

Product Information

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Ultramid® 8350 HS BK102 **Polyamide 6**


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Product Description

Ultramid 8350 HS BK102 is a type 6, black pigmented, impact modified graft copolymer developed for extrusion, tubing, and jacketing applications requiring a high level of toughness combined with a moderate level of flexibility.

Applications

Ultramid 8350 HS BK102 is generally recommended for applications such as automotive vacuum tubing, cable jacketing, and high pressure and hydraulic hoses.

PHYSICAL	ASTM Test Method	Property Value	
Specific Gravity	D-792	1.07	
Mold Shrinkage (1/8" bar, in/in)		0.014	
Moisture, %	D-570		
(24 Hour)		1.1	
(50% RH)		1.9	
(Saturation)		6.7	
MECHANICAL	ASTM Test Method	Dry	Conditioned
Tensile Strength, Yield, MPa (psi)	D-638		
23°C (73°F)		55 (7,970)	32 (4,640)
Elongation, Yield, %	D-638		
23°C (73°F)		5	9
Elongation, Break, %	D-638		
23°C (73°F)		>100	>100
Flexural Modulus, MPa (psi)	D-790		
23°C (73°F)		1,890 (274,000)	-
Flexural Strength, MPa (psi)	D-790		
23°C (73°F)		65 (9,430)	-
Rockwell Hardness, R Scale	D-785	78	-
IMPACT	ASTM Test Method	Dry	Conditioned
Notched Izod Impact, J/M (ft-lbs/in)	D-256		
23°C (73°F)		NB	-
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	56 (132)	-
Coef. of Linear Thermal Expansion, mm/mm °C (in/in °F)	E-831	1.06 X10-4	-
UL RATINGS	UL Test Method	Property Value	
Flammability Rating, 1.5mm	UL94	HB	
Relative Temperature Index, 1.5mm	UL746B		
Mechanical w/o Impact, °C		65	
Mechanical w/ Impact, °C		65	
Electrical, °C		65	
Flammability Rating, 3.0mm	UL94	HB	
Relative Temperature Index, 3.0mm	UL746B		
Mechanical w/o Impact, °C		65	
Mechanical w/ Impact, °C		65	
Electrical, °C		65	
ELECTRICAL	ASTM Test Method	Dry	Conditioned
Volume Resistivity, 1.5 mm	D-257	>1E13	-

Processing Guidelines
Material Handling

Max. Water content: 0.1%

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°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 representative.

Typical Profile

Melt Temperature 240-250°C (464-482°F)

Typical Barrel Profile (°C):

Rear 245-260°C (473-500°F)
Middle 240-255°C (464-491°F)
Front 240-250°C (464-482°F)

Head 225-245°C (437-473°F)

Flange 225-240°C (437-464°F)
Die 225-240°C (437-464°F)

Screw Parameters

Metering Section	40%
Transition Section	6 to 7 flights
Feed Section	balance of screw length
Compression Ratio	3.5:1 to 4.0:1
L/D Ratio	20:1 to 24:1

Tooling & Sizing

Die to Finished Tube dia. 1.5-2.0:1

Selection of pin and die size will be dependent on the material viscosity. In general, the ratio of die size to finished tube diameter is about 1.5-2.0:1. The mandrel (pin) size is determined the same way in relation to the inner tube diameter.

Free (open tank) extrusion is recommended when producing tube diameters 1 cm and below. For larger diameters, a differential pressure vacuum tank is recommended.

Tooling draw ratio is generally higher with free extrusion versus sizing, however will depend on melt viscosity. The vacuum sizer entrance should be about 3-9% larger than the finished tube outer diameter. Selection will depend on melt viscosity and die swell of the extrudate.

Quenching

For diameters less than or equal to 1 cm (.39") O.D., open tank quenching with normal tap water is suggested. Depending upon line speed, quenching distance can vary from 7.5 to 12 meters (24.6-39.4 feet). A short air gap (die to quench water) is recommended for both tubing and cable jacketing for best flexibility.

Note

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BASF Corporation
Engineering Plastics
1609 Biddle Avenue
Wyandotte, MI 48192

General Information: 800-BC-RESIN
Technical Assistance: 800-527-TECH (734-324-5150)
Web address: <http://www.plasticsportal.com/usa>

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