

# Ultramid® 8351 HS BK-102

## Polyamide 6



### Product Description

Ultramid 8351 HS BK-102 is a heat stabilized, pigmented black, impact modified type 6 nylon graft copolymer developed for injection molding applications requiring a high level of toughness combined with a moderate flexibility and faster cycles. Excellent thermal and chemical resistance properties provided by the nylon backbone. It demonstrates the highest impact performance within the Ultramid copolymer product line while maintaining an excellent balance of strength and stiffness. Excellent chemical resistance to greases, oils and hydrocarbons.

### Applications

Ultramid 8351 HS BK-102 is generally recommended for applications such as spray gun and power tool handles, trim clips and fasteners, wall anchors and automotive roof clips rack components.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.07	
Moisture, %	62		
(24 Hour)		1.1	
(50% RH)		1.9	
(Saturation)		6.7	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		1,800	-
Tensile stress at yield, MPa	527		
23C		49	-
Tensile strain at yield, %	527		
23C		5	-
Nominal strain at break, %	527		
23C		>50	-
Flexural Strength, MPa	178		
23C		53	-
Flexural Modulus, MPa	178		
23C		1,500	-
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m <sup>2</sup>	180		
23C		N	-
-40C		18	-
Charpy Notched, kJ/m <sup>2</sup>	179		
23C		92	-
Charpy Unnotched, kJ/m <sup>2</sup>	179		
23C		N	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	49	-
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		105
Mechanical w/ Impact, C		105
Electrical, C		105

## Processing Guidelines

### Material Handling

Max. Water content: 0.2%

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 240-270 degC (464-518 degF)

Mold Temperature 80-95 degC (176-203 degF)

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

### Mold Temperatures

A mold temperature of 80-95 degC (176-203 degF) is recommended, but temperatures of 10-95 degC (50-203 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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