

Ultraform® N2720 M63 AT
POM-MD30

BASF

Mineral-reinforced material for low-warpage moldings with high stiffness, strength and hardness.

Abbreviated designation according to ISO 1043: POM-MD30
Designation according to ISO 29988-POM-K,MD30,M-GNR,2-3

Rheological properties	Value	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	3.8	cm³/10min	ISO 1133
Temperature	190	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	1.2	%	ISO 294-4, 2577
Molding shrinkage, normal	1.5	%	ISO 294-4, 2577

Mechanical Properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	7000	MPa	ISO 527
Yield stress	75	MPa	ISO 527
Yield strain	5	%	ISO 527
Nominal strain at break	6	%	ISO 527
Tensile Creep Modulus, 1h	4100	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	2750	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	55	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	55	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	3.5	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	3	kJ/m²	ISO 179/1eA

Thermal Properties	Value	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	167	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	140	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	160	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	155	°C	ISO 306
Coeff. of Linear Therm. Expansion, parallel	45	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	HB	class	UL 94
Thickness tested	1.6	mm	-
UL recognition	yes	-	-
Burning Behav. at thickness h	HB	class	UL 94
Thickness tested	0.8	mm	-

Electrical Properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	4	-	IEC 62631-2-1
Relative permittivity, 1MHz	4.2	-	IEC 62631-2-1
Dissipation Factor, 100Hz	70	E-4	IEC 62631-2-1
Dissipation Factor, 1MHz	50	E-4	IEC 62631-2-1
Volume Resistivity	1E10	Ohm*m	IEC 62631-3-1
Surface Resistivity	1E14	Ohm	IEC 62631-3-2
Electric Strength	43	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112

Other Properties	Value	Unit	Test Standard
ISO Data			
Water Absorption	0.9	%	Sim. to ISO 62
Humidity absorption	0.15	%	Sim. to ISO 62
Density	1650	kg/m³	ISO 1183

Rheological calculation properties	Value	Unit	Test Standard
ISO Data			
Ejection temperature	125	°C	-

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	200	°C	ISO 294
Injection Molding, mold temperature	90	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	3	h	-
Processing humidity	≤0.2	%	-
Melt temperature	190 - 220	°C	-
Mold temperature	60 - 120	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Features

Copolymer

Injection Molding

PREPROCESSING

Pre/Post-processing, max. allowed water content: .2 %
Pre/Post-processing, Pre-drying, Temperature: 100 °C
Pre/Post-processing, Pre-drying, Time: 3 h

PROCESSING

injection molding, Melt temperature, range: 190 - 220 °C
injection molding, Melt temperature, recommended: 210 °C
injection molding, Mold temperature, range: 60 - 120 °C
injection molding, Mold temperature, recommended: 100 °C
injection molding, Dwell time, thermoplastics: 10 min

Processing

Usual single-flighted three-section screws with an effective screw length of at least 15 D, better 20 - 23 D are suitable for the injection molding of Ultraform.

Pretreatment

Granules or pellets in original packaging can be processed without any special pretreatment. Granules or pellets which have become moist due to prolonged or incorrect storage (e.g. by formation of condensed water) must be dried in dehumidifying or recirculating air dryers for approx. 3 hours at about 100 - 110 °C. The moisture content should not exceed 0.2 %.

Postprocessing

If parts were produced at a comparatively low mold temperature (e.g. in order to obtain short cycle times) and must not change their geometry in use thermal postprocessing inducing dimensional changes by postcrystallization may be necessary. In such cases parts should be stored in an oven with recirculated air at temperatures of 100 - 130 °C until dimensions don't change significantly any further. The time needed for this has to be determined experimentally.

Disclaimer

Liability Exclusion

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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