

Ultramid® 8202CQ

Polyamide 6

Product Description

Ultramid 8202CQ is a low viscosity, PA6 injection molding homopolymer, possessing a modified crystalline structure for increased property performance and faster cycles.

Applications

Ultramid 8202CQ is generally recommended for applications such as furniture casters, gears, window hardware, end fittings, insulators, bushings, slides, valves, relays, wiring devices, and other electrical components.

PHYSICAL	ASTM Test Method	Property Value	
Specific Gravity	D-792	1.13	
Mold Shrinkage (1/8" bar, in/in)		0.01	
Moisture, %	D-570		
(24 Hour)		1.6	
(50% RH)		2.6	
(Saturation)		9.2	
MECHANICAL	ASTM Test Method	Dry	Conditioned
Tensile Strength, Yield, MPa (psi)	D-638		
-40C (-40F)		137 (19,900)	142 (20,600)
23C (73F)		90 (13,100)	43 (6,240)
80C (176F)		40 (5,800)	-
121C (250F)		25 (3,620)	-
Elongation, Yield, %	D-638		
23C (73F)		4	14
Elongation, Break, %	D-638		
23C (73F)		10	>100
Flexural Modulus, MPa (psi)	D-790		
-40C (-40F)		3,370 (489,000)	4,280 (621,000)
23C (73F)		3,170 (460,000)	970 (141,000)
121C (250F)		385 (55,800)	-
Flexural Strength, MPa (psi)	D-790		
-40C (-40F)		183 (26,500)	168 (24,400)
23C (73F)		110 (16,000)	42 (6,090)
121C (250F)		21 (3,040)	-
Rockwell Hardness, R Scale	D-785	120	-
IMPACT	ASTM Test Method	Dry	Conditioned
Notched Izod Impact, J/M (ft-lbs/in)	D-256		
-40C (-40F)		32 (0.6)	21 (0.4)
23C (73F)		48 (0.9)	160 (3.0)
Drop Weight Impact, ft-lbs, 23C	BASF Drop Weight Impact Test	150	-
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	75 (167)	-
Heat Deflection @ 66 psi (.45 MPa) C(F)	D-648	190 (374)	-
Coef. of Linear Thermal Expansion, mm/mm C (in/in F)	E-831	0.81 X10-4	-

UL RATINGS	UL Test Method	Property Value
Flammability Rating, 1.5mm	UL94	HB
Relative Temperature Index, 1.5mm	UL746B	
Mechanical w/o Impact, C		85
Mechanical w/ Impact, C		75
Electrical, C		125

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 degC (176 degF) is recommended. Drying time is dependent on moisture level, but 2-4 hours is generally sufficient. Further information concerning safe handling procedures can be obtained from the Material Safety Data Sheet. Alternatively, please contact your BASF representative.

Typical Profile

Melt Temperature 240-285 degC (464-545 degF)

Mold Temperature 65-80 degC (149-176 degF)

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

Mold Temperatures

A mold temperature of 65-80 degC (149-176 degF) is recommended, but temperatures of as low as 10 degC (50 degF) 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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