

**Product Information**

Feb 2016

# **Ultramid® B3WG6 GPX BK23238** **Polyamide 6**


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**Product Description**

Ultramid B3WG6 GPX BK23238 is a 30% glass fiber reinforced, heat stabilized injection molding PA6 grade for primary use in welded air intake manifolds. This grade has been engineered to provide improved burst pressure strengths with excellent long-term burst strength retention.

**Applications**

Typical applications include automotive manifolds and other powertrain components.

| PHYSICAL                            | ISO Test Method | Property Value |             |
|-------------------------------------|-----------------|----------------|-------------|
| Density, g/cm <sup>3</sup>          | 1183            | 1.35           |             |
| MECHANICAL                          | ISO Test Method | Dry            | Conditioned |
| Tensile Modulus, MPa                | 527             |                |             |
| 23°C                                |                 | 9,600          | -           |
| Tensile stress at break, MPa        | 527             |                |             |
| 23°C                                |                 | 185            | -           |
| Tensile strain at break, %          | 527             |                |             |
| 23°C                                |                 | 3.5            | -           |
| Flexural Strength, MPa              | 178             |                |             |
| 23°C                                |                 | 265            | -           |
| Flexural Modulus, MPa               | 178             |                |             |
| 23°C                                |                 | 8,300          | -           |
| IMPACT                              | ISO Test Method | Dry            | Conditioned |
| Charpy Notched, kJ/m <sup>2</sup>   | 179             |                |             |
| 23°C                                |                 | 13             | -           |
| Charpy Unnotched, kJ/m <sup>2</sup> | 179             |                |             |
| 23°C                                |                 | 95             | -           |
| THERMAL                             | ISO Test Method | Dry            | Conditioned |
| Melting Point, °C                   | 3146            | 220            | -           |
| HDT A, °C                           | 75              | 202            | -           |

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

Max. Water content: 0.15%

Material is supplied in sealed containers and drying prior to molding in a dehumidifying or desiccant dryer is recommended. Drying parameters are dependent upon the actual percentage of moisture in the pellets and typical pre-drying conditions are 2-4 hours at 180F (83C).

Recommended moisture levels for achieving optimum surface qualities and mechanical properties is 0.05% - 0.12%. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet (MSDS), or by contacting your BASF representative.

**Typical Profile**

Melt Temperature 270-290 degC (518-554 degF)

Mold Temperature 80-90 degC (176-194 degF)

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

**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 degC (176-203 degF) is recommended.

**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.

**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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