

Ultramid® B35EG3
PA6-GF15

BASF

Glass fibre reinforced injection moulding grade e.g. for internal gas pressure applications such as steering column switch, automobile mirror housings and wheels of mountain bikes.

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	40 / *	cm³/10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	5800 / 3500	MPa	ISO 527
Stress at Break	130 / 70	MPa	ISO 527
Strain at Break	4 / 18	%	ISO 527
Tensile Creep Modulus, 1h	* / 2500	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	* / 2100	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	60 / 105	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	55 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	9 / 25	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	8 / -	kJ/m²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	220 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	190 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	215 / *	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	210 / *	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	32.5 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	75 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.6 / *	mm	-
UL recognition	yes / *	-	-
Oxygen index	22.5 / *	%	ISO 4589-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	3.8 / 7	-	IEC 62631-2-1
Dissipation Factor, 100Hz	250 / 2400	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	250 / 2400	E-4	IEC 62631-2-1
Volume Resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E10	Ohm	IEC 62631-3-2
Comparative tracking index	- / 550	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	8 / *	%	Sim. to ISO 62
Humidity absorption	2.6 / *	%	Sim. to ISO 62
Density	1230 / -	kg/m³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	170 / *	cm³/g	ISO 307, 1157, 1628

Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Ejection temperature	150	°C	-

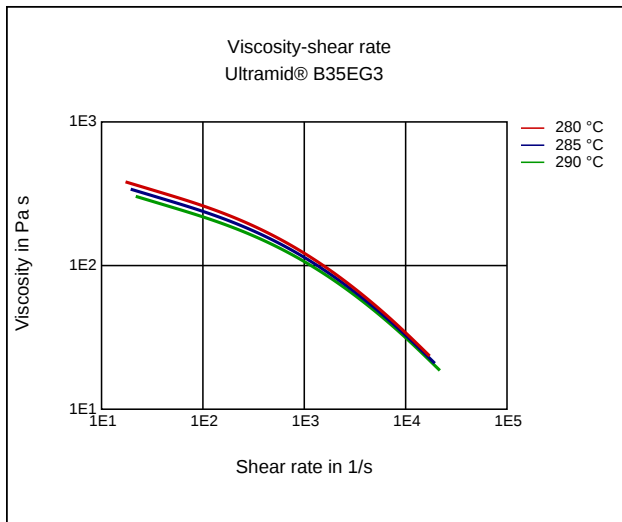
Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294

Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

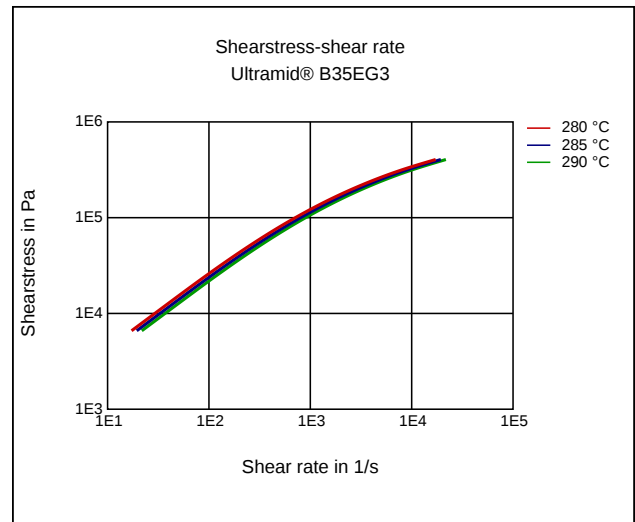
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 90	°C	-

Diagrams

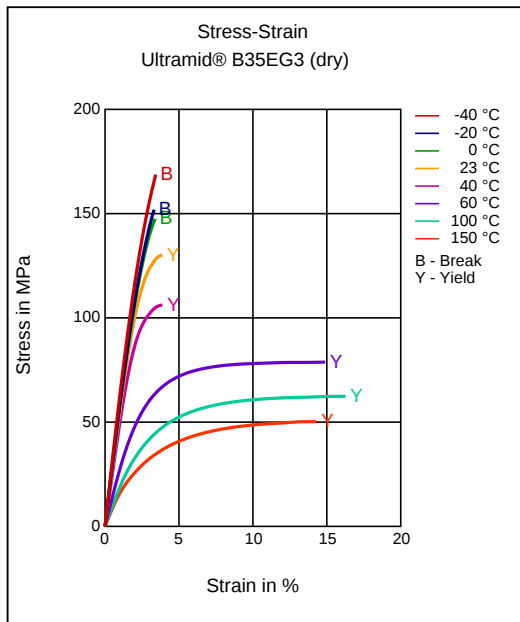
Viscosity-shear rate



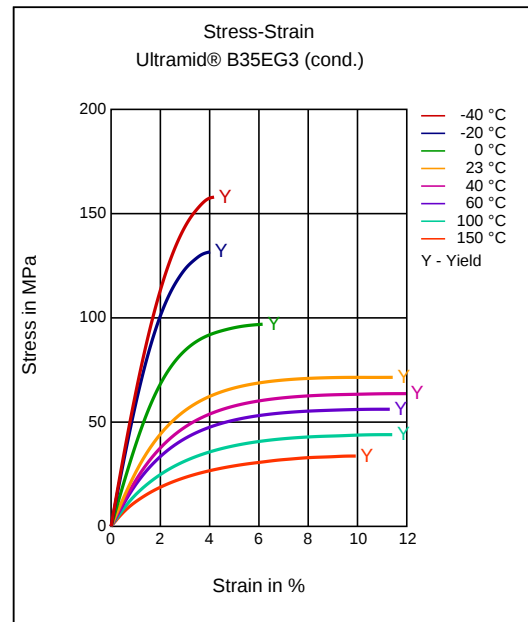
Shearstress-shear rate



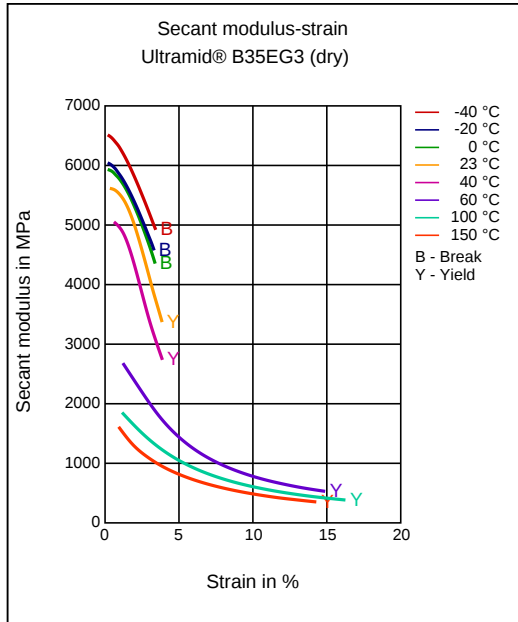
Stress-strain



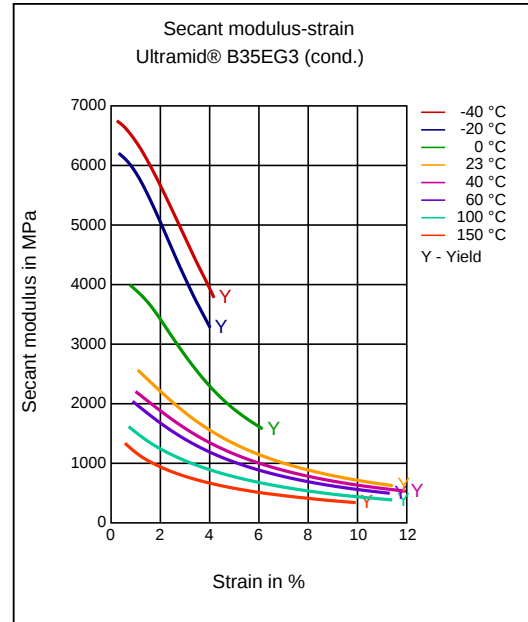
Stress-strain



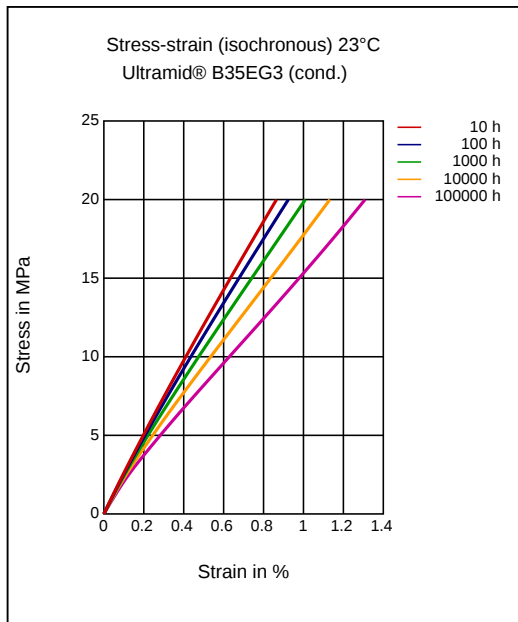
Secant modulus-strain



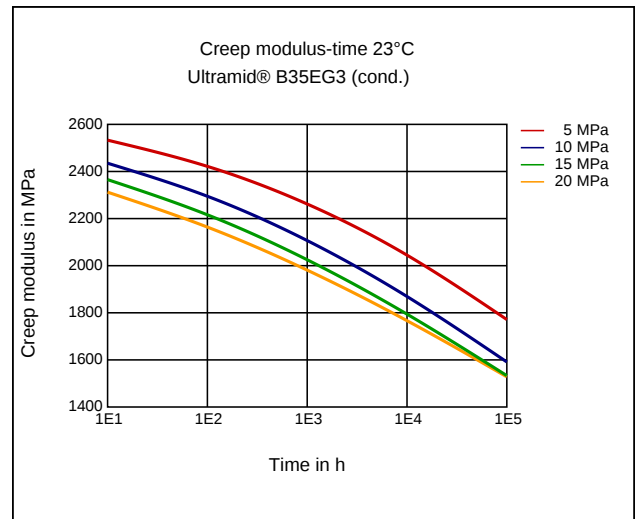
Secant modulus-strain



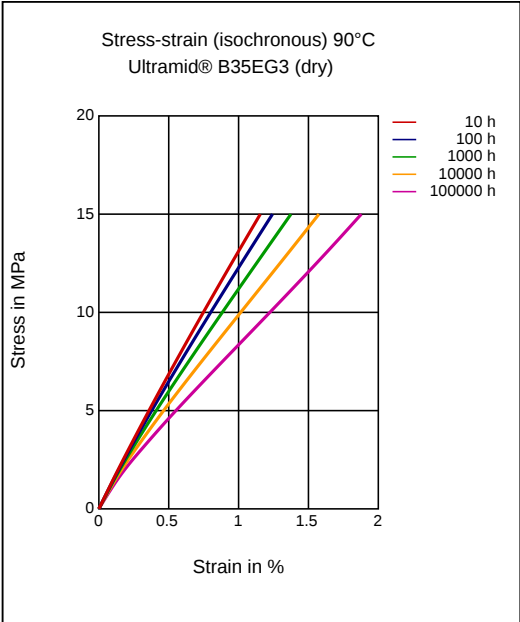
Stress-strain (isochronous) 23 °C



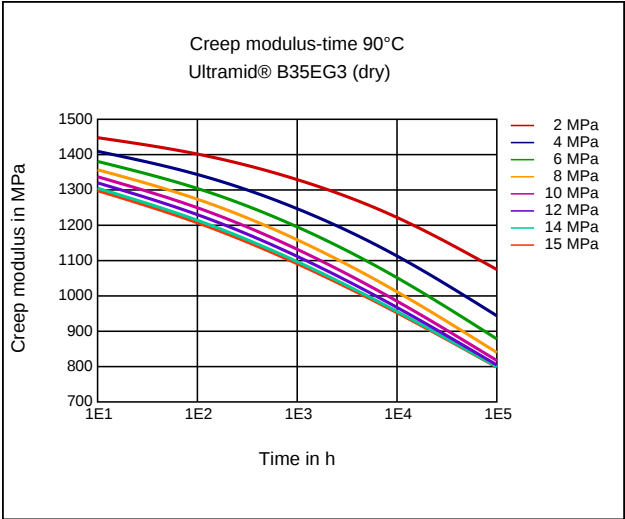
Creep modulus-time 23 °C



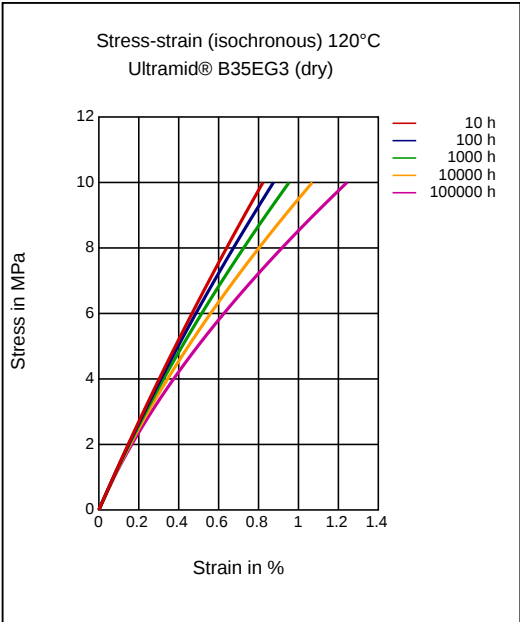
Stress-strain (isochronous) 90 °C



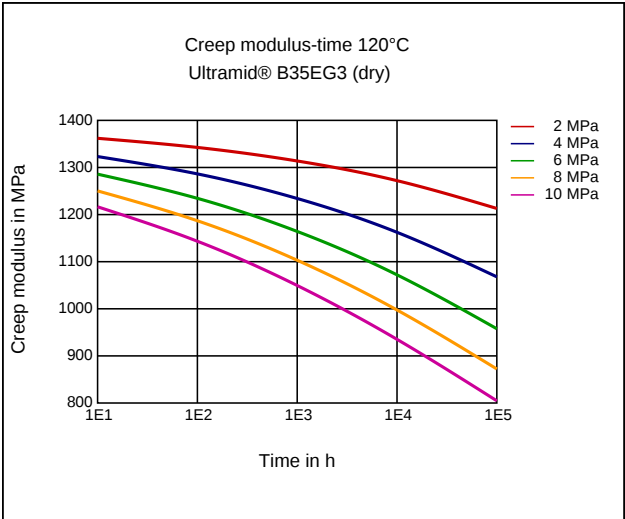
Creep modulus-time 90 °C



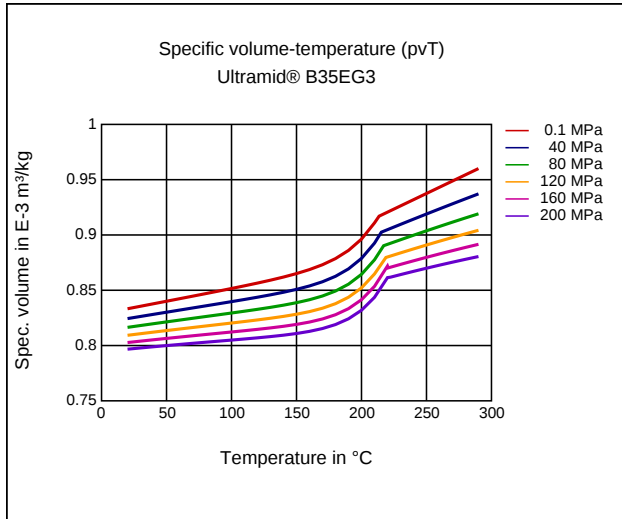
Stress-strain (isochronous) 120 °C



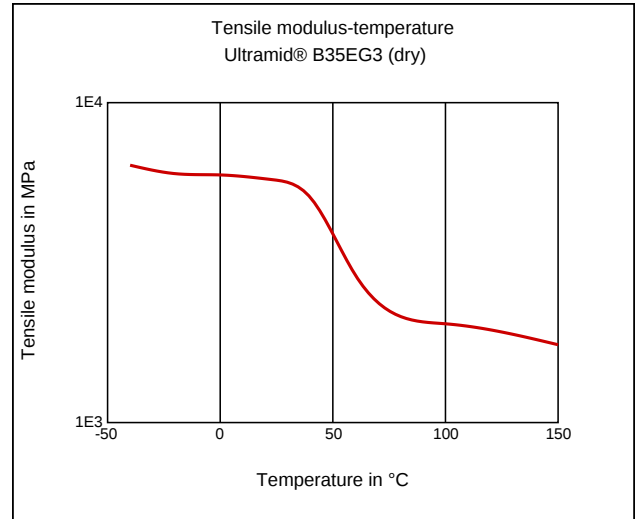
Creep modulus-time 120 °C



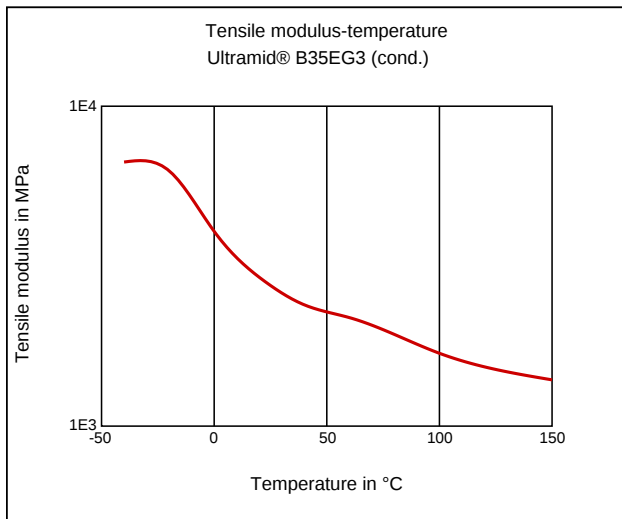
Specific volume-temperature (pvT)



Tensile Modulus-Temperature



Tensile Modulus-Temperature



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Lubricants, Release agent

Special Characteristics

Heat aging stabilized

Injection Molding

PREPROCESSING

Pre/Post-processing, max. allowed water content: .15 %

Pre/Post-processing, Pre-drying, Temperature: 80 °C

Pre/Post-processing, Pre-drying, Time: 4 h

PROCESSING

injection molding, Melt temperature, range: 270 - 290 °C

injection molding, Melt temperature, recommended: 280 °C

injection molding, Mold temperature, range: 80 - 90 °C

injection molding, Mold temperature, recommended: 80 °C

injection molding, Dwell time, thermoplastics: 10 min

Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass) (23°C)

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

Any information given on the chemical and physical characteristics of our products, including, without limitation, technical advice on applications, whether verbally, in writing or by testing the product, is given to the best of our knowledge and in good faith and does not exempt the buyer from carrying out their own investigations and tests in order to ascertain the product's specific suitability for the purpose intended.

The buyer is solely responsible for confirming the suitability of the product for a particular application, its utilization and processing and must observe any applicable laws and government regulations. **NO EXPRESS OR IMPLIED RECOMMENDATION OR WARRANTY IS GIVEN WITH REGARD TO THE SUITABILITY OF THE PRODUCT FOR A PARTICULAR APPLICATION, SUCH AS, BUT NOT LIMITED TO, SAFETY-CRITICAL COMPONENTS OR SYSTEMS.**

Healthcare uses: the supply of any product by ALBIS for any medical, pharmaceutical or diagnostic application is conditional to an assessment by ALBIS in terms of compliance with ALBIS' internal risk management policy – even for products which are in general designated for use in Healthcare applications.

Important: irrespective of product type or designation, ALBIS does not recommend or support the use of any products it supplies which fall into the following medical, pharmaceutical or diagnostic application categories:

- risk class III applications according to EU directive 93/42/EEC
- any bodily implant application for greater than 30 days
- any critical component in any medical device that supports or sustains human life.

At all times, our standard terms and conditions of sale apply.