

ASTAMID™ MB3G8HS

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3G8 HS is a highly heat stabilised 40% glass fibre reinforced Polyamide 6 grade. ASTAMID™ MB3G8 HS has been developed for structural applications within the automotive sector.

General Information				
Filler / Reinforcement		Glass Fiber,40% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Uses		Automotive Applications		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.43	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30	--	%	ASTM D955
Water Absorption				
Saturation, 23°C	5.7	--	%	ASTM D570
Equilibrium, 23°C, 50% RH	2.0	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	13000	8200	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	205	135	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	3.0	5.0	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	10500	7400	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	280	200	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength ⁶	20	30	kJ/m ²	ISO 179
Notched Izod Impact (3.20 mm)	180	250	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed, 3.20 mm	220	--	°C	
1.8 MPa, Unannealed, 3.20 mm	215	--	°C	
CLTE - Flow	3.0E-5	--	cm/cm/°C	ASTM D696
Flammability	Dry	Conditioned		Test Method

Flame Rating (1.60 mm)	HB	--	UL 94
Injection	Dry	Unit	
Drying Temperature	80.0 to 90.0		°C
Drying Time	2.0		hr
Rear Temperature	255 to 265		°C
Middle Temperature	265 to 275		°C
Front Temperature	275 to 285		°C
Processing (Melt) Temp	260 to 290		°C
Mold Temperature	50.0 to 80.0		°C
Injection Pressure	60.0 to 130		MPa
Injection Rate	Moderate-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. 5.0 mm/min
2. 5.0 mm/min
3. 5.0 mm/min
4. 1.3 mm/min
5. 1.3 mm/min
6. 4 mm

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