

Ultramid® Endure D3G10 BK20560

Polyamide 66

BASF Corporation

Message:

Ultramid Endure D3G10 BK20560 is a glass fiber reinforced injection molding grade with high stiffness, very good flowability, and excellent heat aging resistance up to at least 220 degC (428 degF).

General Information			
Filler / Reinforcement	Glass Fiber		
Features	Good Flow		
	Good Heat Aging Resistance		
	High Stiffness		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.61	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	0.77	%	
Flow	0.30	%	
Water Absorption			ISO 62
Saturation, 23°C	3.7 to 4.3	%	
Equilibrium, 23°C, 50% RH	1.0 to 1.4	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	17400	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	240	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2.6	%	ISO 527-2
Flexural Modulus (23°C)	16200	MPa	ISO 178
Flexural Stress (23°C)	375	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	14	kJ/m ²	
23°C	15	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179
-30°C	88	kJ/m ²	
23°C	97	kJ/m ²	
Notched Izod Impact Strength			ISO 180
-30°C	17	kJ/m ²	

23°C	19	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	259	°C	ISO 75-2/B
1.8 MPa, Unannealed	248	°C	ISO 75-2/A
Melting Temperature (DSC)	260	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.12	%	
Processing (Melt) Temp	280 to 300	°C	
Mold Temperature	80.0 to 90.0	°C	
Injection Pressure	3.50 to 12.5	MPa	
Injection Rate	Fast		

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