Ultramid® Exp.A3E3G6 DC OR

PA66-GF30 BASF

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	30 / *	cm³/10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	10300 / 8100	MPa	ISO 527
Stress at Break	200 / 130	MPa	ISO 527
Strain at Break	2.9 / 4.2	%	ISO 527
Impact Strength (Charpy), +23°C	65 / 75	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	60 / 60	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	9.8 / 10.9	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	8.1 / 7.7	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	9300 / 7500	MPa	ISO 178
Flexural strength	256 / 210	MPa	ISO 178

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	260 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	240 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	260 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	24 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	74 / *	E-6/K	ISO 11359-1/-2

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Density	1380 / -	kg/m³	ISO 1183
Bulk density	700	kg/m³	-

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	129 / *	cm³/g	ISO 307, 1157, 1628

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 90	°C	-

Processing Recommendation Extrusion	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Melt temperature	280 - 300	°C	-

Characteristics

Processing
Injection Molding, Other Extrusion

Features
Color Stability

Delivery form
Pellets

Applications
Electrical and Electronical

Disclaimer

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