

ASTAMID™ MB3SX

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MB3SX is an easy flow, heat stabilised, lubricated injection moulding grade of PA6 designed for fast processing and easier demoulding of parts.

General Information				
Additive	Heat Stabilizer			
	Lubricant			
Features	Fast Molding Cycle			
	Good Flow			
	Good Mold Release			
	Heat Stabilized			
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.13	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.5	--	%	ASTM D955
Water Absorption				ISO 62
23°C, 24 hr	9.5	--	%	
Equilibrium, 23°C, 50% RH	3.1	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	3400	1150	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	85.0	45.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	4.5	25	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	2950	1000	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength ⁵	4.0	--	kJ/m ²	ISO 179
Notched Izod Impact (3.20 mm)	45 J/m	No Break		ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed, 3.20 mm	185	--	°C	

1.8 MPa, Unannealed, 3.20 mm	66.0	--	°C	
CLTE - Flow	8.5E-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	220 to 240		°C	
Middle Temperature	230 to 250		°C	
Front Temperature	240 to 260		°C	
Processing (Melt) Temp	250 to 280		°C	
Mold Temperature	40.0 to 80.0		°C	
Injection Pressure	60.0 to 140		MPa	
Injection Rate	Moderate-Fast			
Back Pressure	0.100 to 0.500		MPa	
Screw Speed	40 to 60		rpm	
Clamp Tonnage	5.0 to 9.0		kN/cm ²	
NOTE				
1.	50 mm/min			
2.	50 mm/min			
3.	5.0 mm/min			
4.	1.3 mm/min			
5.	4 mm			

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