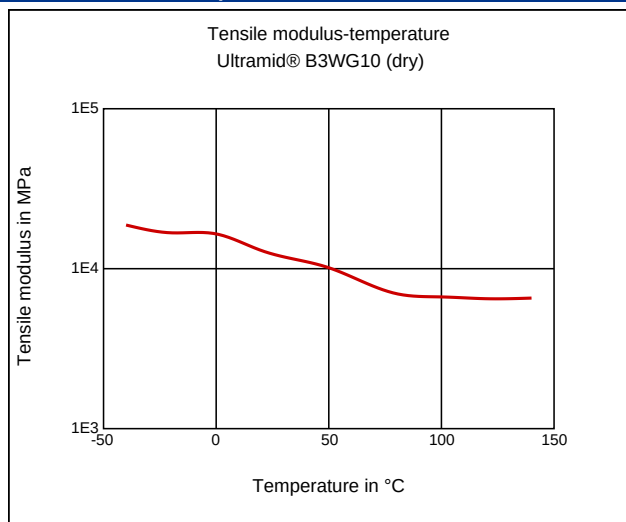
Stress-strain (isochronous) 120°C



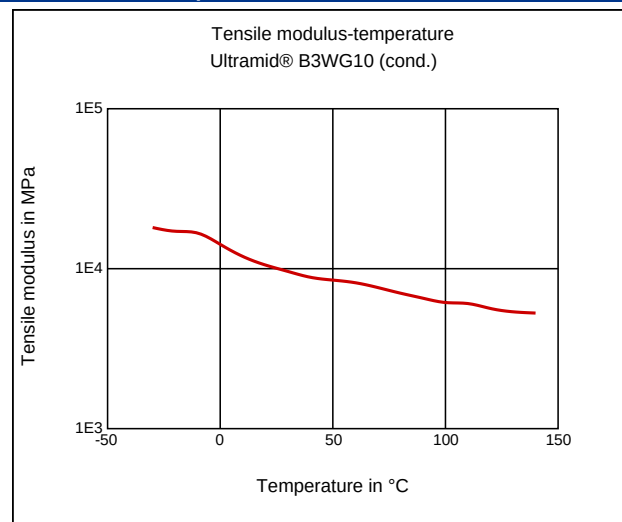
Creep modulus-time 120°C



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

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injection molding, Melt temperature, range: 280 - 300 °C
injection molding, Melt temperature, recommended: 290 °C
injection molding, Mold temperature, range: 80 - 90 °C
injection molding, Mold temperature, recommended: 80 °C
injection molding, Dwell time, thermoplastics: 10 min