Processing Data Sheet **Ultramid®**

B3U50G6 BK

02/2026

PA6-GF30 FR(53+30)

Product Information

Without halogens flame retardant glass fiber reinforced injection moulding grade for plastic parts in electrical applications. The product provides good mechanical and electrical properties. Due to the halide free stabilization the impact on corrosion is minimized and sensitive electronic components are better protected. In particular optimized for the glow wire requirements of IEC 60335.

Physical form and storage

The product is supplied in the form of granules with a bulk density of approx. 0.7 g/cm³. Standard packs are bag and bulk container (octagonal IBC=intermediate bulk container made from corrugated board with a liner bag). Other packaging materials and shipping in road or rail silo wagons are possible by agreement. The containers should only be opened immediately before processing or drying. To ensure that the delivered product absorbs as little moisture as possible, the containers should be stored in dry rooms and always carefully closed again after partial quantities have been withdrawn. In principle, the product can be stored for a long period of time. Containers stored in cold rooms should be equalized to ambient temperature before opening in order to avoid condensation on the granules. Regardless of the storage conditions, the product should be pre-dried according to our recommendations and the machine should preferably be loaded using a closed conveyor system.

Safety instructions

Provide suitable exhaust ventilation in the area surrounding the melt outlet of processing machines.
Ensure thorough ventilation of work areas.

When incorrectly processing an unpleasant odour can be produced, especially when the recommended processing parameters are exceeded.
Check
- Melt temperature
- Residence time

When there is a strong odour, immediately check processing parameters and ventilate the area well. If necessary decrease processing temperatures or reduce the residence time.

Any short stoppages in production, it is recommended that you inject material into the mould not purge an air shot.
Any molten material drooling from the machine nozzle or hot runner nozzles can self-ignite when in open atmosphere.
Meltcakes on air shall cool down under an exhaust ventilation.

Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.
In order to check the availability of products please contact us or our sales agency.

BASF SE
67056 Ludwigshafen, Germany

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We create chemistry

	Test method	Unit	Values
Properties			
Polymer abbreviation	-	-	**PA6-GF30 FR(53+30)**
Density	ISO 1183	kg/m³	**1500**
Melt volume rate MVR 275 °C/5 kg	ISO 1133	cm³/10min	**35**
Drying			
Moisture, recommended [1)]	-	%	**0.03 - 0.06**
Dryer temperature [2)]	-	°C	**80**
Drying time [3)]	-	h	**4**
Injection molding			
Melt temperature range	-	°C	**240 - 265**
Melt temperature, optimal	-	°C	**260**
Mold temperature range	-	°C	**80 - 90**
Mold temperature, optimal	-	°C	**80**
Residence time, max.	-	min	**5**
Machine Settings			
Temperature hopper throat	-	°C	**80**
Cylinder temperature 1 (feed zone)	-	°C	**245**
Cylinder temperature 2 (compression)	-	°C	**255**
Cylinder temperature 3 (metering-zone, in front of the screw)	-	°C	**260**
Cylinder temperature 4 (nozzle)	-	°C	**260**
Peripheral screw speed	-	m/s	**≤ 0.3**
Shrinkage			
Molding shrinkage (parallel)	ISO 294-4	%	**0.25**
Molding shrinkage (normal)	ISO 294-4	%	**0.80**

Footnotes
1) Excessive drying of the granules may lead to an increase of melt viscosity during processing.
2) Dry air dryer; drying time is dependent on the inital moisture content of the granules, drying temperature and the dew point of the dried air.
3) In case of improper storage (e.g. open packages) drying time may have to be extended.

BASF SE

67056 Ludwigshafen, Germany