

**Product Information**

Oct 2016

# **Ultramid® 66 H2 G/35-V0KB1 BK3324** **Polyamide 66**


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**Product Description**

Ultramid 66 H2 G/35-V0KB1 BK3324 is a 35% glass reinforced, heat stabilized, pigmented black injection molding PA66. It's a self-extinguishing V-0, based on red phosphorous. It has good flowability and mechanical properties. It offers high rigidity and excellent electrical properties.

| PHYSICAL                           | ISO Test Method | Property Value |             |
|------------------------------------|-----------------|----------------|-------------|
| Density, g/cm³                     | 1183            | 1.45           |             |
| MECHANICAL                         | ISO Test Method | Dry            | Conditioned |
| Tensile Modulus, MPa               | 527             |                |             |
| 23°C                               |                 | 11,450         | -           |
| Tensile stress at break, MPa       | 527             |                |             |
| 23°C                               |                 | 180            | -           |
| Tensile strain at break, %         | 527             |                |             |
| 23°C                               |                 | 2.5            | -           |
| Flexural Modulus, MPa              | 178             |                |             |
| 23°C                               |                 | 10,500         | -           |
| IMPACT                             | ISO Test Method | Dry            | Conditioned |
| Izod Notched Impact, kJ/m²         | 180             |                |             |
| -40°C                              |                 | 9.4            | -           |
| 23°C                               |                 | 11.3           | -           |
| Charpy Notched, kJ/m²              | 179             |                |             |
| -30°C                              |                 | 9.8            | -           |
| 23°C                               |                 | 11.5           | -           |
| THERMAL                            | ISO Test Method | Dry            | Conditioned |
| Melting Point, °C                  | 3146            | 260            | -           |
| HDT A, °C                          | 75              | 237            | -           |
| UL RATINGS                         | UL Test Method  | Property Value |             |
| Flammability Rating, 0.81mm        | UL94            | HB             |             |
| Relative Temperature Index, 0.81mm | UL746B          |                |             |
| Mechanical w/o Impact, °C          |                 | 150            |             |
| Mechanical w/ Impact, °C           |                 | 115            |             |
| Electrical, °C                     |                 | 130            |             |
| Flammability Rating, 1.5mm         | UL94            | V-0,5VA        |             |
| Relative Temperature Index, 1.5mm  | UL746B          |                |             |
| Mechanical w/o Impact, °C          |                 | 150            |             |
| Mechanical w/ Impact, °C           |                 | 115            |             |
| Electrical, °C                     |                 | 130            |             |
| Flammability Rating, 3.0mm         | UL94            | V-0,5VA        |             |
| Relative Temperature Index, 3.0mm  | UL746B          |                |             |
| Mechanical w/o Impact, °C          |                 | 150            |             |
| Mechanical w/ Impact, °C           |                 | 115            |             |
| Electrical, °C                     |                 | 130            |             |

**Processing Guidelines**
**Material Handling**

Max. Water content: 0.05%

Special handling and safety precautions must be used when processing this grade of material. Please contact your BASF Technical Service Representative for details. Product is supplied in moisture barrier packaging. However, further drying is typically required. A dehumidifying or desiccant dryer operating at 80°C (176°F) is recommended. Drying time is dependent on moisture level, however 2-4 hours is generally sufficient. Further information concerning safe handling procedures can be obtained from the Safety Data Sheet. Alternatively, please contact your BASF Technical Service representative.

**Typical Profile**

Melt Temperature 285-300°C (545-572°F)

Mold Temperature 80-90°C (176-194°F)

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

**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 80-95°C (176-203°F) is required.

**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.

Back pressure can be utilized to provide uniform melt consistency and reduce trapped air and gas. Minimal back pressure should be utilized to prevent glass breakage.

**Fill Rate**

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

affected by injection rate.

**Note**

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