

Ultramid® Structure A3WG10 LFX BK23215

Polyamide 66

Product Description

Ultramid Structure A3WG10 LFX BK23215 is a 50% long glass-fiber reinforced and heat aging resistant injection molding grade designed for applications requiring excellent strength and stiffness.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm ³	1183	1.57	
Mold Shrinkage, parallel, %	294-4	0.4	
Mold Shrinkage, normal, %	294-4	0.75	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23°C		16,400	13,000
Tensile stress at break, MPa	527		
23°C		275	188
Tensile strain at break, %	527		
23°C		2.2	2.3
Flexural Strength, MPa	178		
23°C		390	290
Flexural Modulus, MPa	178		
23°C		15,400	11,900
IMPACT	ISO Test Method	Dry	Conditioned
Charpy Notched, kJ/m ²	179		
-30°C		32	30
23°C		29	26
Charpy Unnotched, kJ/m ²	179		
-30°C		82	84
23°C		90	90
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, °C	3146	260	-
HDT A, °C	75	260	-

Processing Guidelines

Material Handling

Max. Water content: 0.12%

Ultramid 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 83 degC (181 degF). Recommended moisture levels for achieving optimum surface qualities and mechanical properties is 0.03% - 0.08%. Further information concerning safe handling procedures can be obtained from the Material Safety Data Sheet (MSDS), or by contacting your BASF representative.

Typical Profile

Melt Temperature 290-310 degC (554-590 degF)

Mold Temperature 80-100 degC (176-212 degF)

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

Mold Temperatures

A mold temperature of 80-100 degC (176-212 degF) 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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