

Ultramid® 8233G HS BK-106

Polyamide 6



Product Description

Ultramid 8233G HS BK-106 is a heat stabilized, weather resistant, 33% glass fiber reinforced PA6 injection molding compound offering excellent strength, stiffness, high temperature performance and dimensional stability. This balance of engineering properties in combination with excellent processability make it ideal in applications replacing metal, resulting in an overall cost and weight savings.

Applications

Ultramid 8233G HS BK-106 is generally recommended for applications such as weed trimmer components, gears, automotive window hardware, electrical connectors and coil bobbins and all external parts exposed to the environment.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.39	
Moisture, %	62		
(24 Hour)		1.1	
(50% RH)		1.8	
(Saturation)		6.4	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
-40C		10,400	11,500
23C		10,500	7,700
80C		4,660	4,600
121C		4,015	4,200
Tensile stress at break, MPa	527		
-40C		210	215
23C		155	100
80C		85	70
121C		70	60
Tensile strain at break, %	527		
23C		2	6
Flexural Strength, MPa	178		
23C		225	-
Flexural Modulus, MPa	178		
23C		8,700	-
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C		8.5	-
-40C		6	-
Charpy Notched, kJ/m ²	179		
23C		8	-
-30C		5.5	-
Charpy Unnotched, kJ/m ²	179		
23C		55	-



THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	205	-
HDT B, C	75	215	-
ELECTRICAL	ISO Test Method	Dry	Conditioned
Volume Resistivity	IEC 60093	>1E13	-

Processing Guidelines

Material Handling

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 Material Safety Data Sheet (MSDS), or by contacting your BASF representative.

Typical Profile

Melt Temperature 270-295 degC (518-563 degF)
Mold Temperature 80-95 degC (176-203 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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