

Ultradid® A3XZG5
PA66-I-GF25 FR(52)

BASF

An impact-modified, glass fibre reinforced injection moulding grade with improved flame retardance based on red phosphorus; for components requiring high stiffness and enhanced toughness. (eg PV-connectors an PV-junction boxes)

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	3 / *	cm³/10min	ISO 1133
Temperature	300 / *	°C	-
Load	10 / *	kg	-

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	6500 / 4500	MPa	ISO 527
Stress at Break	105 / 70	MPa	ISO 527
Strain at Break	6 / 11	%	ISO 527
Tensile Creep Modulus, 1h	* / 2500	MPa	ISO 899-1
Tensile Creep Modulus, 1000h	* / 2000	MPa	ISO 899-1
Impact Strength (Charpy), +23°C	90 / 100	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	85 / 80	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	25 / 30	kJ/m²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	260 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	240 / *	°C	ISO 75-1/-2
Temp. of deflection under load (0.45 MPa)	250 / *	°C	ISO 75-1/-2
Coeff. of Linear Therm. Expansion, parallel	36 / *	E-6/K	ISO 11359-1/-2
Coeff. of Linear Therm. Expansion, normal	127 / *	E-6/K	ISO 11359-1/-2
Burning Behav. at 1.5 mm Nom. Thickn.	V-0 / *	class	UL 94
Thickness tested	1.6 / *	mm	-
UL recognition	yes / *	-	-
Burning Behav. at thickness h	V-2 / *	class	UL 94
Thickness tested	0.8 / *	mm	-
UL recognition	yes / *	-	-
Burning Behav. 5V at Thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	2.3 / *	mm	-
Yellow Card available	yes / *	-	-
Oxygen index	28 / *	%	ISO 4589-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	3.8 / 4	-	IEC 62631-2-1
Dissipation Factor, 1MHz	200 / 300	E-4	IEC 62631-2-1
Volume Resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E13	Ohm	IEC 62631-3-2
Electric Strength	33 / 30	kV/mm	IEC 60243-1
Comparative tracking index	575 / 575	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	5 / *	%	Sim. to ISO 62
Humidity absorption	1.2 / *	%	Sim. to ISO 62
Density	1320 / -	kg/m³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	290	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294
Injection Molding, injection velocity	200	mm/s	ISO 294

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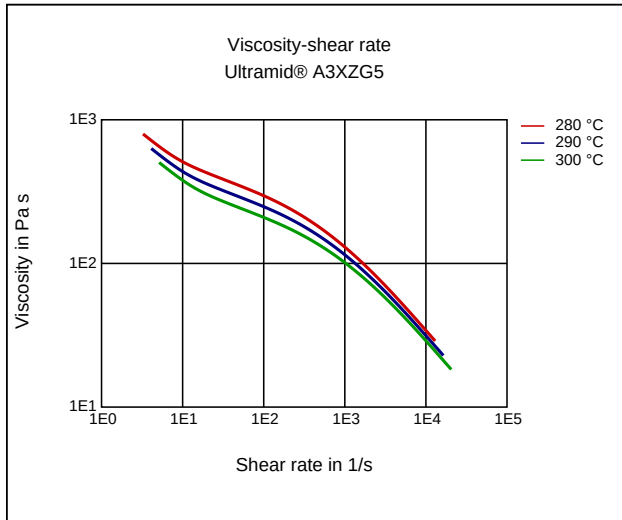
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Processing Recommendation Injection Molding

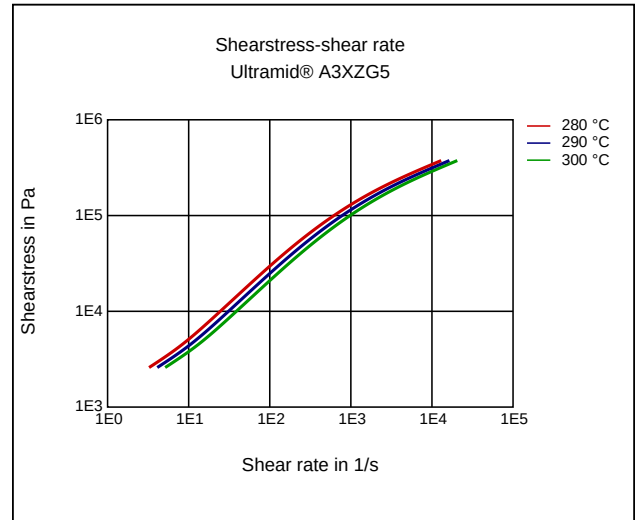
	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	280 - 300	°C	-
Mold temperature	80 - 90	°C	-

Diagrams

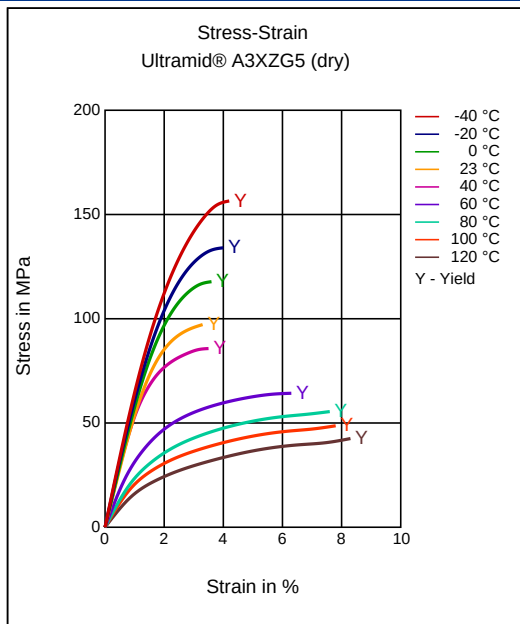
Viscosity-shear rate



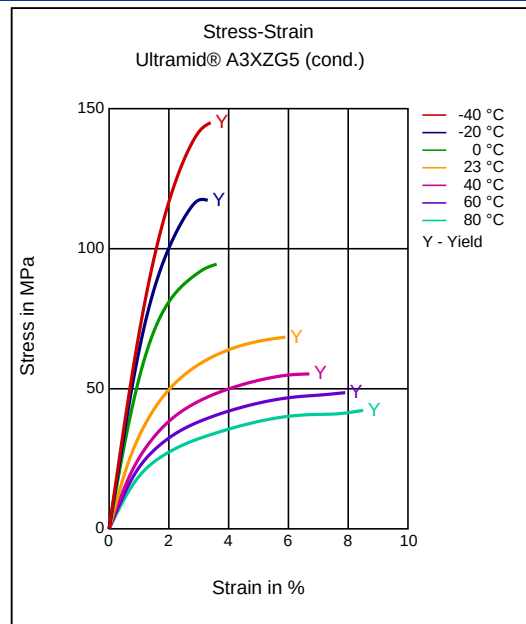
Shearstress-shear rate



Stress-strain



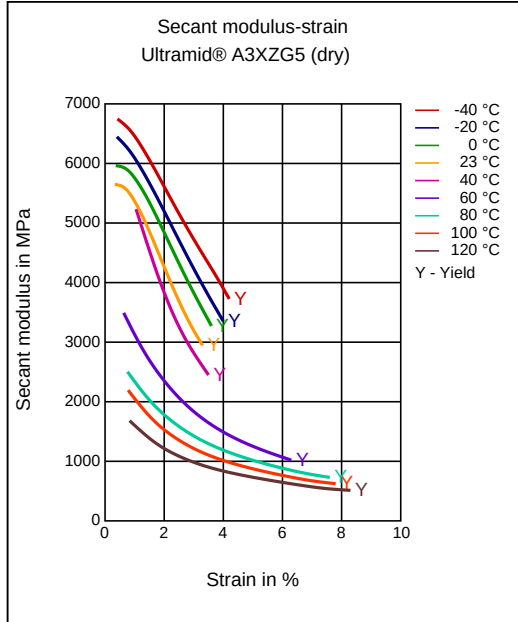
Stress-strain



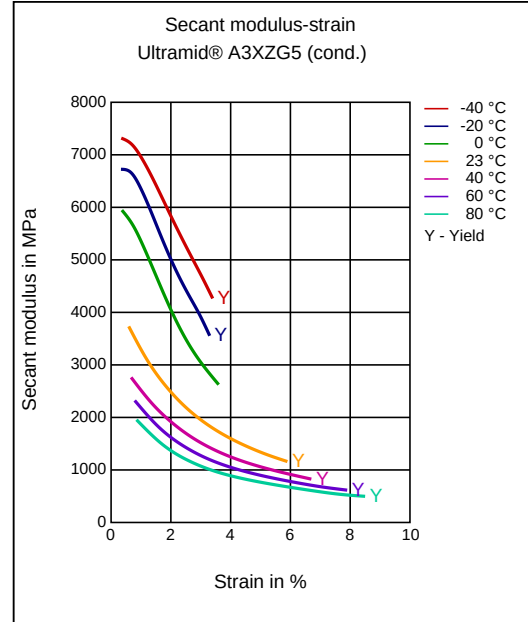
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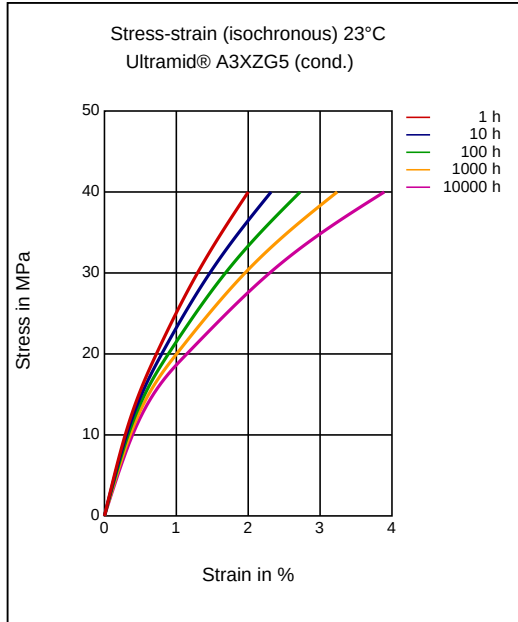
Secant modulus-strain



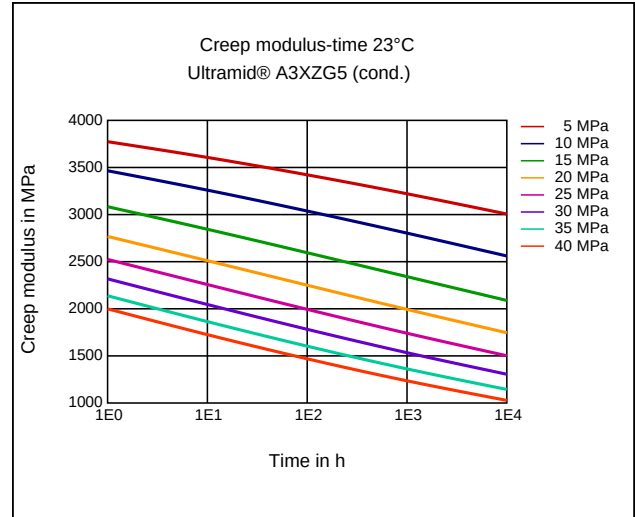
Secant modulus-strain



Stress-strain (isochronous) 23 °C



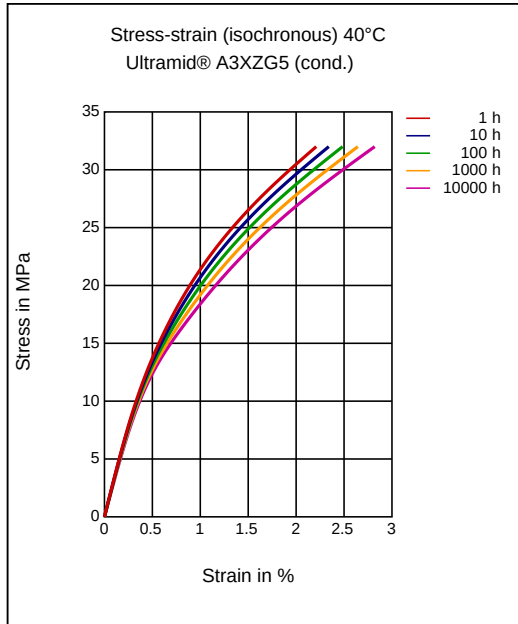
Creep modulus-time 23 °C



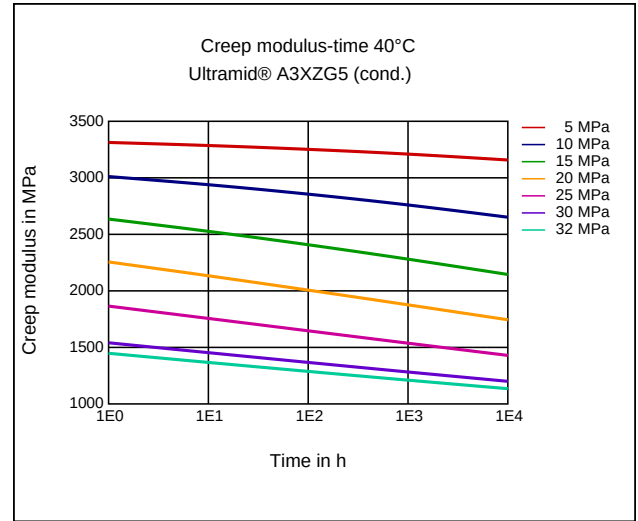
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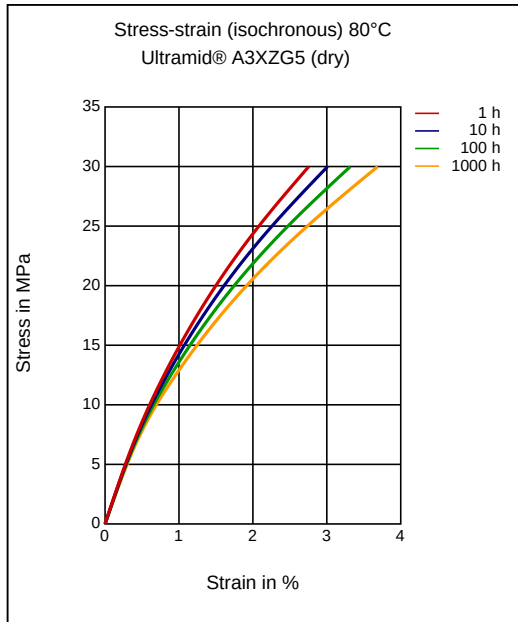
Stress-strain (isochronous) 40 °C



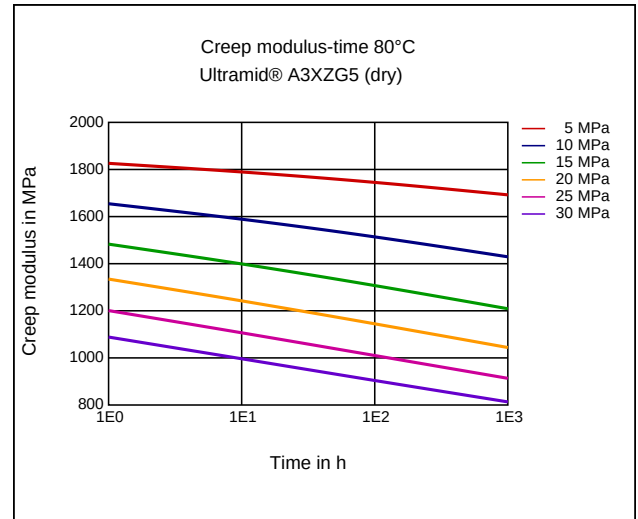
Creep modulus-time 40 °C



Stress-strain (isochronous) 80 °C



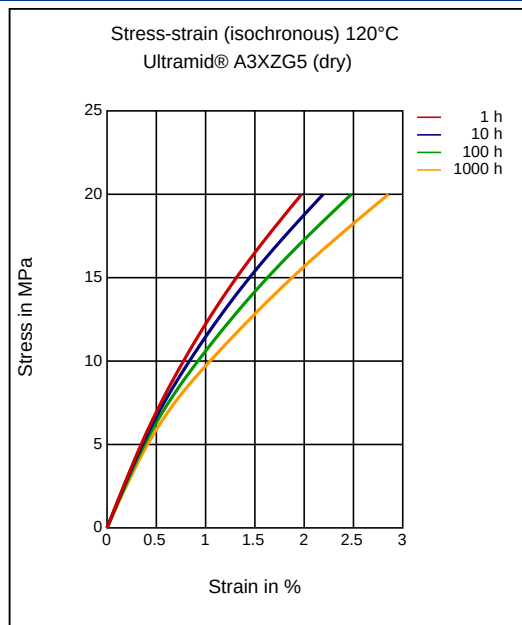
Creep modulus-time 80 °C



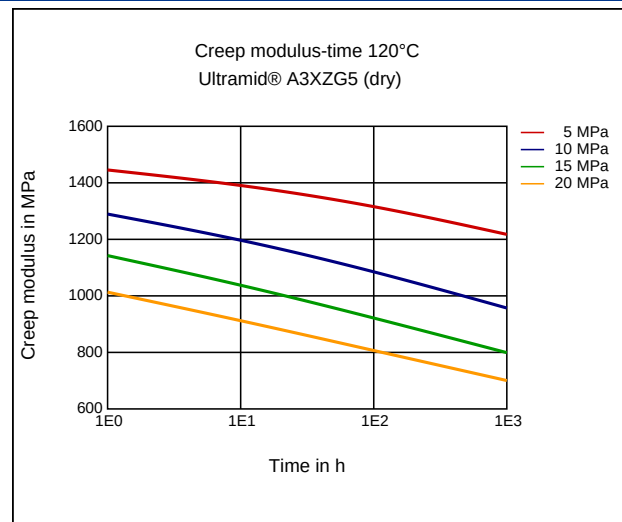
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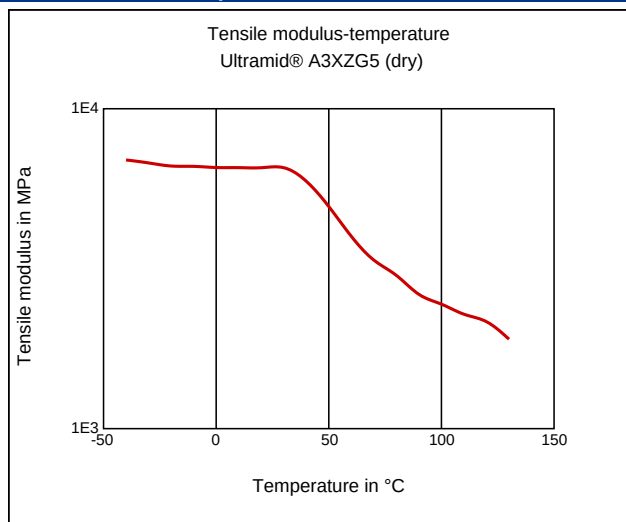
Stress-strain (isochronous) 120 °C



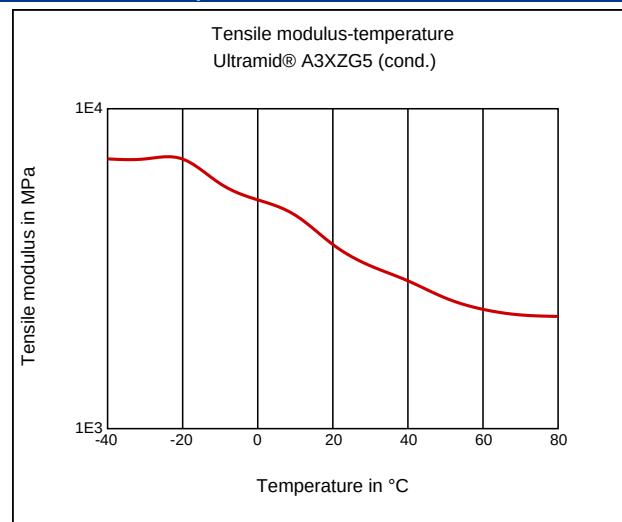
Creep modulus-time 120 °C



Tensile Modulus-Temperature



Tensile Modulus-Temperature



Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Release agent

Special Characteristics

Flame retardant, Halogen-free, Impact modified, Heat aging stabilized

Injection Molding

PREPROCESSING

Pre/Post-processing, max. allowed water content: .15 %

Pre/Post-processing, Pre-drying, Temperature: 80 - 100 °C

Pre/Post-processing, Pre-drying, Time: 4 h

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PROCESSING

injection molding, Melt temperature, range: 280 - 300 °C

injection molding, Melt temperature, recommended: 290 °C

injection molding, Mold temperature, range: 80 - 90 °C

injection molding, Mold temperature, recommended: 80 °C

injection molding, Dwell time, thermoplastics: 10 min