

**Preliminary
Datasheet****Ultramid®****T KR 4355 G8 FC bk 23262**

11/2014

PA6T/6-GF40**Product description**

The BASF Ultramid® FC (Food Contact) grades enable the industry to develop products for food contact applications which are in compliance with multiple regional food contact regulations including FDA, European Food Contact (EU) Nr. 11/2011 and GMP (EC) n°2023/2006.

Additional food contact compliances may also be available. Please contact your local representative or plastics safety (E-Mail: plastics.safety@basf.com, Fax: +49 621-60-93253).

Physical form and storage

The product is supplied extensively dry in moisture-proof packaging in the form of cylindrical or flat pellets. Its bulk density is about 0,7g/cm³. Standard packs are the special 25kg bag and the 1000kg bulk container (octagonal IBC= intermediate bulk container made from corrugated board with a liner bag). Subject to agreement other forms of packaging and shipment in tankers by road or rail are also possible. All containers are tightly sealed and should be opened only immediately prior to processing. To ensure that the material delivered cannot absorb moisture from the air the containers must be stored in dry rooms and always carefully sealed again after portions of material have been withdrawn. The product can be kept indefinitely in the undamaged bags. Experience has shown that product supplied in IBCs can be stored for about 3 months without any adverse effects on processing properties due to moisture absorption. Containers stored in cold rooms should be allowed to equilibrate to normal temperature so that no condensation forms on the pellets.

Product safety

In case processing is done under conditions as recommended (cf. processing data sheet) melts are thermally stable and do not generate hazards by molecular degradation or the evolution of gases and vapors. Like all thermoplastic polymers the product decomposes on exposure to excessive thermal load, e.g. when it is overheated or as a result of cleaning by burning off. Further information is available from the safety data sheet.

Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed. In order to check the availability of products please contact us or our sales agency.

BASF SE
67056 Ludwigshafen, Germany

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Preliminary Datasheet ³⁾

Typical values for uncoloured product at 23 °C ¹⁾	Test method	Unit	Values ²⁾
Properties			
Polymer abbreviation	-	-	PA6T/6-GF40
Density	ISO 1183	kg/m ³	1500
Colour; black (bk), uncoloured (un), coloured (co), transparent (tr)	-		bk
Processing			
Melting temperature, DSC	ISO 11357-1/-3	°C	294
Melt temperature, injection moulding/extrusion	-	°C	310 - 330
Mould temperature, injection moulding	-	°C	80 - 120
Moulding shrinkage, constrained ⁴⁾	-	%	0.45
Molding shrinkage (parallel)	ISO 2577, 294-4	%	0.30
Molding shrinkage (normal)	ISO 2577, 294-4	%	0.90
Mechanical properties			
			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	13500 / -
Stress at break	ISO 527-1/-2	MPa	230 / -
Strain at break	ISO 527-1/-2	%	2.5 / -
Charpy unnotched impact strength (23°C)	ISO 179/1eU	kJ/m ²	80 / -
Charpy notched impact strength (23°C)	ISO 179/1eA	kJ/m ²	9 / -
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	250
Max. service temperature (short cycle operation)	-	°C	260

Footnotes

1) If product name or properties don't state otherwise.

2) The asterisk symbol "*" signifies inapplicable properties.

3) The typical values of preliminary datasheets are not statistically firm.

4) Test box with central gating, dimensions of base (107*47*1,5) mm, processing condition: TM = 320°C (unreinforced) or 330°C (reinforced), TW = 80°C

BASF SE

67056 Ludwigshafen, Germany