

Ultramid® B3S BK00464

Polyamide 6



PHYSICAL		ISO Test Method	Property Value	
Density, g/cm ³		1183	1.13	
Moisture, %		62		
(50% RH)			3	
(Saturation)			9.5	
RHEOLOGICAL		ISO Test Method	Dry	Conditioned
Melt Volume Rate (275 C/5 Kg), cc/10min.		1133	175	-
MECHANICAL		ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa		527		
23C			3,400	1,200
Tensile stress at yield, MPa		527		
23C			88	45
Tensile strain at yield, %		527		
23C			3.8	20
Nominal strain at break, %		527		
23C			10	>50
Flexural Modulus, MPa		178		
23C			2,900	-
IMPACT		ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²		180		
23C			3	-
Charpy Notched, kJ/m ²		179		
23C			4	50
-30C			3	-
Charpy Unnotched, kJ/m ²		179		
23C			250	N
-30C			200	-
THERMAL		ISO Test Method	Dry	Conditioned
Melting Point, C		3146	220	-
HDT A, C		75	65	-

Processing Guidelines

Material Handling

Max. Water content: 0.15%

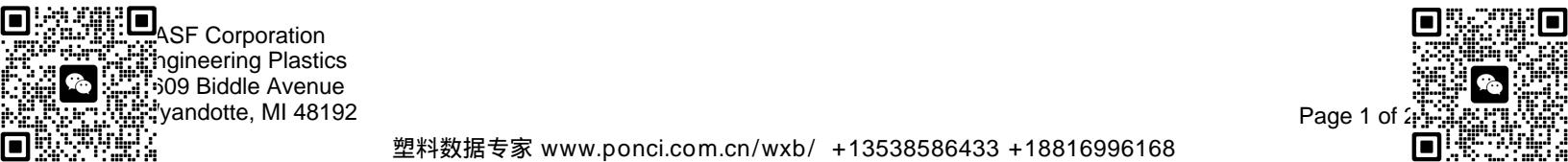
Product is supplied in sealed containers and drying prior to molding is not required. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 80 degC (176 degF) is recommended. Drying time is dependent on moisture level, but 2-4 hours is generally sufficient. Further information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

Typical Profile

Melt Temperature 240-285 degC (464-545 degF)

Mold Temperature 65-80 degC (149-176 degF)

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



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Mold Temperatures

A mold temperature of 65-80 degC (149-176 degF) is recommended, but temperatures of as low as 10 degC (50 degF) can be used where applicable.

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.

Fill Rate

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing.

Note

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