

ASTAMID™ MA3G3HS

Polyamide 66
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MA3G3HS is a 15% glass fibre reinforced and heat stabilised injection moulding grade of Polyamide 66 (PA 66) designed for general industrial applications requiring medium level of strength and rigidity. It has good chemical resistance, heat resistance and long term durability.
Note: The letters "UV" or "W" indicate UV stabilisation has been added [ie: ASTAMID™ MA3EG7UV].

General Information				
Filler / Reinforcement		Glass fiber reinforced material, 15% filler by weight		
Additive		heat stabilizer		
Features		Good strength		
		Good chemical resistance		
		Heat resistance, medium		
		Durability		
		Thermal Stability		
		Medium hardness		
Uses		Industrial application		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.23	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.70	--	%	ASTM D955
Water Absorption (24 hr)	6.5	--	%	ASTM D570
Moisture Regain ¹	2.0	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (M-Scale)	115	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ² (3.20 mm)	6000	4500	MPa	ASTM D638
Tensile Strength ³ (3.20 mm)	125	80.0	MPa	ASTM D638
Tensile Elongation ⁴ (Break, 3.20 mm)	3.0	9.0	%	ASTM D638
Flexural Modulus ⁵ (3.20 mm)	5700	4100	MPa	ASTM D790
Flexural Strength ⁶ (3.20 mm)	240	170	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (3.20 mm)	65	110	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	240	--	°C	ASTM D648
CLTE - Flow	2.2E-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 - 85.0		°C	
Drying Time	2.0		hr	
Rear Temperature	270 - 290		°C	
Middle Temperature	280 - 295		°C	
Front Temperature	290 - 300		°C	
Processing (Melt) Temp	260 - 285		°C	
Mold Temperature	50.0 - 80.0		°C	
Injection Pressure	60.0 - 130		MPa	
Injection Rate	Fast			
Back Pressure	0.100 - 0.500		MPa	
Screw Speed	40 - 60		rpm	
Clamp Tonnage	3.0 - 5.0		kN/cm ²	
Injection instructions				
Drying Time (Opened Bag): > 12 hr				
NOTE				
1.	65% RH			
2.	5.0 mm/min			
3.	5.0 mm/min			
4.	5.0 mm/min			
5.	1.3 mm/min			
6.	1.3 mm/min			

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