Product Information

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Ultramid® A3WG10
Polyamide 66

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Product Description

Ultramid A3WG10 is a 50% glass fiber reinforced and heat aging resistance injection molding PA66 grade.

Applications

Typical applications include industrial articles having very high rigidity.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm³	1183	1.55	
Moisture, %	62		
(50% RH)		1.2	
(Saturation)		4	
RHEOLOGICAL	**ISO Test Method**	**Dry**	**Conditioned**
Melt Volume Rate (275 C/5 Kg), cc/10min.	1133	20	-
MECHANICAL	**ISO Test Method**	**Dry**	**Conditioned**
Tensile Modulus, MPa	527		
23C		16,800	12,500
Tensile stress at break, MPa	527		
23C		230	180
80C		151	113
Tensile strain at break, %	527		
23C		2.5	3.5
80C		5.2	4.9
Flexural Modulus, MPa	178		
23C		15,000	-
IMPACT	**ISO Test Method**	**Dry**	**Conditioned**
Charpy Notched, kJ/m²	179		
-30C		13	-
23C		18	25
Charpy Unnotched, kJ/m²	179		
-30C		85	-
23C		95	100
THERMAL	**ISO Test Method**	**Dry**	**Conditioned**
Melting Point, C	3146	260	-
HDT A, C	75	250	-
HDT B, C	75	250	-
Coef. of Linear Thermal Expansion, Parallel, mm/mm C		0.13 X10-4	-
Coef. of Linear Thermal Expansion, Normal, mm/mm C		0.55 X10-4	-
ELECTRICAL	**ISO Test Method**	**Dry**	**Conditioned**
Comparative Tracking Index	IEC 60112	450	450
Volume Resistivity (Ohm-m)	IEC 60093	1E13	1E10

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Dielectric Constant (1 MHz)	IEC 60250	3.8	6.6
Dissipation Factor (100 Hz), E-4	IEC 60250	150	1,700
Dissipation Factor (1 MHz), E-4	IEC 60250	150	3,000

UL RATINGS	UL Test Method	Property Value
Flammability Rating, 0.8mm	UL94	HB
Relative Temperature Index, 0.8mm	UL746B	
Electrical, C		125
Flammability Rating, 1.5mm	UL94	HB
Relative Temperature Index, 1.5mm	UL746B	
Mechanical w/o Impact, C		130
Mechanical w/ Impact, C		130
Electrical, C		125
Flammability Rating, 3.0mm	UL94	HB
Relative Temperature Index, 3.0mm	UL746B	
Mechanical w/o Impact, C		130
Mechanical w/ Impact, C		130
Electrical, C		125

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. 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. Alternatively, please contact your BASF representative.

Typical Profile
Melt Temperature 280-305C (536-581F)
Mold Temperature 80-90C (176-194F)
Injection and Packing Pressure 35-125 bar (500-1500 psi)

Mold Temperatures
A mold temperature of 80-90C (176-194F) is recommended, however temperatures of as low as 45C (113F) and as high as 105C (221F) 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.

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

Note

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