

Ultramid® A3K FC R01

Polyamide 66

BASF Corporation

Message:

Ultramid A3K FC R01 is an easy flowing, injection molding grade PA66.

Applications

Intended for food contact applications

General Information			
Features	Food Contact Acceptable		
	Good Flow		
Uses	Non-specific Food Applications		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Water Absorption			ISO 62
Saturation, 23°C	8.5	%	
Equilibrium, 23°C, 50% RH	2.8	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	3000	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	85.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	5.0	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	20	%	ISO 527-2
Flexural Modulus (23°C)	2900	MPa	ISO 178
Flexural Stress (23°C)	100	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength (23°C)	5.5	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	75.0	°C	ISO 75-2/A
Melting Temperature (DSC)	260	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	

Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	280 to 300	°C
Mold Temperature	40.0 to 80.0	°C
Injection Pressure	3.50 to 12.5	MPa
Injection Rate	Fast	

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