

ASTAMID™ MB3SW

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3SW is an easy flow, heat and UV stabilized injection moulding grade of PA6 designed for fast processing.

General Information				
Additive	Heat Stabilizer			
	UV Stabilizer			
Features	Fast Molding Cycle			
	Good Flow			
	Heat Stabilized			
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.13	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.5	--	%	ASTM D955
Water Absorption				ISO 62
23°C, 24 hr	9.5	--	%	
Equilibrium, 23°C, 50% RH	3.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	3400	1150	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	85.0	45.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	4.5	25	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2950	1000	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength ⁵	4.0	--	kJ/m ²	ISO 179
Notched Izod Impact (3.20 mm)	45 J/m	No Break		ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed, 3.20 mm	185	--	°C	
1.8 MPa, Unannealed, 3.20 mm	66.0	--	°C	
CLTE - Flow	8.5E-5	--	cm/cm/°C	ASTM D696

Flammability	Dry	Conditioned	Test Method
Flame Rating (1.60 mm)	HB	--	UL 94
Injection	Dry	Unit	
Drying Temperature	75.0 to 85.0		°C
Drying Time	2.0		hr
Rear Temperature	220 to 240		°C
Middle Temperature	230 to 250		°C
Front Temperature	240 to 260		°C
Processing (Melt) Temp	250 to 280		°C
Mold Temperature	40.0 to 80.0		°C
Injection Pressure	60.0 to 140		MPa
Injection Rate	Moderate-Fast		
Back Pressure	0.100 to 0.500		MPa
Screw Speed	40 to 60		rpm
Clamp Tonnage	5.0 to 9.0		kN/cm ²

NOTE

1. 50 mm/min
2. 50 mm/min
3. 5.0 mm/min
4. 1.3 mm/min
5. 4 mm

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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