

### Product Description

Ultramid B3L is an impact-modified, easy flowing injection molding PA6 grade for fast processing.

### Applications

Typical applications include impact-resistant articles such as housings, fittings, small parts and anchors.

PHYSICAL	ASTM Test Method	Property Value
Specific Gravity	D-792	1.1
Mold Shrinkage (1/8" bar, in/in)		0.011
Moisture, %	D-570	
(50% RH)		2.5
(Saturation)		9

MECHANICAL	ASTM Test Method	Dry	Conditioned
Tensile Strength, Yield, MPa (psi)	D-638		
23°C (73°F)		69 (10,000)	-
Elongation, Yield, %	D-638		
23°C (73°F)		4	-
Elongation, Break, %	D-638		
23°C (73°F)		25	-
Flexural Modulus, MPa (psi)	D-790		
23°C (73°F)		2,500 (362,000)	-

IMPACT	ASTM Test Method	Dry	Conditioned
Notched Izod Impact, J/M (ft-lbs/in)	D-256		
-40°C (-40°F)		53 (1.0)	-
23°C (73°F)		134 (2.5)	-

THERMAL	ASTM Test Method	Dry	Conditioned
Melting Point, °C(°F)	D-3418	220 (428)	-
Heat Deflection @ 264 psi (1.8 MPa) °C(°F)	D-648	66 (150)	-
Heat Deflection @ 66 psi (.45 MPa) °C(°F)	D-648	160 (320)	-
Coef. of Linear Thermal Expansion, mm/mm °C (in/in °F)	E-831	0.4 X10-4	-

UL RATINGS	UL Test Method	Property Value
Flammability Rating, 0.4mm	UL94	HB
Relative Temperature Index, 0.4mm	UL746B	
Mechanical w/o Impact, °C		65
Mechanical w/ Impact, °C		65
Electrical, °C		65
Flammability Rating, 0.8mm	UL94	HB
Relative Temperature Index, 0.8mm	UL746B	
Mechanical w/o Impact, °C		65
Mechanical w/ Impact, °C		65
Electrical, °C		65
Flammability Rating, 1.5mm	UL94	HB
Relative Temperature Index, 1.5mm	UL746B	
Mechanical w/o Impact, °C		65
Mechanical w/ Impact, °C		65
Electrical, °C		65
Flammability Rating, 3.0mm	UL94	HB
Relative Temperature Index, 3.0mm	UL746B	
Mechanical w/o Impact, °C		65
Mechanical w/ Impact, °C		65
Electrical, °C		65

ELECTRICAL	ASTM Test Method	Dry	Conditioned
Volume Resistivity, 1.5 mm	D-257	1E13	1E10

### Processing Guidelines

#### Material Handling

Max. Water content: 0.15%

Product is supplied in sealed containers and drying prior to molding is not required. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 80°C (176°F) is recommended. Drying time is dependent on moisture level, however 2-4 hours is generally sufficient. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF representative.

#### Typical Profile

Melt Temperature 240-285°C (464-545°F)

Mold Temperature 65-80°C (149-176°F)

Injection and Packing Pressure 35-125 bar (500-1500 psi)

**Mold Temperatures**

A mold temperature of 65-80°C (149-176°F) is recommended, however temperatures of as low as 10°C (50°F) can be used where applicable.

**Pressures**

Injection pressure controls the filling of the part and should be applied for 90% of ram travel. Packing pressure affects the final part and can be used effectively in controlling sink marks and shrinkage. It should be applied and maintained until the gate area is completely frozen off.

**Fill Rate**

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing.

**Note**

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