

Ultramid® Seal-Fit

Polyamide 66/6 Copolymer

BASF Corporation

Message:

Transparent, tough, amorphous copolyamide for injection moulding, specially developed for tight overmoulding of metal inlays.

General Information				
Features		Copolymer Good toughness amorphous		
Uses		overmolding		
Agency Ratings		EC 1907/2006 (REACH)		
RoHS Compliance		RoHS compliance		
Appearance		Clear/transparent		
Forms		Particle		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.10	--	g/cm ³	ISO 1183
Apparent Density	0.70	--	g/cm ³	
Melt Volume-Flow Rate (MVR)				ISO 1133
230°C/10.0 kg	75.0	--	cm ³ /10min	ISO 1133
275°C/5.0 kg	120	--	cm ³ /10min	ISO 1133
Molding Shrinkage				ISO 294-4
Vertical flow direction	0.30	--	%	ISO 294-4
Flow direction	0.30	--	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	4.5 - 5.0	--	%	ISO 62
Viscosity Number (H ₂ SO ₄ (Sulphuric Acid))	125	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Durometer Hardness (Shore D)	85	65		ISO 868
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2500	--	MPa	ISO 527-2
Tensile Strain (Yield)	5.0	--	%	ISO 527-2/50
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature (0.45 MPa, Unannealed)	57.0	--	°C	ISO 75-2/B

Vicat Softening Temperature	68.0	--	°C	ISO 306/B
Linear thermal expansion coefficient				ISO 11359-2
Flow: 23 to 55°C	8.0E-5 - 1.2E-4	--	cm/cm/°C	ISO 11359-2
Lateral: 23 to 55°C	8.0E-5 - 1.2E-4	--	cm/cm/°C	ISO 11359-2
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	> 1.0E+15	--	ohms	IEC 60093
Volume Resistivity	9.0E+14	--	ohms·cm	IEC 60093
Comparative Tracking Index (Solution A)	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94
1.60 mm	HB	--		UL 94
3.20 mm	V-2	--		UL 94
Additional Information	Dry	Conditioned		
Polymer Abbreviation	PA6/66/136	--		
Screw Speed			mm/sec	
Injection	Dry	Unit		
Drying Temperature	60.0		°C	
Drying Time	8.0		hr	
Suggested Max Moisture	0.15		%	
Hopper Temperature	30.0		°C	
Rear Temperature	200		°C	
Middle Temperature	240		°C	
Front Temperature	240		°C	
Nozzle Temperature	240		°C	
Processing (Melt) Temp	230 - 260		°C	
Mold Temperature	20.0 - 50.0		°C	
Injection instructions				
Residence Time : <10 min				

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