

ASTAMID™ MA3WG63

Polyamide 66
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MA3WG63 is a 33% glass reinforced, heat stabilised & UV improved grade of Polyamide 66 (PA 66 or Nylon 66). It is intended for use in metal replacement applications or assemblies requiring high strength, high rigidity, high heat resistance, high chemical resistance and long term durability. This grade is a direct replacement for Maranyl grade A190S.

General Information				
Filler / Reinforcement		Glass Fiber,33% Filler by Weight		
Additive		Heat Stabilizer		
		UV Stabilizer		
Features		Durable		
		Good Chemical Resistance		
		Heat Stabilized		
		High Heat Resistance		
		High Rigidity		
		High Strength		
Uses		Metal Replacement		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.39	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.40	--	%	ASTM D955
Water Absorption (24 hr)	1.6	--	%	ASTM D570
Moisture Regain ¹	5.0	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (M-Scale)	120	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ² (3.20 mm)	10000	7500	MPa	ASTM D638
Tensile Strength ³ (3.20 mm)	185	135	MPa	ASTM D638
Tensile Elongation ⁴ (Break, 3.20 mm)	3.0	5.0	%	ASTM D638
Flexural Modulus ⁵ (3.20 mm)	9500	7250	MPa	ASTM D790
Flexural Strength ⁶ (3.20 mm)	280	230	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (3.20 mm)	100	150	J/m	ASTM D256

Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	250	--	°C	ASTM D648
CLTE - Flow	1.5E-5 to 2.0E-5	--	cm/cm/°C	ASTM D696
Flammability	Dry	Conditioned		Test Method
Flame Rating (1.60 mm)	HB	--		UL 94
Injection	Dry	Unit		
Drying Temperature	75.0 to 85.0		°C	
Drying Time	2.0		hr	
Rear Temperature	260 to 280		°C	
Middle Temperature	270 to 290		°C	
Front Temperature	280 to 300		°C	
Processing (Melt) Temp	280 to 310		°C	
Mold Temperature	50.0 to 80.0		°C	
Injection Pressure	60.0 to 130		MPa	
Injection Rate	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. 65% RH
2. 5.0 mm/min
3. 5.0 mm/min
4. 5.0 mm/min
5. 10 mm/min
6. 1.3 mm/min

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