

Ultramid® B3WG10 BK00564

Polyamide 6



Product Description

This resin is a heat stabilized, 50% glass fiber reinforced PA6 injection molding compound offering excellent strength, stiffness, high temperature performance and dimensional stability. It is available in natural, black weather resistant and pigmented versions.

Applications

Ultramid B3WG10 BK00564 is generally recommended for applications such as power tool housings, cattle ear taggers, luggage frames, fans and pressure regulator housings.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm ³	1183	1.56	
Moisture, %	62		
(50% RH)		1.4	
(Saturation)		4.8	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		16,700	-
Tensile stress at break, MPa	527		
23C		225	-
Tensile strain at break, %	527		
23C		2.5	-
Flexural Strength, MPa	178		
23C		345	-
Flexural Modulus, MPa	178		
23C		14,500	-
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
-40C		12	-
23C		15	-
Charpy Notched, kJ/m ²	179		
23C		15	-
Charpy Unnotched, kJ/m ²	179		
23C		90	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	215	-
HDT B, C	75	220	-

Processing Guidelines

Material Handling

Max. Water content: 0.06%

Although Product is supplied in sealed containers, drying is recommended in applications requiring optimum surface aesthetics. A dehumidifying or desiccant dryer operating at 80C (176F) is recommended. Drying time is dependent on moisture level, however 2-4 hours is generally sufficient. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF representative.

Typical Profile

Melt Temperature 280-305C (536-581F)

Mold Temperature 80-95C (176-203F)

Injection and Packing Pressure 35-125 bar (500-1500 psi)

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 80-95C (176-203F) 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.

Fill Rate

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

Note

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