

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	ISO Test Method	Property Value	
Density, g/cm	1183	1.13	
Moisture, %	62		
(24 Hour)		1.6	
(50% RH)		2.6	
(Saturation)		9.2	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
-40C	3,730	-	
23C	3,600	1,220	
80C	675	-	
121C	490	-	
Tensile stress at yield, MPa	527		
-40C	137	142	
23C	86	43	
80C	40	-	
121C	25	-	
Tensile strain at yield, %	527		
23C	4	14	
Nominal strain at break, %	527		
23C	10	>50	
Flexural Strength, MPa	178		
23C	90	29	
Flexural Modulus, MPa	178		
23C	2,800	1,010	
IMPACT	ISO Test Method	Dry	Conditioned
Charpy Notched, kJ/m ²	179		
23C	3.5	-	
Charpy Unnotched, kJ/m ²	179		
23C	N	-	
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	60	-
ELECTRICAL	ISO Test Method	Dry	Conditioned



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Comparative Tracking Index	IEC 60112	450
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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