

**Product Information**

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# Ultramid® B3WG13 HPX BK00102 Polyamide 6


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**Product Description**

Ultramid B3WG13 HPX BK00102 is a 63% glass reinforced, injection molding, high modulus nylon designed to have high strength and stiffness for metal replacement applications. It also has excellent moldability and outstanding surface appearance.

| PHYSICAL                     | ISO Test Method | Property Value |             |
|------------------------------|-----------------|----------------|-------------|
| Density, g/cm³               | 1183            | 1.74           |             |
| MECHANICAL                   | ISO Test Method | Dry            | Conditioned |
| Tensile Modulus, MPa         | 527             |                |             |
| 23°C                         |                 | 21,400         | 14,700      |
| Tensile stress at break, MPa | 527             |                |             |
| 23°C                         |                 | 225            | 169         |
| Tensile strain at break, %   | 527             |                |             |
| 23°C                         |                 | 2.0            | 3.4         |
| Flexural Strength, MPa       | 178             |                |             |
| 23°C                         |                 | 379            | 285         |
| Flexural Modulus, MPa        | 178             |                |             |
| 23°C                         |                 | 21,000         | 15,500      |
| IMPACT                       | ISO Test Method | Dry            | Conditioned |
| Izod Notched Impact, kJ/m²   | 180             |                |             |
| -40°C                        |                 | 12             | -           |
| 23°C                         |                 | 14             | 17          |
| Charpy Notched, kJ/m²        | 179             |                |             |
| -30°C                        |                 | 13             | -           |
| 23°C                         |                 | 14             | 18          |
| Charpy Unnotched, kJ/m²      | 179             |                |             |
| -30°C                        |                 | 88             | -           |
| 23°C                         |                 | 95             | 104         |
| THERMAL                      | ISO Test Method | Dry            | Conditioned |
| Melting Point, °C            | 3146            | 220            | -           |
| HDT A, °C                    | 75              | 215            | -           |

**Processing Guidelines**
**Material Handling**

Max. Water content: 0.12%

Although Product is supplied in sealed containers, drying is recommended in applications requiring optimum surface aesthetics. 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. Recommended water content for molding is 0.08%-0.12%. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF representative.

**Typical Profile**

Melt Temperature 300-320°C (572-608°F)

Mold Temperature 80-95°C (176-203°F)

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

Rear Zone 275-300°C (527-572°F)

Center Zone 285-310°C (545-590°F)

Front Zone 300-320°C (572-608°F)

Nozzle 300-320°C (572-608°F)

**Mold Temperatures**

This product can be processed over a wide range of mold temperatures; however, for applications where aesthetics are critical, a mold surface temperature of 80-95°C (176-203°F) is required.

**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.

Back pressure can be utilized to provide uniform melt consistency and reduce trapped air and gas. Minimal back pressure should be utilized to prevent glass breakage. recommended to minimize glass fiber breakage.

**Fill Rate**

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing. Surface appearance is directly affected by injection rate.

**Note**

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