

ASTAMID™ MB3S

Polyamide 6
Marplex Australia Pty. Ltd.

Message:
ASTAMID™ MB3S is an easy flow, heat stabilized injection moulding grade of PA6 designed for fast processing.

General Information				
Additive		Heat Stabilizer		
Features		Fast Molding Cycle		
		Good Flow		
		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)	25	50	%	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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