

Ultramid® T KR 4340 G6
PPA-GF30

BASF

Rheological properties	dry / cond	Unit	Test Standard
ISO Data			
Melt volume-flow rate, MVR	25 / *	cm³/10min	ISO 1133
Temperature	325 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	11000 / 11000	MPa	ISO 527
Stress at Break	155 / 135	MPa	ISO 527
Strain at Break	2.5 / 2.5	%	ISO 527
Impact Strength (Charpy), +23°C	65 / 50	kJ/m²	ISO 179/1eU
Impact Strength (Charpy), -30°C	65 / -	kJ/m²	ISO 179/1eU
Notched Impact Strength (Charpy), +23°C	8 / -	kJ/m²	ISO 179/1eA
Notched Impact Strength (Charpy), -30°C	7.5 / -	kJ/m²	ISO 179/1eA
Flexural Modulus (23°C)	11000 / 11000	MPa	ISO 178

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
Melting Temperature (10°C/min)	290 / *	°C	ISO 11357-1/-3
Temp. of deflection under load (1.80 MPa)	240 / *	°C	ISO 75-1/-2
Oxygen index	50 / *	%	ISO 4589-1/-2

Electrical Properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	3.9 / 4.1	-	IEC 62631-2-1
Dissipation Factor, 1MHz	150 / 270	E-4	IEC 62631-2-1
Volume Resistivity	>1E13 / >1E13	Ohm*m	IEC 62631-3-1
Surface Resistivity	* / 1E14	Ohm	IEC 62631-3-2
Comparative tracking index	600 / -	-	IEC 60112

Other Properties	dry / cond	Unit	Test Standard
ISO Data			
Water Absorption	5.3 / *	%	Sim. to ISO 62
Humidity absorption	1.8 / *	%	Sim. to ISO 62
Density	1480 / -	kg/m³	ISO 1183
Bulk density	700	kg/m³	-

Material Specific Properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	125 / *	cm³/g	ISO 307, 1157, 1628

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	8	h	-
Processing humidity	≤0.03	%	-
Melt temperature	310 - 330	°C	-
Mold temperature	80 - 120	°C	-
Feed temperature	80	°C	-
Zone 1	300	°C	-
Zone 2	310	°C	-
Zone 3	320	°C	-
Zone 4	320	°C	-
Maximum residence time	5	min	-

Characteristics

Ultramid® T KR 4340 G6
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BASF

Delivery form

Pellets

Features

Low Odor

Special Characteristics

Flame retardant, Halogen-free