

Ultramid® 8260 HS BK-102

Polyamide 6



Product Description

Ultramid 8260 HS BK-102 is a heat stabilized, pigmented black, 40% mineral reinforced PA6 injection molding resin. It possesses high stiffness, dimensional stability and heat resistance combined with excellent processability including low warp and resistance to sink-mark formation. It maintains its inherent chemical resistance to greases, oils and hydrocarbons.

Applications

Ultramid 8260 HS BK-102 is generally recommended for applications such as marine hardware, brackets, fittings, bobbins, office furniture, appliance components, and power tool housings.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.49	
Moisture, %	62		
(24 Hour)		1.1	
(50% RH)		1.6	
(Saturation)		5.7	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
-40C	8,310	7,700	
23C	6,400	3,800	
80C	1,360	1,400	
121C	970	1,200	
Tensile stress at break, MPa	527		
-40C	135	135	
23C	85	60	
80C	40	35	
121C	30	27	
Tensile strain at break, %	527		
23C	10	30	
Flexural Strength, MPa	178		
23C	140	50	
Flexural Modulus, MPa	178		
23C	5,200	2,100	
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C	6	-	
Charpy Notched, kJ/m ²	179		
23C	3	-	
Charpy Unnotched, kJ/m ²	179		
23C	130	-	
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	
HDT A, C	75	90	



BASF Corporation
Engineering Plastics
609 Biddle Avenue
Ypsilanti, MI 48192



Ultramid® 8260 HS BK-102

BASF
The Chemical Company

HDT B, C	75	190	-
ELECTRICAL	ISO Test Method	Dry	Conditioned
Volume Resistivity	IEC 60093	>1E13	-
UL RATINGS	UL Test Method	Property Value	
Flammability Rating, 1.5mm	UL94	HB	
Relative Temperature Index, 1.5mm	UL746B		
Mechanical w/o Impact, C		65	
Mechanical w/ Impact, C		65	
Electrical, C		65	

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

Although all statements and information in this publication are believed to be accurate and reliable, they are presented gratis and for guidance only, and risks and liability for results obtained by use of the products or application of the suggestions described are assumed by the user. NO WARRANTIES OF ANY KIND, EITHER EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, ARE MADE REGARDING PRODUCTS DESCRIBED OR DESIGNS, DATA OR INFORMATION SET FORTH. Statements or suggestions concerning possible use of the products are made without representation or warranty that any such use is free of patent infringement and are not recommendations to infringe any patent. The user should not assume that toxicity data and safety measures are indicated or that other measures may not be required.



BASF Corporation
Engineering Plastics
609 Biddle Avenue
Ypsilanti, MI 48192

