

BASF Ultramid® Seal-Fit PA6/66 (Dry)

Category : Polymer , Thermoplastic , Nylon , Nylon 6/66 , Nylon 66/6 , Unreinforced

Material Notes:

Description: Transparent, tough, amorphous copolyamide for injection molding, specially developed for tight overmoulding of metal inlays. Information provided by BASF

Order this product through the following link:

http://www.lookpolymers.com/polymer_BASF-Ultramid-Seal-Fit-PA666-Dry.php

Physical Properties	Metric	English	Comments
Bulk Density	0.500 - 0.800 g/cc	0.0181 - 0.0289 lb/in ³	
Density	1.10 g/cc	0.0397 lb/in ³	ISO 1183
Moisture Absorption at Equilibrium	4.5 - 5.0 %	4.5 - 5.0 %	ISO 62
Viscosity Measurement	125	125	ISO 307
Linear Mold Shrinkage, Flow	0.0030 cm/cm	0.0030 in/in	ISO 2577
Linear Mold Shrinkage, Transverse	0.0030 cm/cm	0.0030 in/in	ISO 2577
Melt Flow	82.5 g/10 min	82.5 g/10 min	ISO 1133
	@Load 10.0 kg, Temperature 230 °C	@Load 22.0 lb, Temperature 446 °F	
	132 g/10 min	132 g/10 min	ISO 1133
	@Load 5.00 kg, Temperature 275 °C	@Load 11.0 lb, Temperature 527 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	85	85	ISO 868
Elongation at Yield	5.0 %	5.0 %	50mm/min; ISO 527-1/-2
Tensile Modulus	2.50 GPa	363 ksi	ISO 527-1/-2

Thermal Properties	Metric	English	Comments
CTE, linear, Parallel to Flow	80.0 - 120 µm/m-°C	44.4 - 66.7 µin/in-°F	ISO 11359-1/-2
	@Temperature 23.0 - 55.0 °C	@Temperature 73.4 - 131 °F	
CTE, linear, Transverse to Flow	80.0 - 120 µm/m-°C	44.4 - 66.7 µin/in-°F	ISO 11359-1/-2
	@Temperature 23.0 - 55.0 °C	@Temperature 73.4 - 131 °F	

Thermal Properties	Metric	English	Comments
Vicat Softening Point	68.0 °C @Load 5.10 kg	154 °F @Load 11.2 lb	ISO 306
Decomposition Temperature	>= 300 °C	>= 572 °F	
Flammability, UL94	HB @Thickness 1.60 mm	HB @Thickness 0.0630 in	
	V-2 @Thickness 3.20 mm	V-2 @Thickness 0.126 in	

Optical Properties	Metric	English	Comments
Transmission, Visible	90 %	90 %	transparent; thickness not quantified

Processing Properties	Metric	English	Comments
Processing Temperature	30.0 °C	86.0 °F	Hopper Throat
Zone 1	200 °C	392 °F	Feed Zone
Zone 2	240 °C	464 °F	Compression
Zone 3	240 °C	464 °F	Metering-zone
Zone 4	240 °C	464 °F	Nozzle
Melt Temperature	240 °C	464 °F	Optimal
	230 - 260 °C	446 - 500 °F	Injection-molding/Extrusion
Mold Temperature	20.0 - 50.0 °C	68.0 - 122 °F	Injection-molding
	40.0 °C	104 °F	Optimal
Drying Temperature	60.0 °C	140 °F	
Dry Time	8 hour	8 hour	
Moisture Content	0.030 - 0.060 %	0.030 - 0.060 %	Optimal
	<= 0.15 %	<= 0.15 %	

Descriptive Properties	Value	Comments
Commercial Status	Europe	
Ignition Temperature	>400°C	ASTM D1929

Perinbaral screw speed
Descriptive Properties

< 0.3 m/s
Value

Comments

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