

BASF Capron® 8360 HS 34% Mineral-Filled Nylon 6 (Dry) (discontinued **)

Category : Polymer , Thermoplastic , Nylon , Nylon 6 , Nylon 6, 30% Mineral Filled

Material Notes:

Capron 8360 HS is a heat stabilized 34% mineral reinforced nylon 6 injection molding resin possessing a high level of toughness and ductility combined with excellent processability and surface aesthetics. Its performance characteristics include strength and stiffness while maintaining excellent drop weight impact. It maintains its inherent chemical resistance to greases, oils and hydrocarbons. It is also available in natural, black or custom colors and can be painted. Capron 8360 HS is generally recommended for applications such as automotive fuel filter pockets, door and window hardware, wheel hubs and covers, mirror housings, and interior lighting components. ASTM Callout PA220 M34 A92120 UB041 AA002 ZP01 NNI > = 1600 J/M. 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: 270-300 degC (518-572 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-8360-HS-34-Mineral-Filled-Nylon-6-Dry-nbspdiscontinued-.php

Physical Properties	Metric	English	Comments
Density	1.43 g/cc	0.0517 lb/in ³	ISO data
Water Absorption	1.0 %	1.0 %	24 hrs; ISO data
Moisture Absorption at Equilibrium	1.8 %	1.8 %	50% RH; 23°C; ISO data
Water Absorption at Saturation	6.3 %	6.3 %	in water; 23°C; ISO data
Linear Mold Shrinkage	0.010 cm/cm	0.010 in/in	ASTM Data MD

Mechanical Properties	Metric	English	Comments
Tensile Strength, Yield	90.0 MPa	13100 psi	50 mm/min; Same value from ASTM and ISO test.
Elongation at Break	15 %	15 %	Nominal
Flexural Yield Strength	130 MPa	18900 psi	ASTM Data
Flexural Modulus	5.00 GPa	725 ksi	ASTM Data

Poissons Ratio Mechanical Properties	0.35 Metric	0.35 English	ISO data Comments
Coefficient of Friction	0.15	0.15	vs. steel.
	0.22	0.22	vs. polymer
Coefficient of Friction, Static	0.23	0.23	vs. steel.
	0.41	0.41	vs. polymer

Thermal Properties	Metric	English	Comments
CTE, linear	54.0 $\mu\text{m}/\text{m}\cdot^\circ\text{C}$	30.0 $\mu\text{in}/\text{in}\cdot^\circ\text{F}$	ASTM data
	@Temperature 20.0 $^\circ\text{C}$	@Temperature 68.0 $^\circ\text{F}$	
Melting Point	220 $^\circ\text{C}$	428 $^\circ\text{F}$	ASTM and ISO test
Deflection Temperature at 1.8 MPa (264 psi)	117 $^\circ\text{C}$	243 $^\circ\text{F}$	ASTM Data
Flammability, UL94	HB	HB	
	@Thickness 3.00 mm	@Thickness 0.118 in	

Processing Properties	Metric	English	Comments
Drying Temperature	85.0 $^\circ\text{C}$	185 $^\circ\text{F}$	See Materials Notes

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