Product Information

Ultramid® 1403-2 NF3001
Polyamide 66

BASF
The Chemical Company

Product Description

Ultramid 1403-2 NF3001 is a 13% glass reinforced, heat stabilized injection molding PA6/6.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.23	
Moisture, %	62		
(50% RH)		2.2	
(Saturation)		7.4	
MECHANICAL	**ISO Test Method**	**Dry**	**Conditioned**
Tensile Modulus, MPa	527		
23C		6,000	3,900
Tensile stress at break, MPa	527		
23C		125	90
Tensile strain at break, %	527		
23C		3	13
Flexural Modulus, MPa	178		
23C		5,800	3,000
IMPACT	**ISO Test Method**	**Dry**	**Conditioned**
Izod Notched Impact, kJ/m^2	180		
23C		5.2	6
Charpy Notched, kJ/m^2	179		
23C		5.5	7
-30C		4.5	6
Charpy Unnotched, kJ/m^2	179		
23C		55	65
-30C		45	45
THERMAL	**ISO Test Method**	**Dry**	**Conditioned**
Melting Point, C	3146	260	-
HDT A, C	75	245	-
HDT B, C	75	262	-

Back Pressure: 0-0.35 MPa (0-50 psi)
Screw RPM 40-80
Screw Compression Ratio:3:1-4:1

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 60-100 degC (140-212 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.

Fill Rate
Fast fill rates are recommended to ensure uniform melt delivery to the cavity and prevent premature freezing.

Note