

Product description

Ultramid® ONE J 60X1 V15 natural is a high temperature polyamide based on a non-halogenated flame retardant system, reinforced with 15% of glass fiber with best-in-class fire protection behavior, for injection moulding. This product has superior electrical performance compared to traditional high-performance plastics. Its low corrosion ensures processing tools longevity. This product, based on a high fluidity matrix, offers strong benefits in term of productivity and design freedom.

The data provided are based on laboratory/experimental results. These data could be adjusted after industrial production.

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 substitutive 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.

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

Preliminary Datasheet ³⁾

Typical values for uncoloured product at 23 °C ¹⁾	Test method	Unit	Values ²⁾
General Properties			
Asia Pacific	-	-	+
Processing: Injection moulding (M), Extrusion (E), Blow moulding (B)	-	-	M
Colour: black (bk), uncoloured (un), coloured (co), transparent (tr)	-	-	un
Pellets	-	-	+
Physical			
Molding shrinkage (parallel)	ISO 294-4	%	0.50
Molding shrinkage (normal)	ISO 294-4	%	1.00
Water absorption, 24 h in water, 23 °C	ISO 62	%	0.75
Moisture absorption, equilibrium 23°C/50% r.h	similar to ISO 62	%	1.70
Density	ISO 1183	kg/m ³	1300 / -
Mechanical properties			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	7600 / -
Stress at break	ISO 527-1/-2	MPa	125 / -
Strain at break	ISO 527-1/-2	%	2.8 / -
Flexural modulus	ISO 178	MPa	6300 / -
Flexural strength	ISO 178	MPa	120 / -
Charpy notched impact strength ISO 179/1eA (23°C)	ISO 179/1eA	kJ/m ²	6 / -
Charpy impact strength ISO 179-1eU (23°C)	ISO 179/1eU	kJ/m ²	47 / -
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	245
Melting temperature, DSC (10°C/min)	ISO 11357-1/-3	°C	278
RTI, electrical, d = 0.8 mm	UL-746B	°C	150
Electrical properties			dry / cond.
Electric strength (d = 0.8 mm)	IEC 60243-1	kV/mm	35 / -
Comparative tracking index, CTI, test liquid A	IEC 60112	-	600 / -
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
Burning Behav. 5V at thickness 1.6 mm	IEC 60695-11-20	class	5VA
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 (0.8 mm)	IEC 60695-2-13	°C	750
Glow Wire Ignition Temperature (1.6 mm)	IEC 60695-2-13	°C	725
Injection			
Pre/Post-processing, Pre-drying, Temperature	-	°C	80
Pre/Post-processing, max. allowed water content	-	%	0.12
Injection molding cylinder temperature 1 (feed zone)	-	°C	285 - 295
Injection molding cylinder temperature 2 (compression)	-	°C	290 - 300
Injection molding cylinder temperature 3 (metering-zone, head room of screw)	-	°C	290 - 300
injection molding, Mold temperature, range	ISO 294	°C	90 - 110

Footnotes

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

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

3) The typical values of preliminary datasheets are not statistically firm.

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