

Product description

Ultramid® A3XTG5 BLACK 23335 is a Red Phosphorous flame retardant polyamide 66, reinforced with 25% of glass fiber, heat stabilized, for injection molding. This grade provides robust UL 94 V-0 and a full UL yellow card while offering good mechanical properties. This grade is suitable for molding insulating parts for electrical devices, and more generally for thin parts under stress.

Injection Notes

The material is supplied in airtight bags, ready for use. In case that the virgin material has absorbed moisture, it must be dried with a dehumidified air drying equipment, dew Point mini -20°C. Recommended time 2-4h.

Injection Advice:

- All reinforced, flame retardant compounds generate some level of abrasion/corrosion to the steel processing equipment. These issues may be magnified by using incorrect processing conditions (temperatures, residence time, moisture level ...) during the moulding process. Therefore, BASF SE recommends you adhere to the processing conditions detailed in this technical data sheet. For equipment that comes into contact with molten flame retardant compounds, BASF SE advises you to use a steel with high chromium and high carbon content (having a minimum concentration of 16% Chromium) to prevent corrosion and abrasion. For the correct reference of steel associated to flame retardant compounds' processing, please refer to your equipment manufacturers. In the case of high requirements on surface quality a mould temperature of up to 120°C can be considered.
- The processing parameters like processing temperatures are a recommendation and can be adjusted in function of injection machine size, part geometry / design.

Disclaimer

The information contained in this document is given in good faith based on our current knowledge. It is only an indication and it is in no way binding. This information must on no account be used as a substitute for necessary prior tests which alone can ensure that a product is suitable for a given use. ANY WARRANTY OF PRODUCT PERFORMANCE, MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE IS EXPRESSLY EXCLUDED. Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorizations. Users are requested to check that they are in possession of the latest version of this document, and BASF SE is at their disposal to supply any additional information.

Safety Information

Detailed information regarding safety are available on the safety data sheet (MSDS). MSDS is sent with the first material order or available by contacting our customer services

Regulations Compliance

This product is not intended to be used for the following regulated market: food contact, drinking water, toys, cosmetics or medical devices.

This grade complies with RoHS Directive 2011/65/EU, 2015/863 and local regulations as amended.

Customer Services

Our customer services are not only concerned with manufacturing and supply of Engineering Plastics products. We are available to assist our customers in finding technical solutions that meet their requirements. Specific support is in particular offered on:

- Material selection
- Material testing
- Parts design advice, training for design engineers
- Part testing
- Design simulation
- Processing through different technologies
- Assembly and post-processing technology expertise
- Parts optimization through Computer Aided Design

Product Information

Typical values for uncoloured product at 23 °C ¹⁾	Test method	Unit	Values ²⁾
General Properties			
Asia Pacific	-	-	+
Pellets	-	-	+
Physical			
Water absorption, 24 h in water, 23 °C	ISO 62	%	0.75
Moisture absorption, equilibrium 23°C/50% r.h	similar to ISO 62	%	2.1
Density	ISO 1183	kg/m ³	1380 / -
Mechanical properties			
			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	9400 / 6300
Stress at break	ISO 527-1/-2	MPa	150 / 100
Strain at break	ISO 527-1/-2	%	2.5 / 5.2
Flexural modulus	ISO 178	MPa	8500 / 5700
Flexural strength	ISO 178	MPa	255 / 170
Charpy notched impact strength ISO 179/1eA (-30°C)	ISO 179/1eA	kJ/m ²	7 / -
Charpy notched impact strength ISO 179/1eA (23°C)	ISO 179/1eA	kJ/m ²	8 / 9
Charpy impact strength ISO 179/1eU (-30°C)	ISO 179/1eU	kJ/m ²	50 / -
Charpy impact strength ISO 179-1eU (23°C)	ISO 179/1eU	kJ/m ²	55 / 60
Izod notched impact strength ISO 180/A (23°C)	ISO 180/A	kJ/m ²	8 / 9
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	244
Melting temperature, DSC (10°C/min)	ISO 11357-1/-3	°C	263
Electrical properties			
			dry / cond.
Surface resistivity	IEC 62631-3-2	Ohm	1E13 / 1E12
Volume resistivity	IEC 62631-3-1	Ohm*m	1E13 / 1E11
Electric strength (d = 0.8 mm)	IEC 60243-1	kV/mm	30 / -
Relative permittivity (100Hz)	IEC 62631-2-1	-	3.4 / 4
Dissipation factor (100 Hz)	IEC 62631-2-1	E-4	0.02 / 0.05
Comparative tracking index, CTI, test liquid A	IEC 60112	-	400 / -
Flammability			
Burning Behav. at 1.6 mm nom. thickn.	IEC 60695-11-10	class	V-0
Burning Behav. at thickness 0.8 mm	IEC 60695-11-10	class	V-0
Burning Behav. at thickness 3.2 mm	UL-94, IEC 60695	class	V-0
Glow Wire Flammability Index (0.8 mm)	IEC 60695-2-12	°C	960
Glow Wire Flammability Index (1.6 mm)	IEC 60695-2-12	°C	960
Glow Wire Flammability Index (3.2 mm)	IEC 60695-2-12	°C	960
Glow Wire Ignition Temperature (1.6 mm)	IEC 60695-2-13	°C	725
Oxygen index	ISO 4589-1/-2	%	31
Injection			
Pre/Post-processing, Pre-drying, Temperature	-	°C	80
Pre/Post-processing, max. allowed water content	-	%	0.2
Injection molding cylinder temperature 1 (feed zone)	-	°C	265 - 275
Injection molding cylinder temperature 2 (compression)	-	°C	270 - 280
Injection molding cylinder temperature 3 (metering-zone, head room of screw)	-	°C	280 - 290
injection molding, Mold temperature, range	-	°C	60 - 90

Footnotes

1) If product name or properties don't state otherwise.

2) The asterisk symbol "*" signifies inapplicable properties.

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