

ASTAMID™ KB3EG5

Polyamide 6
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ KB3EG5 is a flame retardant, low smoke, 25% glass fibre filled Polyamide 6 (PA6) designed for use in applications where a UL94 V-0 flammability rating and high modulus are required.

General Information				
Filler / Reinforcement	Glass Fiber,25% Filler by Weight			
Additive	Flame Retardant			
Features	Flame Retardant			
	High Stiffness			
	Low Smoke Emission			
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.52	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.50	--	%	ASTM D955
Water Absorption (24 hr)	0.40	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (M-Scale)	119	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	8250	5250	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	115	65.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	2.5	4.0	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	7750	3750	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	170	90.0	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact (3.20 mm)	80	120	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	190	140	°C	ASTM D648
CLTE - Flow	6.0E-5	--	cm/cm/°C	ASTM D696
Flammability	Dry	Conditioned	Test Method	
Flame Rating (3.00 mm)	V-0	V-0	UL 94	
Injection	Dry	Unit		

Drying Temperature	75.0 to 85.0	°C
Drying Time	2.0	hr
Rear Temperature	210 to 230	°C
Middle Temperature	220 to 240	°C
Front Temperature	230 to 250	°C
Processing (Melt) Temp	240 to 260	°C
Mold Temperature	80.0 to 100	°C
Injection Pressure	60.0 to 130	MPa
Injection Rate	Moderate-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. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 5.0 mm/min |
| 4. | 2.8 mm/min |
| 5. | 2.8 mm/min |

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