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Ultramid® B3ZG7 OSI BK23273

PA6-GF35 BASF

Ultramid® B3ZG7 OSI BK2373 is a 35% glass reinforced, pigmented black, heat stabilized, impact modified Polyamide 6 injection molding grade. It was developed to meet demanding mechanical and chemical requirements for the automotive oil pan application.

流变性能	干 / 湿	单位	试验方法
ISO数据			
模塑收缩率, 平行	0.2 / *	%	ISO 294-4, 2577
模塑收缩率, 垂直	0.6 / *	%	ISO 294-4, 2577

机械性能	干 / 湿	单位	试验方法
ISO数据			
拉伸模量	10000 / 6170	MPa	ISO 527
断裂应力	170 / 112	MPa	ISO 527
断裂伸长率	3.5 / 11	%	ISO 527
无缺口简支梁冲击强度, +23°C	102 / 106	kJ/m²	ISO 179/1eU
无缺口简支梁冲击强度, -30°C	113 / -	kJ/m²	ISO 179/1eU
简支梁缺口冲击强度, +23°C	26 / 34	kJ/m²	ISO 179/1eA
简支梁缺口冲击强度, -30°C	18 / -	kJ/m²	ISO 179/1eA
弯曲模量, 23°C	8920 / 5650	MPa	ISO 178
悬臂梁缺口冲击强度, 23°C	24 / 34	kJ/m²	ISO 180/1A
悬臂梁缺口冲击强度	17 / -	kJ/m²	ISO 180/1A
悬臂梁缺口冲击强度 - 温度	-40	°C	-

热性能	干 / 湿	单位	试验方法
ISO数据			
熔融温度, 10°C/min	220 / *	°C	ISO 11357-1/-3
热变形温度, 1.80 MPa	206 / *	°C	ISO 75-1/-2
热变形温度, 0.45 MPa	220 / *	°C	ISO 75-1/-2
线性热膨胀系数, 平行	13.1 / *	E-6/K	ISO 11359-1/-2
线性热膨胀系数, 垂直	110 / *	E-6/K	ISO 11359-1/-2

其它性能	干 / 湿	单位	试验方法
ISO数据			
吸湿性	1.7 / *	%	类似ISO 62
密度	1380 / -	kg/m³	ISO 1183

加工推荐（注塑）	数值	单位	试验方法
预干燥-温度	80	°C	-
预干燥-时间	2 - 4	h	-
加工湿度	≤ 0.08	%	-
注塑熔体温度	270 - 295	°C	-
模具温度	80 - 95	°C	-
1区	245 - 275	°C	-
2区	260 - 285	°C	-
3区	270 - 295	°C	-
喷嘴温度	270 - 295	°C	-
注射压力	3.5 - 12.5	MPa	-

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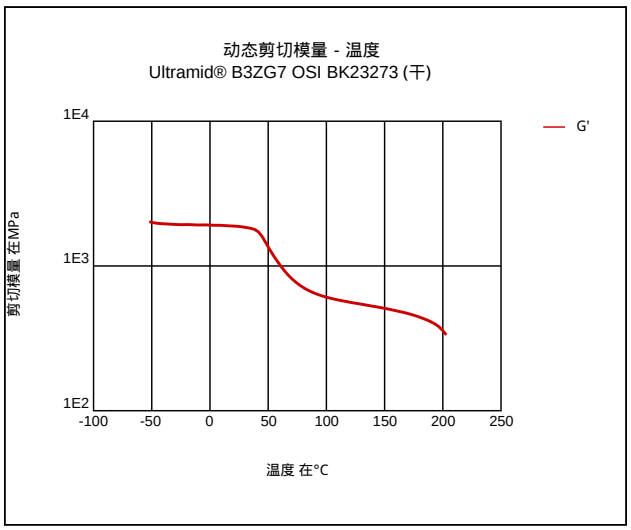
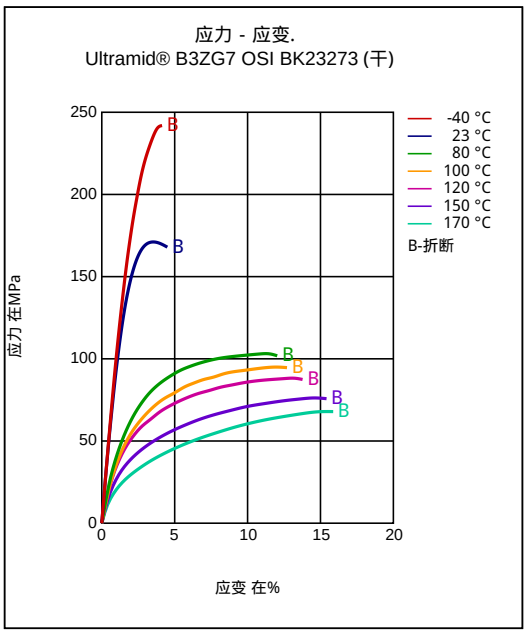
函数

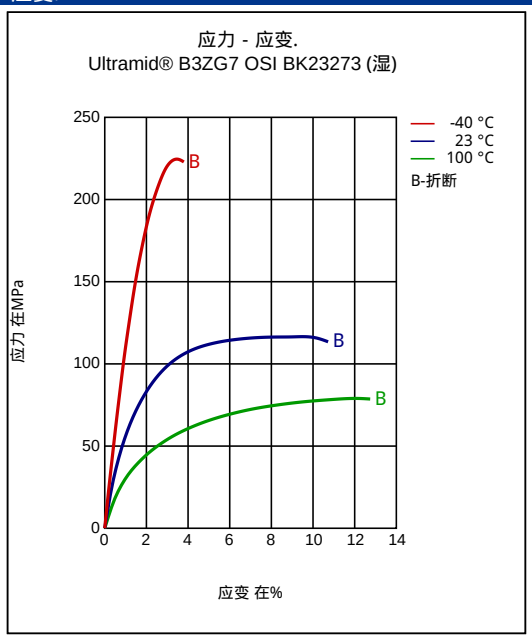
动态剪切模量 - 温度



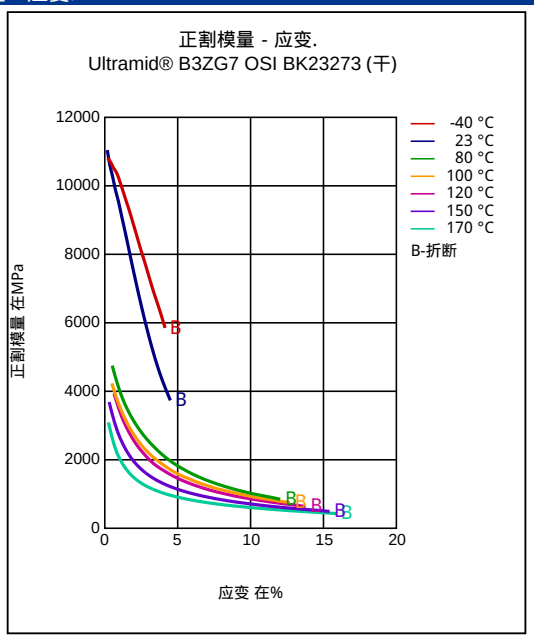
应力 - 应变.



应力 - 应变.



正割模量 - 应变.



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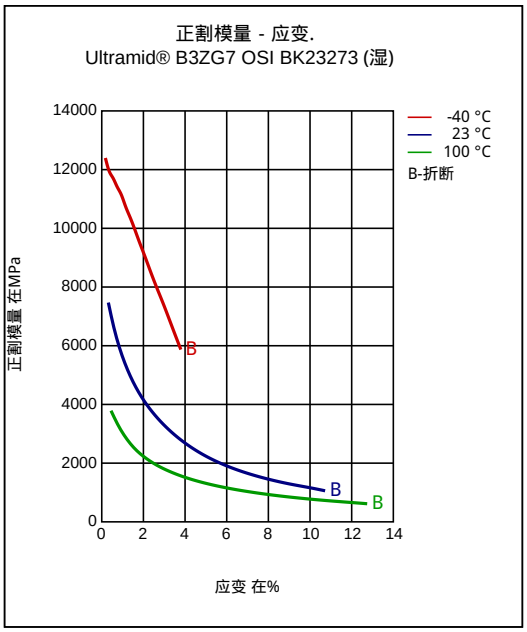
正割模量 - 应变.



特征

加工方法
注塑

耐化学试剂
耐油性

供货形式
粒料, 黑色

应用
汽车

特殊性能
高冲击韧性的/经抗冲改性的, 经热稳处理的/耐热的

注塑

PREPROCESSING
Pre/Post-processing, max. allowed water content: .08 %
Pre/Post-processing, Pre-drying, Temperature: 80 °C
Pre/Post-processing, Pre-drying, Time: 2 - 4 h

PROCESSING
injection molding, Melt temperature, range: 270 - 295 °C
injection molding, Mold temperature, range: 80 - 95 °C

Material Handling
Max. Water content: 0.08%
Product is supplied in sealed containers and drying prior to molding is not required. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 80 °C (176 °F) is recommended. Drying time is dependent on moisture level but 2-4 hours is generally sufficient.
Further information concerning safe handling procedures can be obtained from the Material Safety Data Sheet. Alternatively, please contact your BASF representative.

Typical Profile
Melt Temperature 270-295 °C (518-563 °F)
Mold Temperature 80-95 °C (176-203 °F)
Injection and Packing Pressure 35-125 bar (500-1800psi)
Rear Zone 245-275 °C (473-527 °F)
Center Zone 260-285 °C (500-545 °C)
Front Zone 270-295 °C (518-563 °F)
Nozzle 270-295 °C (518-563 °F)

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Mold Temperatures
This product can be processed over a wide range of mold temperatures; however, for applications where aesthetics are critical, a mold surface temperature of 80-95 °C (176-203 °F) is required.

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. recommended to minimize glass fiber breakage.

Fill Rate
Fast fill rates are recommended to insure uniform melt delivery to the cavity and prevent premature freezing. Surface appearance is directly affected by injection rate.