

Ultramid® A3L BK7793 **Polyamide 66**

Product Description

Ultramid A3L BK7793 is an impact modified, heat stabilized polyamide 66 for injection molding. This grade has excellent surface appearance and was designed to offer exceptional scratch and mar resistance.

Applications

Ultramid A3L BK7793 can be used in automotive interior applications such as instrument panel bezels and door bezels.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.22	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		2,500	-
Tensile stress at yield, MPa	527		
23C		55	-
Tensile strain at yield, %	527		
23C		2.8	-
Nominal strain at break, %	527		
23C		5.2	-
Flexural Modulus, MPa	178		
23C		2,360	-
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C		11.3	-
-40C		7.8	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	257	-
HDT A, C	75	65	-

Processing Guidelines

Material Handling

Nylon 66 materials must be properly dried in order to provide parts with optimum strength and toughness. Nylon 66 materials are hygroscopic and will become degraded by excessive moisture during the injection molding process. For unopened bag/box, dry at 60 degC (140 degF) for 1-2 hours. For material exposed to the atmosphere, if additional drying is needed, dry at 66 degC (150 degF) or until the moisture level is between 0.04 - 0.20%.

Typical Profile

Melt Temperature: 288-305 degC (550-581 degF)

Mold Temperature: 60-100 degC (140-212 degF)

Injection Pressure: 35-125 MPa (5000-18000 psi)

Back Pressure: 0-0.35 MPa (0-50 psi)

Screw RPM 40-80



Screw Compression Ratio:3:1-4:1

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 60-100 degC (140-212 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.

Fill Rate

Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing.

Note

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