

Ultramid® HPN 9362

Polyamide 6

Product Description

Ultramid HPN 9362 is a 40% mineral reinforced, impact modified PA6 injection molding compound. It is one of the High Productivity Nylon series having improved surface appearance while reducing cycle time. It possesses excellent balance of strength, stiffness and toughness combined with a high level of drop weight impact, excellent processability and chemical resistance to greases, oils and hydrocarbons.

Applications

Ultramid HPN 9362 is generally recommended for applications such as wheel cover and hubs, mirror housings, appliance components, power tool housings, small engine pulleys, and trimmer spools.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.41	
Moisture, %	62		
(50% RH)		1.4	
(Saturation)		4.9	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		4,330	2,900
Tensile stress at yield, MPa	527		
23C		65	45
Tensile strain at yield, %	527		
23C		3	27
IMPACT	ISO Test Method	Dry	Conditioned
Charpy Notched, kJ/m ²	179		
23C		6	-
-30C		3	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	220	-
ELECTRICAL	ISO Test Method	Dry	Conditioned
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	



Material is supplied in sealed containers and drying prior to molding in a dehumidifying or desiccant dryer is recommended. Drying parameters are dependent upon the actual percentage of moisture in the pellets and typical pre-drying conditions are 2-4 hours at 180F (83C). Recommended moisture levels for achieving optimum surface qualities and mechanical properties is 0.05% - 0.12%. Further information concerning safe handling procedures can be obtained from the Material Safety Data Sheet (MSDS), or by contacting your BASF representative.

Typical Profile

Melt Temperature 270-295 degC (518-563 degF)
Mold Temperature 80-95 degC (176-203 degF)
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 degC (176-203 degF) is recommended.

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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