

Ultramid® A3L HP BK20465

Polyamide 66

BASF Corporation

Message:

Ultramid A3L HP BK20465 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		
Appearance		Black		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.10	--	g/cm³	ISO 1183
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	2440	1370	MPa	ISO 527-2
Tensile Stress				ISO 527-2
Yield, 23°C	63.0	44.0	MPa	
Break, 23°C	49.0	41.0	MPa	
Tensile Strain (Yield, 23°C)	6.2	25	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	28	> 50	%	ISO 527-2
Flexural Modulus (23°C)	2280	1150	MPa	ISO 178
Flexural Stress (23°C)	85.0	45.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
-30°C	14	11	kJ/m²	

23°C	19	28	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179
-30°C	No Break	No Break		
23°C	No Break	No Break		
Notched Izod Impact Strength				ISO 180
-40°C	12	9.4	kJ/m ²	
23°C	18	29	kJ/m ²	
Thermal	Dry	Conditioned	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	Dry	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	35.0 to 125		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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