Ultramid® 8333G HI HS BK-106

Polyamide 6

BASF Corporation

Message:

Ultramid 8333G HI HS BK-106 is a 33% glass reinforced, impact modified PA6 injection molding compound pigmented black developed for applications requiring improved dry as molded toughness in combination with a balance of strength, stiffness and excellent moldability/surface aesthetics.
Applications
Ultramid 8333G HI HS BK-106 is generally recommended for application such as front wheel chair wheels, bicycle wheels, power tool housings, chain saw housings, clips and fasteners, hose clamps and window hardware.

General Information			
UL YellowCard	E36632-231152		
Filler / Reinforcement	Glass Fiber,33% Filler by Weight		
Additive	Impact Modifier		
Features	Good Stiffness Good Strength Impact Modified Pleasing Surface Appearance		
Uses	Fasteners Housings Power/Other Tools Wheels		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Appearance	Black		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.36	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage - Flow (3.18 mm)	0.30	%	
Water Absorption			
24 hr	0.90	%	ASTM D570
23°C, 24 hr	0.90	%	ISO 62
Saturation	5.5	%	ASTM D570
Saturation, 23°C	5.5	%	ISO 62
Equilibrium, 50% RH	1.5	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.5	%	ISO 62
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**

Tensile Strength (Break, 23°C)	145	MPa	ASTM D638, ISO 527-2
Tensile Elongation (Break, 23°C)	2.5	%	ASTM D638, ISO 527-2
Flexural Modulus			
23°C	7990	MPa	ASTM D790
23°C	7910	MPa	ISO 178
Flexural Strength (23°C)	232	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	180	J/m	ASTM D256
23°C	18	kJ/m^2	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (1.8 MPa, Unannealed)	208	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418, ISO 3146
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.080	%	
Rear Temperature	245 to 275	°C	
Middle Temperature	260 to 285	°C	
Front Temperature	270 to 295	°C	
Nozzle Temperature	270 to 295	°C	
Processing (Melt) Temp	270 to 295	°C	
Mold Temperature	80.0 to 95.0	°C	
Injection Pressure	3.50 to 12.5	MPa	
Injection Rate	Fast		

Recommended distributors for this material

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