

ASTAMID™ MB3TUV

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3TUV is an Impact Modified, Heat and UV Stabilised Polyamide 6 (PA 6 or Nylon 6).
Note: The letters "UV" indicate UV stabilisation has been added.

General Information			
Additive	Heat Stabilizer		
	Impact Modifier		
	UV Stabilizer		
Features	Heat Stabilized		
	Impact Modified		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/2.16 kg)	12	g/10 min	ASTM D1238
Water Absorption (Equilibrium, 23°C, 50% RH)	2.4	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (3.20 mm)	45.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	4.5	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1800	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	65.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	800	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	50.0	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 80.0	°C	
Drying Time	2.0	hr	
Rear Temperature	250 to 255	°C	
Middle Temperature	255 to 265	°C	
Front Temperature	265 to 270	°C	
Processing (Melt) Temp	255 to 265	°C	
Mold Temperature	50.0 to 80.0	°C	
Injection Pressure	60.0 to 120	MPa	
Injection Rate	Fast		

Back Pressure	0.100 to 0.500	MPa
Screw Speed	40 to 60	rpm
Clamp Tonnage	3.0 to 5.0	kN/cm ²

NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	

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