

Ultramid® B3S FC R01

Polyamide 6



Product Description

Ultramid B3S FC R01 is a general purpose, PA6 resin for injection molding.

Applications

Intended for food contact applications

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm ³	1183	1.13	
RHEOLOGICAL	ISO Test Method	Dry	Conditioned
Melt Volume Rate (275 C/5 Kg), cc/10min.	1133	145	-
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		3,200	-
Tensile stress at yield, MPa	527		
23C		85	-
Tensile strain at yield, %	527		
23C		3.8	-
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C		5	-
Charpy Notched, kJ/m ²	179		
23C		3	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	65	-
HDT B, C	75	180	-

Processing Guidelines

Material Handling

Max. Water content: 0.15%

Product is supplied in sealed containers and drying prior to molding is not required. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 80C (176F) is recommended. Drying time is dependent on moisture level, however 2-4 hours is generally sufficient. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF representative.

Typical Profile

Melt Temperature: 240-285C (464-545F)

Mold Temperature: 65-80C (149-176F)

Injection and Packing Pressure: 35-125 bar (500-1500 psi)

Mold Temperatures

A mold temperature of 65-80C (149-176F) is recommended, however temperatures of as low as 10C (50F) can be used where applicable.

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.

Fill Rate

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing.

Note

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