Product Information

Ultramid® 66 H2 G/35-V0KB NAT0046

Polyamide 66

BASF The Chemical Company

Product Description

Ultramid 66 H2 G/35-V0KB NAT0046 is a 35% glass reinforced, heat stabilized injection molding grade. It is a V-0 self-extinguishing grade, with phosphorous. It offers good flowability and mechanical properties. It has excellent electrical properties.

Applications

Ultramid 66H2 G/35-V0KB NAT0046 is designed for applications requiring good processing, mechanical integrity and flammability performance.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.45	
MECHANICAL	**ISO Test Method**	**Dry**	**Conditioned**
Tensile Modulus, MPa	527		
23C		11,300	-
Tensile stress at break, MPa	527		
23C		175	-
Tensile strain at break, %	527		
23C		2.7	-
Flexural Modulus, MPa	178		
23C		10,700	-
IMPACT	**ISO Test Method**	**Dry**	**Conditioned**
Izod Notched Impact, kJ/m^2	180		
23C		10	-
-40C		9	-
Charpy Notched, kJ/m^2	179		
23C		10	-
-30C		9	-
THERMAL	**ISO Test Method**	**Dry**	**Conditioned**
Melting Point, C	3146	260	-
HDT A, C	75	247	-

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 required.

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