

#### Product description

Ultramid® 1021GF6 Bright is a polyamide 6, reinforced with 30% of glass fiber, for injection moulding. This grade offers good mechanical properties.

#### Injection Notes

The material is supplied in airtight bags, ready for use. In case that the virgin material has absorbed moisture, it must be dried with a dehumidified air drying equipment, dew point mini -20°C. Recommended time 2-4h

Injection Advice:

- For reinforced polyamides, BASF SE recommends the use of steel with a high content of carbon, and purified for polishing, to avoid or limit the abrasion. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (DIN Norm) or X160CrMoV12 (EN Norm) - 1.2601 /1.2379 (DIN Norm). In the case of high requirements on surface quality a mould temperature of up to 120°C can be considered.
- The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design.

#### Disclaimer

The information contained in this document is given in good faith based on our current knowledge. It is only an indication and it is in no way binding. This information must on no account be used as a substitute for necessary prior tests which alone can ensure that a product is suitable for a given use. ANY WARRANTY OF PRODUCT PERFORMANCE, MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE IS EXPRESSLY EXCLUDED. Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorizations. Users are requested to check that they are in possession of the latest version of this document, and BASF SE is at their disposal to supply any additional information.

#### Safety Information

Detailed information regarding safety are available on the safety data sheet (MSDS). MSDS is sent with the first material order or available by contacting our customer services

#### Regulations Compliance

This product is not intended to be used for the following regulated market: food contact, drinking water, toys, cosmetics or medical devices.

#### Customer Services

Our customer services are not only concerned with manufacturing and supply of Engineering Plastics products. We are available to assist our customers in finding technical solutions that meet their requirements. Specific support is in particular offered on:

- Material selection
- Material testing
- Parts design advice, training for design engineers
- Part testing
- Design simulation
- Processing through different technologies
- Assembly and post-processing technology expertise
- Parts optimization through Computer Aided Design



## Product Information

Typical values for uncoloured product at 23 °C <sup>1)</sup>	Test method	Unit	Values <sup>2)</sup>
<b>General Properties</b>			
Asia Pacific	-	-	+
Processing: Injection moulding (M), Extrusion (E), Blow moulding (B)	-	-	M
Colour: black (bk), uncoloured (un), coloured (co), transparent (tr)	-	-	bk
Pellets	-	-	+
<b>Physical</b>			
Water absorption, 24 h in water, 23 °C	ISO 62	%	0.95
Water absorption, equilibrium in water at 23°C	similar to ISO 62	%	1.4
Moisture absorption, equilibrium 23°C/50% r.h	similar to ISO 62	%	2.20
Density	ISO 1183	kg/m <sup>3</sup>	1360 / -
<b>Mechanical properties</b>			
			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	9600 / 6000
Tensile stress at yield, 2 in/min (ASTM)	ASTM D 638	MPa	175 / -
Stress at break	ISO 527-1/-2	MPa	175 / -
Yield strain, 50 mm/min	ISO 527-1/-2	%	3.4 / -
Strain at break	ISO 527-1/-2	%	3.4 / -
Tensile elongation at break, 2 in/min (ASTM)	ASTM D 638	%	3.5 / -
Flexural modulus	ISO 178	MPa	8700 / 5400
Flexural modulus (ASTM)	ASTM D 790	MPa	8900 / -
Flexural strength (ASTM)	ASTM D 790	MPa	260 / 100
Charpy impact strength ISO 179-1eU (23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	80 / 75
Izod notched impact strength ASTM D 256 (23 °C)	ASTM D 256	J/m	130 / -
<b>Thermal properties</b>			
HDT B (0.45 MPa)	ISO 75-1/-2	°C	216
HDT B (0.45 MPa), ASTM	ASTM D 648	°C	216
HDT A (1.80 MPa)	ISO 75-1/-2	°C	210
HDT A (1.82 MPa), ASTM	ASTM D 648	°C	210
Melting temperature, DSC (10°C/min)	ISO 11357-1/-3	°C	222
<b>Electrical properties</b>			
			dry / cond.
Surface resistivity	IEC 62631-3-2	Ohm	1E13 / 1E11
Volume resistivity	IEC 62631-3-1	Ohm*m	1E13 / 1E9
Electric strength (d = 2.0 mm)	IEC 60243-1	kV/mm	- / 22
Comparative tracking index, CTI, test liquid A	IEC 60112	-	550 / 475
<b>Flammability</b>			
Glow Wire Flammability Index (1.6 mm)	IEC 60695-2-12	°C	650
<b>Injection</b>			
Pre/Post-processing, Pre-drying, Temperature	-	°C	80
Pre/Post-processing, max. allowed water content	-	%	0.2
Injection molding cylinder temperature 1 (feed zone)	-	°C	230 - 235
Injection molding cylinder temperature 2 (compression)	-	°C	235 - 240
Injection molding cylinder temperature 3 (metering-zone, head room of screw)	-	°C	240 - 250
injection molding, Mold temperature, range	ISO 294	°C	60 - 90

