

Ultramid® B3U Q721

Polyamide 6



Product Description

Ultramid B3U Q721 is an injection molding grade, flame-retardant, free from halogen and phosphorus, and UL94 V0 approved. Technical molded parts are used for electrical engineering.

PHYSICAL	ASTM Test Method	Property Value	
Specific Gravity	D-792	1.17	
Mold Shrinkage (1/8" bar, in/in)		0.008	
Moisture, %	D-570		
(50% RH)		2.5	
(Saturation)		0.10	
MECHANICAL	ASTM Test Method	Dry	Conditioned
Tensile Strength, Yield, MPa (psi)	D-638		
23C (73F)		83 (12,000)	-
Elongation, Yield, %	D-638		
23C (73F)		5	-
Elongation, Break, %	D-638		
23C (73F)		50	-
Flexural Modulus, MPa (psi)	D-790		
23C (73F)		3,000 (435,000)	-
IMPACT	ASTM Test Method	Dry	Conditioned
Notched Izod Impact, J/M (ft-lbs/in)	D-256		
-40C (-40F)		32 (0.6)	-
23C (73F)		43 (0.8)	-
THERMAL	ASTM Test Method	Dry	Conditioned
Melting Point, C(F)	D-3418	220 (428)	-
Heat Deflection @ 264 psi (1.8 MPa) C(F)	D-648	91 (195)	-
Heat Deflection @ 66 psi (.45 MPa) C(F)	D-648	224 (435)	-
Coef. of Linear Thermal Expansion, mm/mm C (in/in F)	E-831	0.4 X10-4	-
ELECTRICAL	ASTM Test Method	Dry	Conditioned
Volume Resistivity, 1.5 mm	D-257	1E13	1E10

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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