

Ultramid® 8254 HS BK-102

Polyamide 6



Product Description

Ultramid 8254 HS BK-102 is a highly flexible, heat stabilized, pigmented black, impact modified PA6 extrusion compound for tubing application.

Applications

Ultramid 8254 HS BK-102 is generally recommended for applications such as convoluted and emission tubing, cable jacketing and other types of automotive tubing.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.07	
Moisture, %	62		
(24 Hour)		1.2	
(50% RH)		2	
(Saturation)		7.1	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
-40C		2,730	3,000
23C		875	460
80C		180	230
121C		155	145
Tensile stress at yield, MPa	527		
-40C		83	104
23C		34	26
80C		15	-
121C		12	-
Tensile strain at yield, %	527		
23C		7	30
Nominal strain at break, %	527		
23C		>50	>50
Flexural Modulus, MPa	178		
23C		750	-
IMPACT	ISO Test Method	Dry	Conditioned
Izod Notched Impact, kJ/m ²	180		
23C		N	-
-40C		6	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
HDT A, C	75	43	-
Coef. of Linear Thermal Expansion, Parallel, mm/mm C		0.93 X10-4	-
Coef. of Linear Thermal Expansion, Normal, mm/mm C		1.11 X10-4	-
ELECTRICAL	ISO Test Method	Dry	Conditioned



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Volume Resistivity IEC 60093 >1E13 -

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

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 65 degC (149 degF) is recommended. Drying time is dependent on moisture level, but 2-4 hours is generally sufficient. Further information concerning safe handling procedures can be obtained from the Material Safety Data Sheet. Alternatively, please contact your BASF representative.

Typical Profile

Melt Temperature 240-250 degC (464-482 degF)

Typical Barrel Profile (degC):

Rear 245-255 degC (473-491 degF)
Middle 245-260 degC (473-500 degF)
Front 240-250 degC (464-482 degF)

Head 230-245 degC (446-473 degF)
Flange 230-245 degC (446-473 degF)
Die 230-245 degC (446-473 degF)

Screw Parameters

Metering Section	40%
Transition Section	3 to 4 flights
Feed Section	balance of screw length
Compression Ratio	3.5:1 to 4.0:1
L/D Ratio	20:1 to 24:1

