

Ultramid® A3HG6 WIT

Polyamide 6T/66 Copolymer

BASF Corporation

Message:

Glass fibre reinforced injection moulding grade with good resistance to hydrolysis, suited for processing by water injection technology (WIT). Applications in the automotive cooling circuit, e.g. cooling water pipes.

General Information				
Filler / Reinforcement		Glass Beads \Glass Fiber, 30% Filler by Weight		
Features		Copolymer		
		Hydrolysis resistance		
		Oil resistance		
Uses		Application in Automobile Field		
Agency Ratings		EC 1907/2006 (REACH)		
RoHS Compliance		RoHS compliance		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.37	--	g/cm ³	ISO 1183
Apparent Density	0.70	--	g/cm ³	
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	8.00	--	cm ³ /10min	ISO 1133
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.86	--	%	ISO 294-4
Flow direction	0.37	--	%	ISO 294-4
Viscosity Number (96% H ₂ SO ₄)	146	--	cm ³ /g	ISO 307
Mold Shrinkage - constrained ¹	0.36	--	%	
Polymer Abbreviation	(PA66+PA6T/6)-(GF+GB)30	--		
Screw Speed			mm/sec	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	8700	5300	MPa	ISO 527-2
Tensile Stress (Break)	165	95.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	4.9	%	ISO 527-2
Flexural Modulus	7900	4900	MPa	ISO 178
Flexural Stress	250	150	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	5.0	5.0	kJ/m ²	ISO 179/1eA

23°C	6.0	8.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength				ISO 179/1eU
-30°C	50	50	kJ/m ²	ISO 179/1eU
23°C	55	85	kJ/m ²	ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	250	--	°C	ISO 75-2/B
1.8 MPa, not annealed	230	--	°C	ISO 75-2/A
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0		hr	
Suggested Max Moisture	0.15		%	
Hopper Temperature	80.0		°C	
Rear Temperature	290		°C	
Middle Temperature	290		°C	
Front Temperature	290		°C	
Nozzle Temperature	290		°C	
Processing (Melt) Temp	280 - 300		°C	
Mold Temperature	80.0 - 90.0		°C	
Injection instructions				
Residence Time : <10 min				
NOTE				

1. Test box with central gating, dimensions of base (107*47*1,5) mm, processing conditions: TM = 290°C, TW = 80°C

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