

Ultramid® Structure A3WG12 LFX BK23215
PA66-GF60

BASF

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	19300 / 15500	MPa	ISO 527
Stress at Break	255 / 195	MPa	ISO 527
Strain at Break	1.8 / 2.1	%	ISO 527
Impact Strength (Charpy), +23°C	90 / 90	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	90 / 90	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	40 / 35	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	40 / 38	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	19400 / 15400	MPa	ISO 178

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	260 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	260 / *	°C	ISO 75-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1700 / -	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	290 - 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