

Ultramid® A3EG7
PA66-GF35

BASF

Glass fibre reinforced injection moulding grade for machinery components and housings with high stiffness and dimensional stability such as lamp socket housings, heating pumps, flow heaters as well as electrically insulating parts.

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	30 / *	cm ³ /10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.5 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.0 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	11500 / 8500	MPa	ISO 527
Stress at Break	210 / 150	MPa	ISO 527
Strain at Break	3 / 5	%	ISO 527
Tensile Creep Modulus, 1000h	* / 6650	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	95 / 107	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), -30°C Notched	75 / 77	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy), +23°C Notched	14 / 22	kJ/m ²	ISO 179/1eA
Impact Strength (Charpy), -30°C	12 / -	kJ/m ²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	260 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	250 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	260 / *	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	250 / *	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	22 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	93 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB / *	class	UL 94
Thickness tested	1.6 / *	mm	-
UL recognition	yes / *	-	-
Burning Behav. at thickness h	HB / *	class	UL 94
Thickness tested	0.8 / *	mm	-
UL recognition	yes / *	-	-
Oxygen index	24 / *	%	ISO 4589-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	4.3 / 10.1	-	IEC 62631-2-1
Relative permittivity, 1MHz	3.8 / 4.5	-	IEC 62631-2-1
Dissipation Factor, 100Hz	120 / 1570	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	210 / 830	E-4	IEC 62631-2-1
Volume Resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E10	Ohm	IEC 62631-3-2
Electric Strength	39 / 37	kV/mm	IEC 60243-1
Comparative tracking index	- / 550	-	IEC 60112

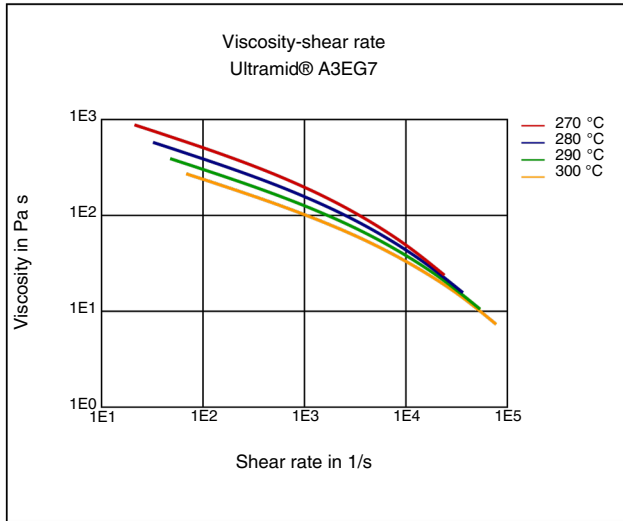
Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	5 / *	% %	Sim. to ISO 62
Humidity absorption	1.6 / *	kg/m	Sim. to ISO 62
Density	1410 / -	³	ISO 1183

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	145 / *	cm ³ /g	ISO 307, 1157, 1628

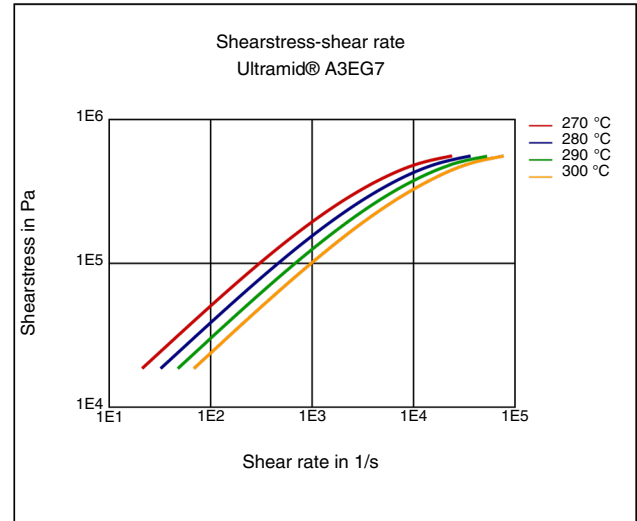
Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 90	°C	-

Diagrams

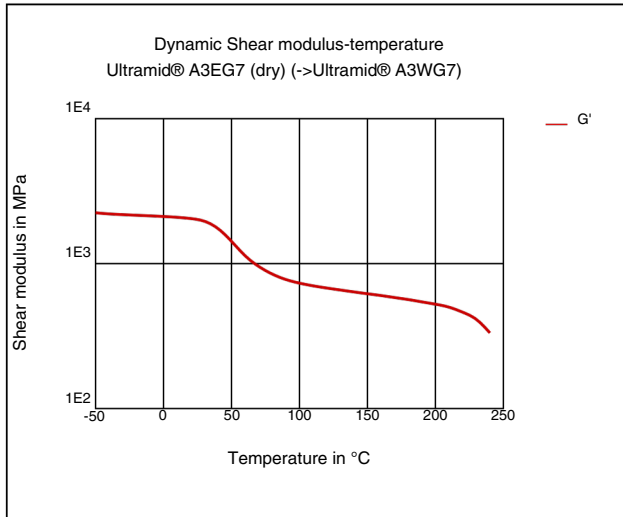
Viscosity-shear rate



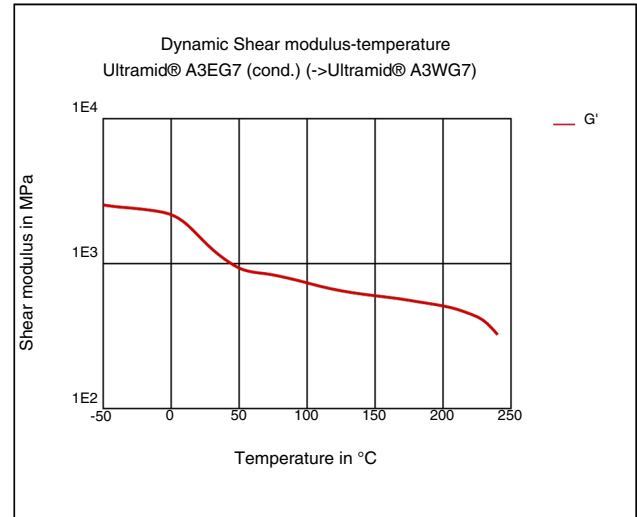
Shearstress-shear rate



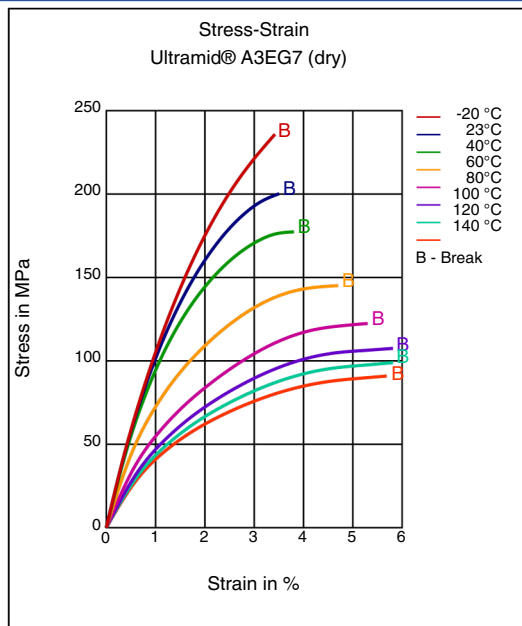
Dynamic Shear modulus-temperature



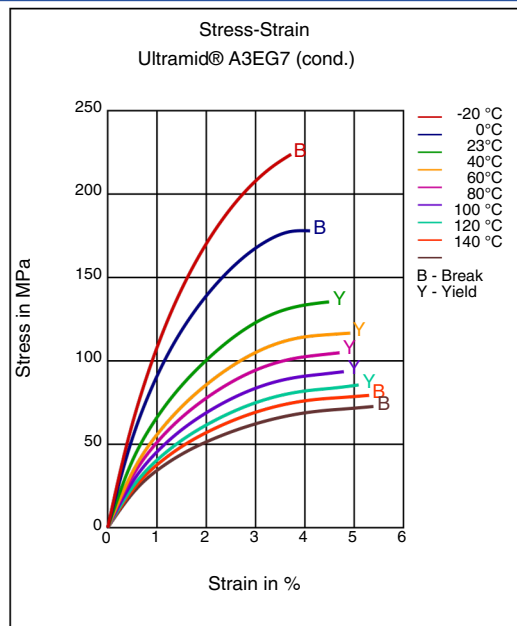
Dynamic Shear modulus-temperature



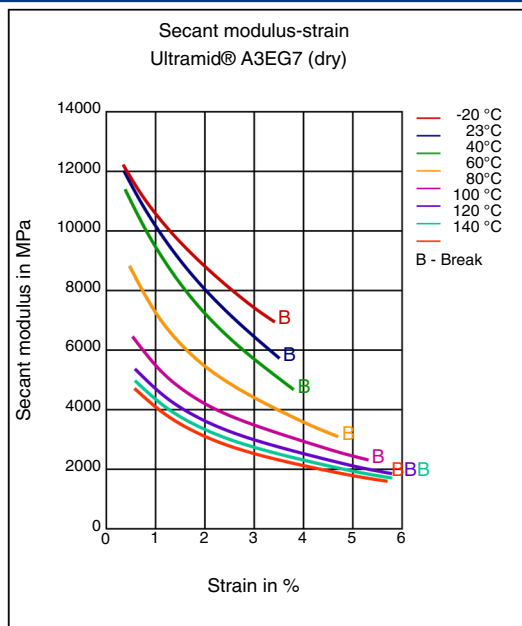
Stress-strain



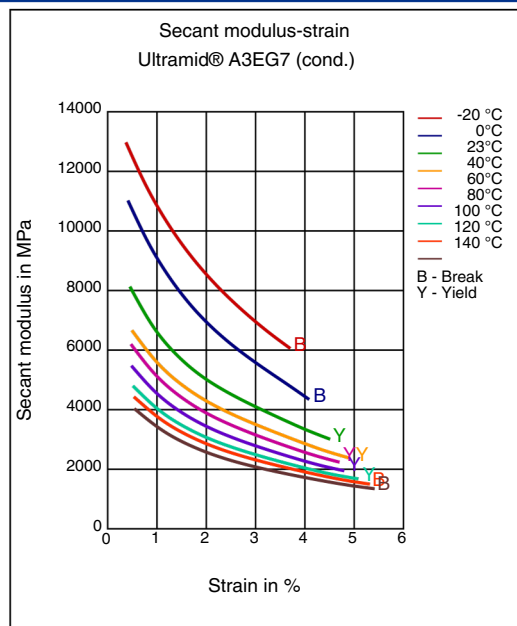
Stress-strain



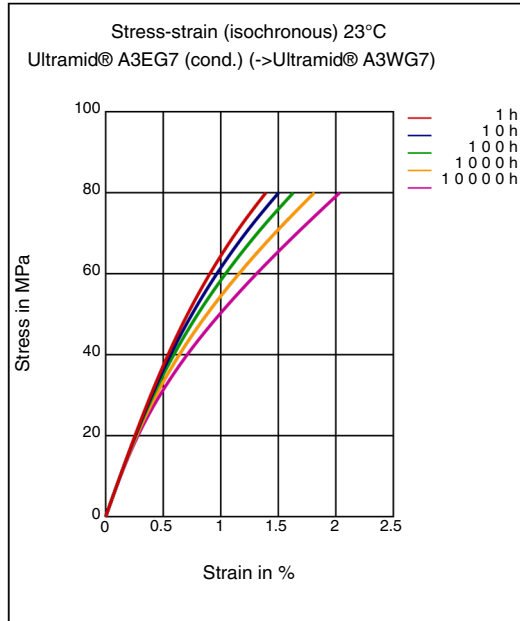
Secant modulus-strain



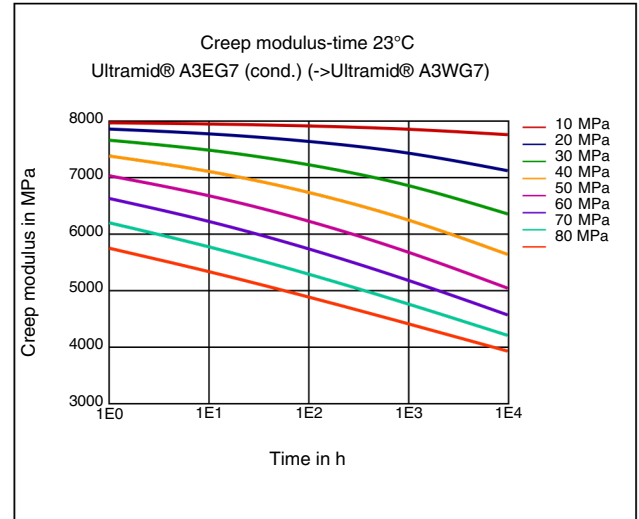
Secant modulus-strain



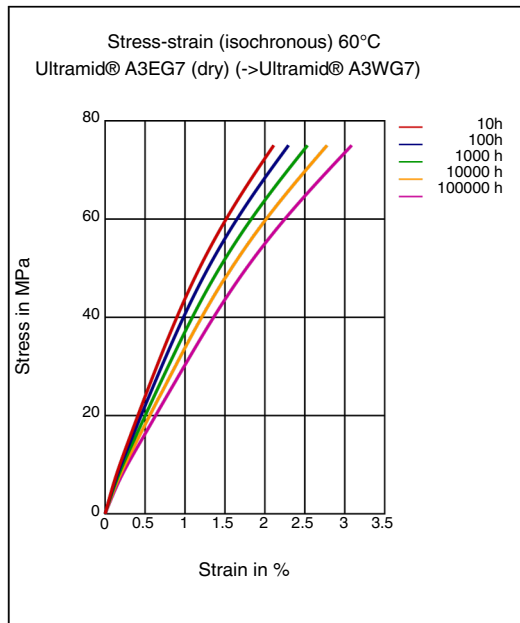
Stress-strain (isochronous) 23°C



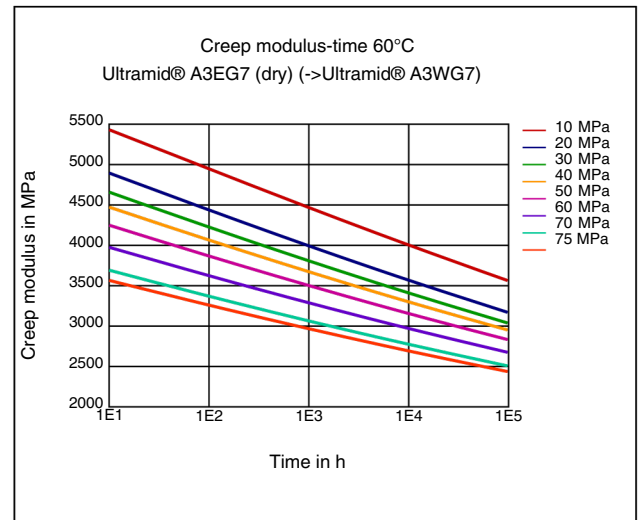
Creep modulus-time 23°C



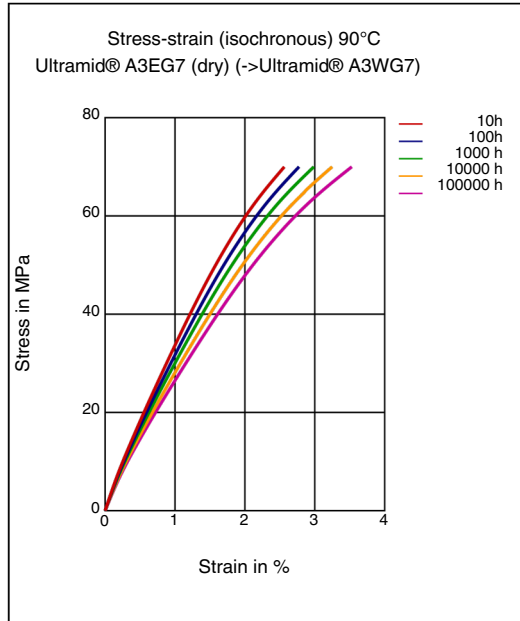
Stress-strain (isochronous) 60°C



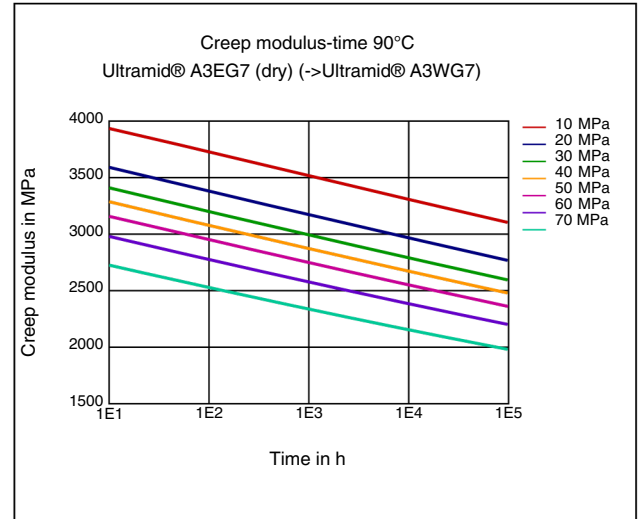
Creep modulus-time 60°C



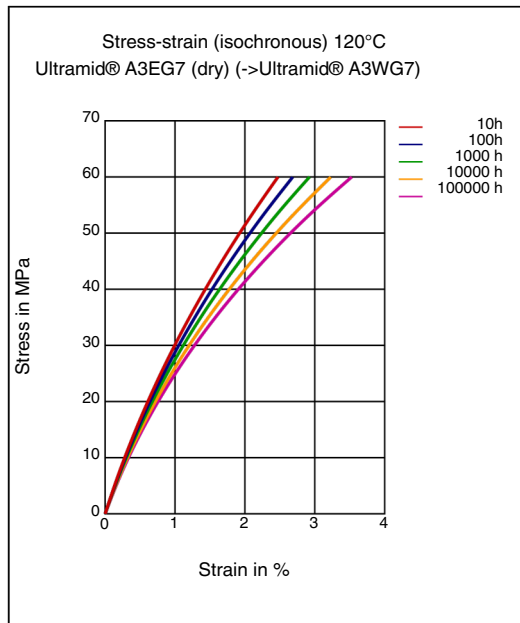
Stress-strain (isochronous) 90°C



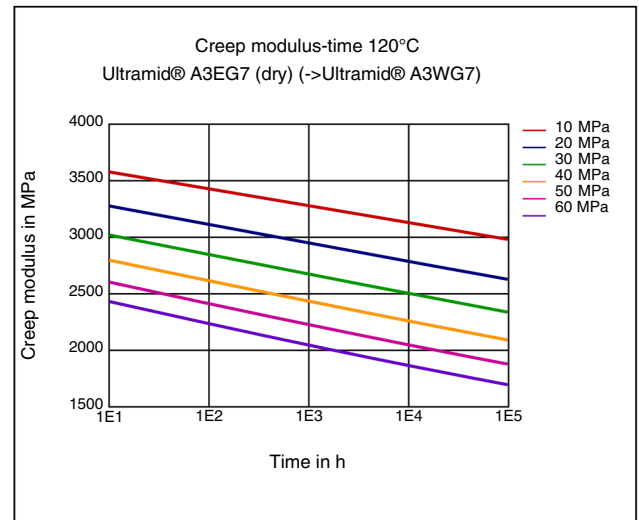
Creep modulus-time 90°C



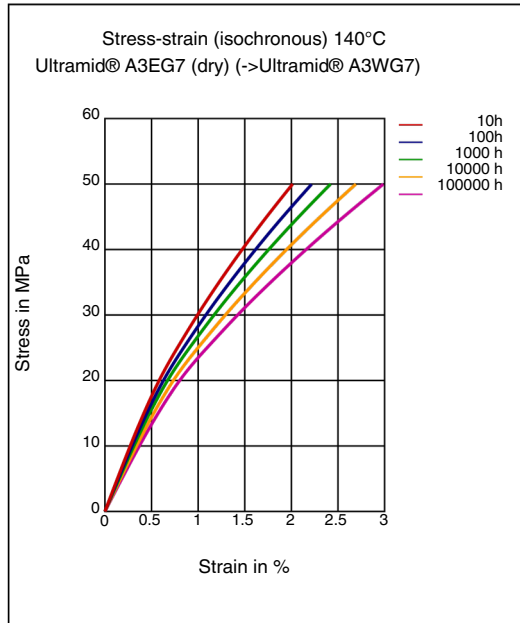
Stress-strain (isochronous) 120°C



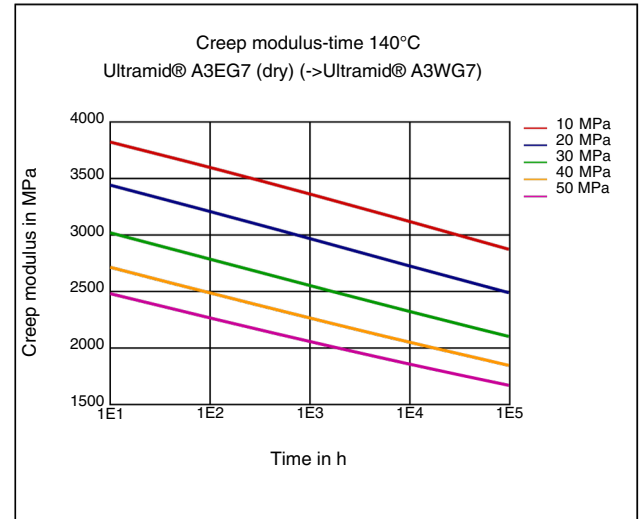
Creep modulus-time 120°C



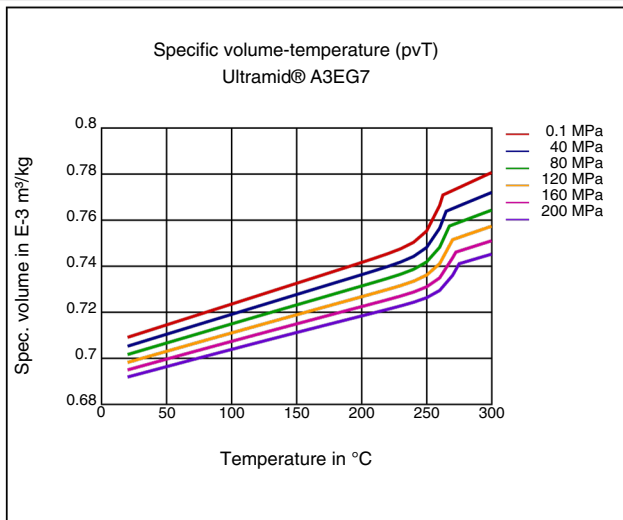
Stress-strain (isochronous) 140°C



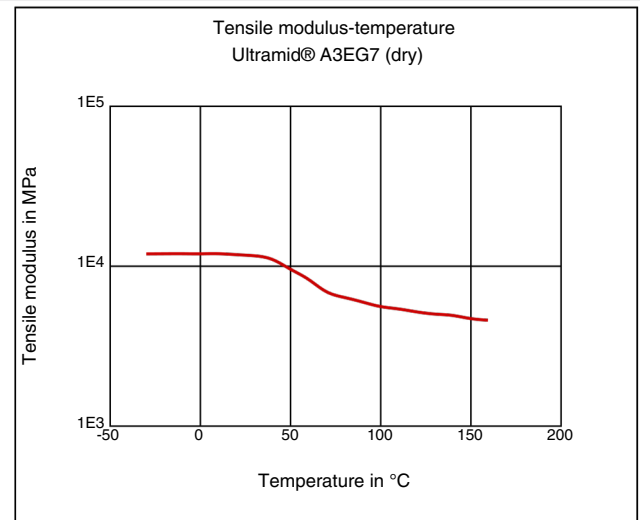
Creep modulus-time 140°C



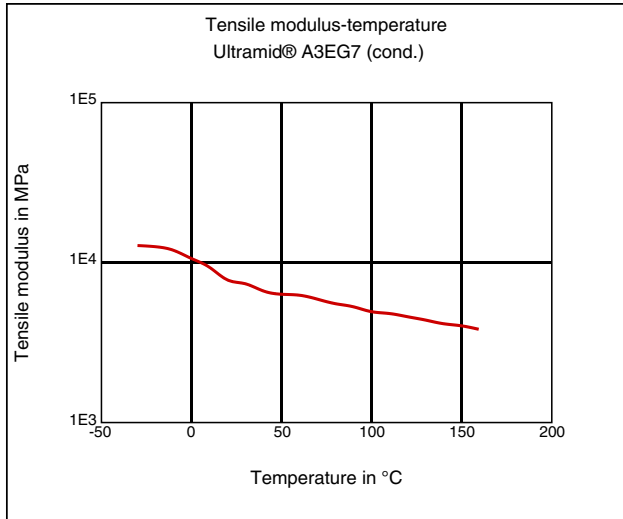
Specific volume-temperature (pvT)



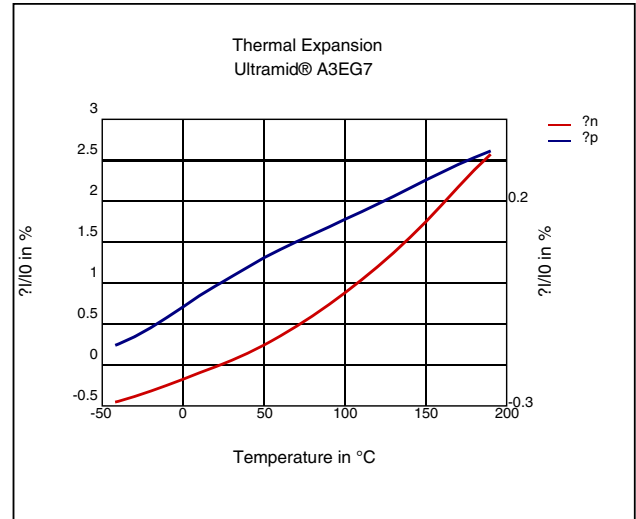
Tensile Modulus-Temperature



Tensile Modulus-Temperature



Coeff. of linear thermal expansion, normal



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Lubricants, Release agent

Special Characteristics

Heat aging stabilized

Injection Molding

PREPROCESSING

Pre/Post-processing, max. allowed water content: .15 %

Pre/Post-processing, Pre-drying, Temperature: 80 °C

Pre/Post-processing, Pre-drying, Time: 4 h

PROCESSING

injection molding, Melt temperature, range: 280 - 300 °C

injection molding, Melt temperature, recommended: 290 °C

injection molding, Mold temperature, range: 80 - 90 °C

injection molding, Mold temperature, recommended: 80 °C

injection molding, Dwell time, thermoplastics: 10 min

Chemical Media Resistance

Acids

- ✓ Acetic Acid (5% by mass) (23°C)
- ✓ Citric Acid solution (10% by mass) (23°C)
- ✓ Lactic Acid (10% by mass) (23°C)
- ✗ Hydrochloric Acid (36% by mass) (23°C)
- ✗ Nitric Acid (40% by mass) (23°C)
- ✗ Sulfuric Acid (38% by mass) (23°C)
- ✗ Sulfuric Acid (5% by mass) (23°C)
- ✗ Chromic Acid solution (40% by mass) (23°C)

Bases

- ✗ Sodium Hydroxide solution (35% by mass) (23°C)
- ✓ Sodium Hydroxide solution (1% by mass) (23°C)

Alcohols

- ✓ Isopropyl alcohol (23°C)
- ✓ Methanol (23°C)
- ✓ Ethanol (23°C)

Hydrocarbons

- ✓ n-Hexane (23°C)
- ✓ Toluene (23°C)
- ✓ iso-Octane (23°C)

Ketones

- ✓ Acetone (23°C)

Ethers

- ✓ Diethyl ether (23°C)

Mineral oils

- ✓ SAE 10W40 multigrade motor oil (23°C)
- ✓ SAE 10W40 multigrade motor oil (130°C)

Standard Fuels

- ✓ Diesel fuel (pref. ISO 1817 Liquid F) (23°C)
- ✗ Diesel fuel (pref. ISO 1817 Liquid F) (>90°C)

Salt solutions

- ✓ Sodium Chloride solution (10% by mass) (23°C)
- ✗ Sodium Hypochlorite solution (10% by mass) (23°C)
- ✗ Zinc Chloride solution (50% by mass) (23°C)

Other

- ✓ Ethyl Acetate (23°C)
- ✗ Hydrogen peroxide (23°C)
- ✗ DOT No. 4 Brake fluid (130°C)
- ✗ Ethylene Glycol (50% by mass) in water (108°C)
- ✓ Water (23°C)

Disclaimer

Liability Exclusion

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