

Ultramid® B3WGM24 HPX **BK23210** **Polyamide 6**



Product Description

Ultramid B3WGM24 HPX BK23210 is a very high productivity, 30% glass/mineral reinforced heat stabilized injection molding PA6 grade for components that require medium rigidity, excellent dimensional stability, low warpage out of the tool and excellent appearance.

Applications

Typical applications include automobile engine covers, housings and automotive door handles.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.36	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		7,900	-
Tensile stress at break, MPa	527		
23C		110	-
Tensile strain at break, %	527		
23C		3.0	-
Flexural Modulus, MPa	178		
23C		7,960	-
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C		5.2	-
-40C		4.4	-
Charpy Notched, kJ/m ²	179		
23C		4.4	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	190	-
HDT B, C	75	210	-

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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