

**Product description**

Ultramid® ONE J 60X1 V35 Natural is a high temperature polyamide, based on a non-halogenated flame retardant system, reinforced with 35% of glass fiber with best-in-class fire protection behavior, heat stabilized, for injection moulding.

This grade offers superior electrical and fire performances. Its high flow matrix allows to decrease corrosion and increases life time of the injection tool when adequate steel is in use. In addition, it offers benefit in term of productivity and for design freedom.

**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:

- All reinforced, flame retardant compounds generate some level of abrasion/corrosion to the steel processing equipment. These issues may be magnified by using incorrect processing conditions (temperatures, residence time, moisture level ...) during the moulding process. Therefore, BASF SE recommends you adhere to the processing conditions detailed in this technical data sheet. For equipment that comes into contact with molten flame retardant compounds, BASF SE advises you to use a steel with high chromium and high carbon content (having a minimum concentration of 16% Chromium) to prevent corrosion and abrasion. For the correct reference of steel associated to flame retardant compounds' processing, please refer to your equipment manufacturers. 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 not on no account be used as a substitute 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.

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

Grades produced or imported in Europe comply with REACH directive 1907/2006/EC 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



## Product Information

Typical values for uncoloured product at 23 °C <sup>1)</sup>	Test method	Unit	Values <sup>2)</sup>
<b>General Properties</b>			
North America	-	-	+
Asia Pacific	-	-	+
South and Central America	-	-	+
Near East/Africa	-	-	+
Processing: Injection moulding (M), Extrusion (E), Blow moulding (B)	-	-	M
Colour: black (bk), uncoloured (un), coloured (co), transparent (tr)	-	-	un
Pellets	-	-	+
<b>Physical</b>			
Molding shrinkage (parallel)	ISO 294-4	%	0.40
Molding shrinkage (normal)	ISO 294-4	%	0.75
Water absorption, 24 h in water, 23 °C	ISO 62	%	0.55
Moisture absorption, equilibrium 23°C/50% r.h	similar to ISO 62	%	1.50
Density	ISO 1183	kg/m <sup>3</sup>	1480 / -
<b>Mechanical properties</b>			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	12500 / 12000
Stress at break	ISO 527-1/-2	MPa	160 / 130
Strain at break	ISO 527-1/-2	%	2.5 / 2.8
Flexural modulus	ISO 178	MPa	10000 / -
Flexural strength	ISO 178	MPa	248 / -
Charpy notched impact strength ISO 179/1eA (23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	10 / 10
Charpy impact strength ISO 179-1eU (23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	63 / 59
<b>Thermal properties</b>			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	257
Melting temperature, DSC (10°C/min)	ISO 11357-1/-3	°C	280
RTI, electrical, d = 0.4 mm	UL-746B	°C	150
<b>Electrical properties</b>			dry / cond.
Electric strength (d = 0.8 mm)	IEC 60243-1	kV/mm	35 / -
Comparative tracking index, CTI, test liquid A	IEC 60112	-	600 / -
<b>Flammability</b>			
Burning Behav. at 1.6 mm nom. thickn.	IEC 60695-11-10	class	V-0
Burning Behav. at thickness 0.4 mm	IEC 60695-11-10	class	V-0
Burning Behav. at thickness 0.8 mm	UL-94, IEC 60695	class	V-0
Burning Behav. at thickness 3.2 mm	UL-94, IEC 60695	class	V-0
Burning Behav. 5V at thickness 0.8 mm	IEC 60695-11-20	class	5VA
Glow Wire Flammability Index (0.4 mm)	IEC 60695-2-12	°C	960
Glow Wire Flammability Index (0.8 mm)	IEC 60695-2-12	°C	960
Glow Wire Flammability Index (1.6 mm)	IEC 60695-2-12	°C	960
Glow Wire Ignition Temperature (0.4 mm)	IEC 60695-2-13	°C	800
Glow Wire Ignition Temperature (0.8 mm)	IEC 60695-2-13	°C	800
<b>Injection</b>			
Pre/Post-processing, Pre-drying, Temperature	-	°C	80
Pre/Post-processing, max. allowed water content	-	%	0.12
Injection molding cylinder temperature 1 (feed zone)	-	°C	285 - 295
Injection molding cylinder temperature 2 (compression)	-	°C	290 - 300
Injection molding cylinder temperature 3 (metering-zone, head room of screw)	-	°C	290 - 300
injection molding, Mold temperature, range	ISO 294	°C	90 - 110

