

Ultramid® Structure B3WG10 LFX BK23215
PA6-GF50

BASF

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	16300 / 11300	MPa	ISO 527
Stress at Break	250 / 160	MPa	ISO 527
Strain at Break	2.3 / 2.6	%	ISO 527
Impact Strength (Charpy), +23°C	95 / 85	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	85 / 95	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	28 / 28	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	30 / 30	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	16000 / 11500	MPa	ISO 178

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

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1600 / -	kg/m³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	83	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.08	%	-
Melt temperature	280 - 310	°C	-
Mold temperature	80 - 100	°C	-
Injection pressure	3.5 - 12.5	MPa	-

Characteristics

Processing

Injection Molding

Special Characteristics

Heat aging stabilized

Delivery form

Pellets, Black