

ASTAMID™ MB3GM24HS

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3GM24HS is a highly heat stabilised combination 30% glass fibre and mineral filled Polyamide 6 grade. The product reinforcement levels are 10% glass fibres and 20% mineral. ASTAMID™ MB3GM24 HS has been developed for the automotive sector and is intended for metal replacement applications within the powertrain area. DRY indicates "Dry-As-Moulded" and WET indicates "Conditioned at 23 °C & 50% RH"

General Information				
Filler / Reinforcement	Glass fiber reinforced material, 10% filler by weight Mineral filler, 20% filler by weight			
Additive	heat stabilizer			
Features	Thermal Stability			
Uses	Metal substitution Application in Automobile Field			
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.37	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.60	--	%	ASTM D955
Water Absorption				
24 hr	7.2	--	%	ASTM D570
Equilibrium, 23°C, 50% RH	2.2	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (3.20 mm)	6250	3650	MPa	ASTM D638
Tensile Strength (3.20 mm)	105	62.0	MPa	ASTM D638
Tensile Elongation (Break, 3.20 mm)	4.0	12	%	ASTM D638
Flexural Modulus (3.20 mm)	5500	2850	MPa	ASTM D790
Flexural Strength (3.20 mm)	162	82.0	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength ¹	5.0	9.0	kJ/m ²	ISO 179
Notched Izod Impact ² (3.20 mm)	55	95	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load ³				ASTM D648
0.45 MPa, unannealed, 3.20mm	215	--	°C	ASTM D648

1.8 MPa, unannealed, 3.20mm	175	--	°C	ASTM D648
CLTE - Flow	4.2E-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 - 85.0		°C	
Rear Temperature	250 - 260		°C	
Middle Temperature	260 - 270		°C	
Front Temperature	270 - 280		°C	
Processing (Melt) Temp	275 - 290		°C	
Mold Temperature	70.0 - 90.0		°C	
Injection Pressure	60.0 - 140		MPa	
Injection Rate	Moderate-Fast			
Back Pressure	0.100 - 0.500		MPa	
Screw Speed	40 - 60		rpm	
Clamp Tonnage	5.0 - 9.0		kN/cm ²	
Injection instructions				
Drying Time (Opened Bag): > 12 hrDrying Time (Unopened Bag): 2 hr				
NOTE				
1.	10 x 4 mm			
2.	12.7 x 3.2 mm			
3.	12.7 x 3.2 mm			

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