

Ultramid® HFX 35

Polyamide 6

BASF Corporation

Message:

Ultramid HFX 35 is a polyamide specialty extrusion resin combining high flexibility, outstanding chemical resistance and enhanced heat stability.

Applications

Ultramid HFX 35 is recommended for pipe and tubing applications requiring high melt strength and flexibility.

General Information			
Features	Good melt strength		
	Good flexibility		
	Good chemical resistance		
	Thermal stability, good		
Uses	Piping system		
	Pipe fittings		
Agency Ratings	EC 1907/2006 (REACH)		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (23°C)	1180	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	48.0	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	30	%	ISO 527-2
Nominal Tensile Strain at Break (23°C)	200	%	ISO 527-2
Flexural Modulus (23°C)	1050	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	12	kJ/m²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	48.0	°C	ISO 75-2/A
Melting Temperature (DSC)	220	°C	ISO 3146
Extrusion	Nominal Value	Unit	
Drying Temperature	65.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.10	%	
Cylinder Zone 1 Temp.	225 - 245	°C	
Cylinder Zone 3 Temp.	225 - 250	°C	

Cylinder Zone 5 Temp.	225 - 245	°C
Flange temperature	230 - 245	°C
Head Temperature	230 - 245	°C
Extruder Screw L/D Ratio	20.1:1.0 to 24.0:1.0	
Extruder Screw Compression Ratio	3.5:1.0 to 4.0:1.0	
Melt Temperature	225 - 245	°C
Die Temperature	230 - 245	°C

Extrusion instructions

Screw Parameters

Metering Section : 40%

Transition Section : 3 to 4 flights

Feed Section : balance of screw length

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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

