

## BASF Capron® 8333G HI HS BK-102 Impact Modified, 33% Glass-Filled Nylon 6 (Conditioned) (discontinued \*\*)

Category : Polymer , Thermoplastic , Nylon , Nylon 6 , Nylon 6 , Glass Filled, Impact Grade

### Material Notes:

Capron 8333G HI HS BK-102 is a 33% glass reinforced, impact modified polyamide 6 injection molding compound pigmented black developed for applications requiring improved dry as molded toughness in combination with a balance of strength, stiffness and excellent moldability/surface aesthetics. Capron 8333G HI HS BK-102 is generally recommended for application such as front wheel chair wheels, bicycle wheels, power tool housings, chain saw housings, clips and fasteners, hose clamps and window hardware. Data provided by Allied Signal. Processing: Max. water content 0.12%. Product is supplied in sealed containers and drying is not required. If drying becomes necessary, a dehumidifying or desiccant dryer operating at 85°C (185 °F). Is recommended. Drying time is dependent on moisture level. Melt Temperature: 270-295 degC (518-563 degF). Mold Temperature: 80-95 degC (176-203 degF). Injection and Packing Pressure: 35-125 bar (500-1500psi) This product can be processed over a wide range of mold temperatures; however, for applications where aesthetics critical, a mold surface temperature of 80-95 degC (176-203 degF) is required. Injection pressure controls the filling of the part and should be applied for 90% of ram travel. Packing pressure affects the final part and can be used effectively in controlling sink marks and shrinkage. It should be applied and maintained until the gate area is completely frozen off. Back pressure can be utilized to provide uniform melt consistency and reduce trapped air and gas. A maximum of 3.5 bar (50 psi) is recommended to minimize glass fiber breakage. Fast fill rates are recommended to insure uniform melt delivery to the cavity and prevent premature freezing. Surface appearance is directly affected by injection rate. Capron® is no longer a part of the BASF standard line. The BASF nylon products have been consolidated in the Ultramid® line.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_BASF-Capron-8333G-HI-HS-BK-102-Impact-Modified-33-Glass-Filled-Nylon-6-Conditioned-nbspdiscontinued-.php](http://www.lookpolymers.com/polymer_BASF-Capron-8333G-HI-HS-BK-102-Impact-Modified-33-Glass-Filled-Nylon-6-Conditioned-nbspdiscontinued-.php)

| Physical Properties   | Metric       | English                   | Comments           |
|-----------------------|--------------|---------------------------|--------------------|
| Density               | 1.34 g/cc    | 0.0484 lb/in <sup>3</sup> | (Dry)              |
| Linear Mold Shrinkage | 0.0030 cm/cm | 0.0030 in/in              | ASTM Data MD (Dry) |

| Mechanical Properties      | Metric   | English   | Comments               |
|----------------------------|----------|-----------|------------------------|
| Tensile Strength, Ultimate | 90.0 MPa | 13100 psi | ASTM data at 5 mm/min. |

| Thermal Properties | Metric | English | Comments |
|--------------------|--------|---------|----------|
| Melting Point      | 220 °C | 428 °F  | (Dry)    |

| Processing Properties | Metric  | English | Comments            |
|-----------------------|---------|---------|---------------------|
| Drying Temperature    | 85.0 °C | 185 °F  | See Materials Notes |

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