

ASTAMID™ MA3K

Polyamide 66
Marplex Australia Pty. Ltd.

Message:

ASTAMID™ MA3K is a heat stabilised, easy flow Polyamide 66 grade designed for fast processing.

General Information			
Additive	heat stabilizer		
Features	Fast molding cycle		
	Good liquidity		
	Thermal Stability		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.0	%	ASTM D955
Water Absorption			
24 hr	0.90	%	ASTM D570
Equilibrium, 23°C, 50% RH	2.8	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹ (3.20 mm)	3150	MPa	ASTM D638
Tensile Strength ² (3.20 mm)	85.0	MPa	ASTM D638
Tensile Elongation ³ (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ⁴ (3.20 mm)	3100	MPa	ASTM D790
Flexural Strength ⁵ (3.20 mm)	115	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	55	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	77.0	°C	ASTM D648
CLTE - Flow	7.0E-4	cm/cm/°C	ASTM D696

Flammability	Nominal Value	Test Method	
Flame Rating (1.60 mm)	HB	UL 94	

Injection	Nominal Value	Unit
Drying Temperature	75.0 - 85.0	°C
Drying Time	2.0	hr
Rear Temperature	275 - 285	°C
Middle Temperature	285 - 295	°C
Front Temperature	285 - 295	°C
Processing (Melt) Temp	270 - 290	°C
Mold Temperature	50.0 - 80.0	°C

Injection Pressure	60.0 - 130	MPa
Injection Rate	Moderate	
Back Pressure	0.100 - 0.500	MPa
Screw Speed	40 - 60	rpm
Clamp Tonnage	3.0 - 5.0	kN/cm ²

Injection instructions

Drying Time (Opened Bag): > 12 hr

NOTE

- | | |
|----|------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 5.0 mm/min |
| 4. | 1.3 mm/min |
| 5. | 1.3 mm/min |

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