

Product description

Ultramid® STAR AFX 216 V60 Grey 2327 is a high flow polyamide 66 resin, reinforced with 60% of glass fibre, for injection moulding. Due to its outstanding flow characteristics, this grade shows exceptional processing behaviour and excellent surface aspect of the finished part.

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 reinforced polyamides, BASF SE recommends the use of steel with a high content of carbon, and purified for polishing, to avoid or limit the abrasion. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (DIN Norm) or X160CrMoV12 (EN Norm) - 1.2601 /1.2379 (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, MERCHANTABILITY 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.

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



Product Information

Typical values for uncoloured product at 23 °C ¹⁾	Test method	Unit	Values ²⁾
General Properties			
Asia Pacific	-	-	+
Near East/Africa	-	-	+
Processing: Injection moulding (M), Extrusion (E), Blow moulding (B)	-	-	M
Colour; black (bk), uncoloured (un), coloured (co), transparent (tr)	-	-	un,co
Pellets	-	-	+
Physical			
Molding shrinkage (parallel)	ISO 294-4	%	0.35
Molding shrinkage (normal)	ISO 294-4	%	0.45
Water absorption, 24 h in water, 23 °C	ISO 62	%	0.52
Density	ISO 1183	kg/m ³	1710 / -
Mechanical properties			
			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	22000 / 16500
Stress at break	ISO 527-1/-2	MPa	260 / 195
Tensile Strength at Break (ASTM)	ASTM D 638	MPa	250 / -
Strain at break	ISO 527-1/-2	%	2.2 / 2.9
Tensile elongation at break, 2 in/min (ASTM)	ASTM D 638	%	2 / -
Flexural modulus	ISO 178	MPa	18000 / 13200
Flexural modulus (ASTM)	ASTM D 790	MPa	18000 / -
Flexural strength	ISO 178	MPa	400 / 300
Flexural strength (ASTM)	ASTM D 790	MPa	370 / -
Charpy notched impact strength ISO 179/1eA (23°C)	ISO 179/1eA	kJ/m ²	15 / 15
Charpy impact strength ISO 179-1eU (23°C)	ISO 179/1eU	kJ/m ²	90 / 87
Izod notched impact strength ASTM D 256 (23 °C)	ASTM D 256	J/m	170 / -
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	258
HDT A (1.82 MPa), ASTM	ASTM D 648	°C	253
Melting temperature, DSC (10°C/min)	ISO 11357-1/-3	°C	262
Flammability			
Burning Behav. at 1.6 mm nom. thickn.	IEC 60695-11-10	class	HB
Burning Behav. at thickness 0.8 mm	IEC 60695-11-10	class	HB
Burning Behav. at thickness 3.2 mm	UL-94, IEC 60695	class	HB
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	265 - 275
Injection molding cylinder temperature 2 (compression)	-	°C	270 - 280
Injection molding cylinder temperature 3 (metering-zone, head room of screw)	-	°C	280 - 290
injection molding, Mold temperature, range	ISO 294	°C	60 - 90

