

Ultramid® 8262G HS BK-102

Polyamide 6



Product Description

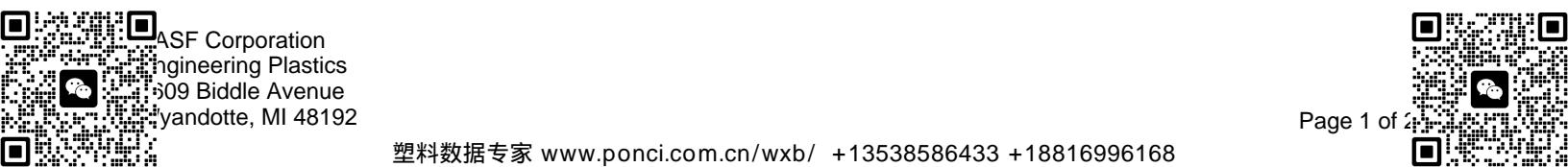
Ultramid 8262G HS BK-102 is a heat stabilized, pigmented black, 20% glass and mineral reinforced PA6 injection molding compound resulting in a balance of engineering properties with excellent dimensional stability, low warp and good resistance to sink mark formation.

Applications

Ultramid 8262G HS BK-102 is generally recommended for applications such as automotive housings, brackets, hubs, shrouds and roller bearings.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm ³	1183	1.29	
Moisture, %	62		
(24 Hour)		1.3	
(50% RH)		2.2	
(Saturation)		7.9	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		5,200	
Tensile stress at break, MPa	527		
23C		100	
Tensile strain at break, %	527		
23C		3	
Flexural Modulus, MPa	178		
23C		4,200	
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C		4	
-40C		3	
Charpy Notched, kJ/m ²	179		
23C		3	
-30C		3	
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	
HDT A, C	75	163	
HDT B, C	75	211	
UL RATINGS	UL Test Method	Property Value	
Flammability Rating, 1.5mm	UL94	HB	
Relative Temperature Index, 1.5mm	UL746B		
Mechanical w/o Impact, C		105	
Mechanical w/ Impact, C		105	
Electrical, C		105	

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
Yandotte, MI 48192

