

Ultramid® B3WG7 BK00564

Polyamide 6



Product Description

Ultramid B3WG7 BK00564 is a 35% glass fiber reinforced, pigmented black, injection molding PA6 grade for highly rigid, dimensionally stable components which are resistant to high temperature aging and have improved retention of properties in a hot water environment.

Applications

Typical applications include automotive clutch and accelerator pedals.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm ³	1183	1.40	
Moisture, %	62		
(50% RH)		2	
(Saturation)		6.2	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		11,000	7,200
Tensile stress at break, MPa	527		
23C		190	120
Tensile strain at break, %	527		
23C		2.7	6.3
Flexural Strength, MPa	178		
23C		290	180
Flexural Modulus, MPa	178		
23C		10,000	6,800
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C		13	23
Charpy Notched, kJ/m ²	179		
-40C		10	-
-30C		10	-
23C		13	23
Charpy Unnotched, kJ/m ²	179		
-30C		72	-
23C		85	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	209	-
ELECTRICAL	ISO Test Method	Dry	Conditioned
Comparative Tracking Index	IEC 60112	450	450
Volume Resistivity (Ohm-m)	IEC 60093	1E13	1E10
Dielectric Constant (1 MHz)	IEC 60250	3.9	6.2
Dissipation Factor (100 Hz), E-4	IEC 60250	210	1,900
Dissipation Factor (1 MHz), E-4	IEC 60250	210	1,900

Processing Guidelines

Material Handling

Max. Water content: 0.15%

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 Safety Data Sheet (MSDS), or by contacting your BASF representative.

Typical Profile

Melt Temperature 270-295C (518-563F)

Mold Temperature 80-95C (176-203F)

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 80-95C (176-203F) 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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