

Ultramid® A3K BK00464

Polyamide 66

Product Description

Ultramid A3K BK 464 is an easy flowing, pigmented black, injection molding grade PA66.

Applications

Typical applications include fast processing high stress technical parts or electrically insulating parts.

PHYSICAL	ISO Test Method	Property Value	
Density, g/cm	1183	1.13	
Moisture, %	62		
(50% RH)		2.8	
(Saturation)		8.5	
MECHANICAL	ISO Test Method	Dry	Conditioned
Tensile Modulus, MPa	527		
23C		3,600	-
Tensile stress at yield, MPa	527		
23C		87	-
Tensile strain at yield, %	527		
23C		4.2	-
IMPACT	ISO Test Method	Dry	Conditioned
Charpy Notched, kJ/m ²	179		
23C		5	-
THERMAL	ISO Test Method	Dry	Conditioned
Melting Point, C	3146	260	-
HDT A, C	75	75	-

Processing Guidelines

Material Handling

Max. Water content: 0.20%

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 80 degC (176 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 280-300 degC (536-572 degF)

Mold Temperature 40-80 degC (104-176 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 40-80 degC (104-176 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.

