

Ultramid® B3G10 SI BK20560
PA6-GF50

BASF

Glass fibre-reinforced injection moulding grade, with excellent surface quality especially suitable for the production of visible parts with very high stiffness. Optimum surface quality is generally obtained at a very high injection speed.

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	12 / *	cm³/10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	16500 / 10800	MPa	ISO 527
Stress at Break	235 / 160	MPa	ISO 527
Strain at Break	3 / 5	%	ISO 527
Impact Strength (Charpy), +23°C	95 / 100	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	85 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	20 / 25	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	16 / -	kJ/m²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Temp. of deflection under load (1.80 MPa)	200 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	215 / *	°C	ISO 75-1/-2

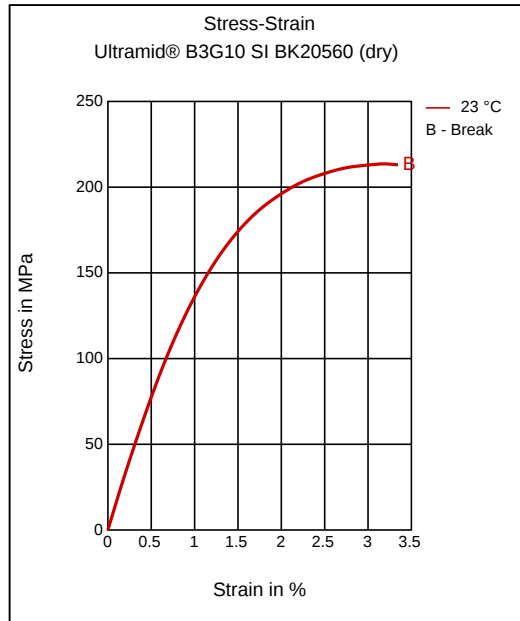
Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1570 / -	kg/m³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	135 / *	cm³/g	ISO 307, 1157, 1628

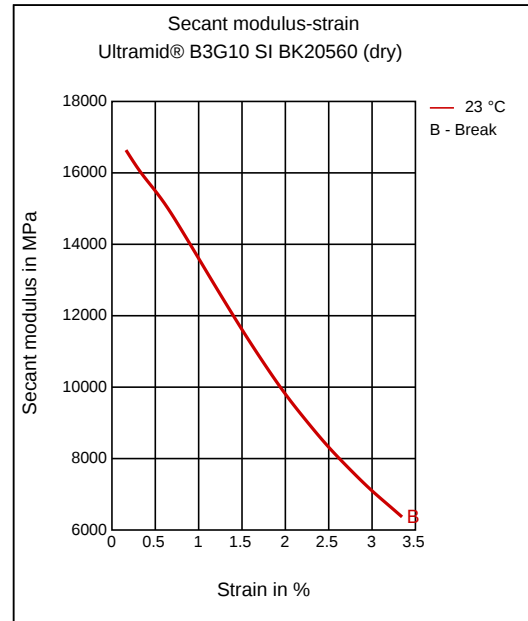
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 110	°C	-

Diagrams

Stress-strain



Secant modulus-strain



Characteristics

Processing

Injection Molding

Delivery form

Pellets, Black

Additives

Release agent

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: 280 - 300 °C

injection molding, Melt temperature, recommended: 290 °C

injection molding, Mold temperature, range: 80 - 110 °C

injection molding, Mold temperature, recommended: 100 °C

injection molding, Dwell time, thermoplastics: 10 min

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.**

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- any critical component in any medical device that supports or sustains human life.

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