

Ultramid® A3Z HP UV

Polyamide 66



Product Description

Ultramid A3Z HP UV is an impact modified PA66 containing heat and ultraviolet light stabilizers. Designed for maximum toughness at low temperatures, Ultramid A3Z HP UV offers a unique combination of impact performance and excellent processability.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.08	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile stress at yield, MPa	527	46	-
23C			
Nominal strain at break, %	527	50	-
23C			
Flexural Modulus, MPa	178	1,703	-
23C			
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180	83	-
23C			
-40C		22	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	258	-
HDT A, C	75	63	-

Processing Guidelines

Material Handling

Max. Water content: 0.20%

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 280-304 degC (536-579 degF)

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

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

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

Screw Speed 40-80 rpm

Screw Compression Ratio 3:1 to 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.



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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.

Note

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