

Ultramid® A3L HP

Polyamide 66

BASF Corporation

Message:

Ultramid A3L HP is an unreinforced, heat stabilized, impact modified, high flow, nylon 66 for injection molding. This grade has excellent flow and improved ambient and low temperature toughness.

Applications

Typical applications include fasteners and clamps.

General Information			
UL YellowCard	E36632-641863	E36632-101655559	
Additive	Heat Stabilizer		
	Impact Modifier		
Features	Heat Stabilized		
	High Flow		
	Impact Modified		
	Low Temperature Toughness		
	Oil Resistant		
Uses	Fasteners		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS Compliant		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	2440	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	63.5	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	6.2	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	28	%	ISO 527-2
Flexural Modulus (23°C)	2280	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	14	kJ/m²	
23°C	19	kJ/m²	
Notched Izod Impact Strength			ISO 180
-40°C	12	kJ/m²	
23°C	18	kJ/m²	
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature (1.8 MPa, Unannealed)	70.0	°C	ISO 75-2/A
Melting Temperature (DSC)	260	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	60.0	°C	
Drying Time	1.0 to 2.0	hr	
Suggested Max Moisture	0.040 to 0.20	%	
Processing (Melt) Temp	288 to 305	°C	
Mold Temperature	60.0 to 100	°C	
Injection Pressure	3.50 to 12.5	MPa	
Injection Rate	Fast		
Back Pressure	0.00 to 0.350	MPa	
Screw Speed	40 to 80	rpm	
Screw Compression Ratio	3.0:1.0 to 4.0:1.0		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

