Product Information **Ultramid®**

ALLOY KC 246 BLACK

(PA6+ABS)

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Product description

Ultramid® ALLOY KC 246 Black is an unfilled grade based on blend of polyamide 6 and acrylonitrile butadiene styrene (PA6 + ABS), impact modified, for injection moulding. This grade offers an excellent impact with an ideal combination between stiffness and toughness.
It is a synergistic blend material between Polyamide 6 and ABS with an ideal property combination, meaning that it has dual characteristics between semi-crystalline and amorphous polymers.

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 unfilled polyamides, BASF SE recommends the use of high alloy steel with a low chromium content. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (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 substitutive for necessary prior tests which alone can ensure that a product is suitable for a given use. ANY WARRANTY OF PRODUCT PERFORMANCE, MERCHANDABILITY 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.

This grade complies with RoHS Directive 2011/65/EU, 2015/863 and local regulations as amended.

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

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Typical values for uncoloured product at 23 °C[1)]	Test method	Unit	Values[2)]
General Properties			
Asia Pacific	-	-	**+**
Processing: Injection moulding (M), Extrusion (E), Blow moulding (B)	-	-	**M**
Colour; black (bk), uncoloured (un), coloured (co), transparent (tr)	-		**bk,un,co**
Pellets	-	-	**+**
Physical			
Water absorption, 24 h in water, 23 °C	ISO 62	%	**0.9**
Density	ISO 1183	kg/m³	**1080 / -**
Mechanical properties			**dry / cond.**
Tensile modulus	ISO 527-1/-2	MPa	**2250 / -**
Stress at break	ISO 527-1/-2	MPa	**53 / -**
Strain at break	ISO 527-1/-2	%	**94 / -**
Flexural modulus	ISO 178	MPa	**2150 / -**
Charpy notched impact strength ISO 179/1eA (23°C)	ISO 179/1eA	kJ/m²	**63 / -**
Charpy impact strength ISO 179-1eU (23°C)	ISO 179/1eU	kJ/m²	**N / -**
Izod notched impact strength ISO 180/A (23°C)	ISO 180/A	kJ/m²	**48 / -**
Thermal properties			
HDT B (0.45 MPa)	ISO 75-1/-2	°C	**105**
HDT A (1.80 MPa)	ISO 75-1/-2	°C	**70**
Melting temperature, DSC (10°C/min)	ISO 11357-1/-3	°C	**225**
Electrical properties			**dry / cond.**
Comparative tracking index, CTI, test liquid A	IEC 60112	-	**600 / -**
Flammability			
Burning Behav. at thickness 0.8 mm	IEC 60695-11-10	class	**HB**
Glow Wire Flammability Index (0.8 mm)	IEC 60695-2-12	°C	**750**
Glow Wire Flammability Index (1.6 mm)	IEC 60695-2-12	°C	**650**
Glow Wire Flammability Index (3.2 mm)	IEC 60695-2-12	°C	**650**
Injection			
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	**235 - 240**
Injection molding cylinder temperature 2 (compression)	-	°C	**240 - 250**
Injection molding cylinder temperature 3 (metering-zone, head room of screw)	-	°C	**250 - 260**
injection molding, Mold temperature, range	ISO 294	°C	**60 - 90**