

# Ultramid® B3GK24 BK00564

## Polyamide 6



### Product Description

Ultramid B3GK24 BK00564 is 30% combined glass-fiber and glass bead injection molding PA6 grade for industrial articles having very high dimensional stability.

### Applications

Typical applications include automobile ashtrays and housings for electronics.

PHYSICAL	ISO Test Method	Property Value	
Moisture, %	62		
RHEOLOGICAL	ISO Test Method	Dry	Conditioned
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
Tensile stress at yield, MPa	527		
Tensile stress at break, MPa	527		
Tensile strain at yield, %	527		
Tensile strain at break, %	527		
Flexural Strength, MPa	178		
Flexural Modulus, MPa	178		
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m <sup>2</sup>	180		
Charpy Notched, kJ/m <sup>2</sup>	179		
Charpy Unnotched, kJ/m <sup>2</sup>	179		
THERMAL	ISO Test Method	Dry	Conditioned
Coef. of Linear Thermal Expansion, Parallel, mm/mm C		X10-4	X10-4
Coef. of Linear Thermal Expansion, Normal, mm/mm C		X10-4	X10-4
ELECTRICAL	ISO Test Method	Dry	Conditioned

### Processing Guidelines

#### Material Handling

Material is supplied in sealed containers and drying prior to molding in a dehumidifying or desiccant dryer is recommended. Drying parameters are dependent upon the actual percentage of moisture in the pellets and typical pre-drying conditions are 2-4 hours at 180F (83C). Recommended moisture levels for achieving optimum surface qualities and mechanical properties is 0.05% - 0.12%. Further information concerning safe handling procedures can be obtained from the Material Safety Data Sheet (MSDS), or by contacting your BASF representative.

#### Typical Profile

Melt Temperature 270-295 degC (518-563 degF)  
Mold Temperature 80-95 degC (176-203 degF)  
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 80-95 degC (176-203 degF) is recommended.

## 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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