

Ultramid® B3M8 (8260)

Polyamide 6

BASF Corporation

Message:

Ultramid B3M8 (8260) is a 40% mineral reinforced PA6 injection molding compound. It possesses high stiffness, dimensional stability and heat resistance combined with excellent processability including low warp and resistance to sink-mark formation. It is also available in heat stabilized (Ultramid B3WM8) versions. It can be painted or chrome plated and is also available in pigmented versions.

General Information				
Filler / Reinforcement		Mineral,40% Filler by Weight		
Features		Good Dimensional Stability		
		Good Processability		
		High Heat Resistance		
		High Stiffness		
		Low Warpage		
		Paintable		
Agency Ratings		EC 1907/2006 (REACH)		
RoHS Compliance		RoHS Compliant		
Appearance		Colors Available		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.49	--	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage - Flow (3.18 mm)	0.90	--	%	
Water Absorption				
24 hr	1.1	--	%	ASTM D570
23°C, 24 hr	1.1	--	%	ISO 62
Saturation	5.7	--	%	ASTM D570
Saturation, 23°C	5.7	--	%	ISO 62
Equilibrium, 50% RH	1.6	--	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.6	--	%	ISO 62
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	119	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus				ISO 527-2
-40°C	8310	--	MPa	
23°C	6400	2390	MPa	
80°C	1360	--	MPa	

121°C	970	--	MPa	
Tensile Strength				
Break, 23°C	90.0	60.0	MPa	ASTM D638
Break, 23°C	85.0	60.0	MPa	ISO 527-2
Tensile Elongation (Break, 23°C)	10	30	%	ASTM D638, ISO 527-2
Flexural Modulus				
-40°C	5860	--	MPa	ASTM D790
23°C	5760	2730	MPa	ASTM D790
65°C	1540	--	MPa	ASTM D790
90°C	810	--	MPa	ASTM D790
121°C	815	--	MPa	ASTM D790
23°C	5200	2100	MPa	ISO 178
Flexural Strength				
-40°C	207	--	MPa	ASTM D790
23°C	138	76.0	MPa	ASTM D790
65°C	55.0	--	MPa	ASTM D790
90°C	35.0	--	MPa	ASTM D790
121°C	34.0	--	MPa	ASTM D790
23°C	140	50.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
-30°C	3.0	--	kJ/m ²	
23°C	3.0	--	kJ/m ²	
Charpy Unnotched Impact Strength (23°C)	120	--	kJ/m ²	ISO 179
Notched Izod Impact (23°C)	53	--	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)				
	195	--	°C	ISO 75-2/B
Peak Melting Temperature	220	--	°C	ASTM D3418, ISO 3146
CLTE				
Flow	5.0E-5	--	cm/cm/°C	ASTM E831
Flow	4.6E-5	--	cm/cm/°C	
Transverse	5.8E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method
Volume Resistivity				
1.50 mm	> 1.0E+15	--	ohms · cm	ASTM D257
--	> 1.0E+15	--	ohms · cm	IEC 60093
Dielectric Strength ¹ (1.50 mm)	22	--	kV/mm	ASTM D149

Additional Information	Dry	Conditioned	Unit	Test Method
Drop Weight Impact Strength (23°C)	6.78	108	J	Internal Method
Injection	Dry	Unit		
Drying Temperature	83.0		°C	
Drying Time	2.0 to 4.0		hr	
Suggested Max Moisture	0.15		%	
Processing (Melt) Temp	270 to 295		°C	
Mold Temperature	80.0 to 95.0		°C	
Injection Pressure	3.50 to 12.5		MPa	
Injection Rate	Fast			
NOTE				

1. Method A (Short-Time)

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