Preliminary

Processing Data Sheet

Ultramid®

A3XZC3 ESD BK23187

09/2026

PA66-I-CF15 FR(52)

We create chemistry

Product Information

An impact-modified, carbon fibre reinforced injection moulding grade with reduced surface resistivity. Flame retardance based on red
phosphorus for components requiring enhanced toughness and special requirements on electrical properties.

Physical form and storage

The product is supplied in the form of granules with a bulk density of approx. 0.7 g/cm³. Standard packs are bag and bulk container (octagonal IBC=intermediate bulk container made from corrugated board with a liner bag). Other packaging materials and shipping in road or rail silo wagons are possible by agreement. The containers should only be opened immediately before processing or drying. To ensure that the delivered product absorbs as little moisture as possible, the containers should be stored in dry rooms and always carefully closed again after partial quantities have been withdrawn. In principle, the product can be stored for a long period of time. Containers stored in cold rooms should be equalized to ambient temperature before opening in order to avoid condensation on the granules. Regardless of the storage conditions, the product should be pre-dried according to our recommendations and the machine should preferably be loaded using a closed conveyor system.

Product safety

In case processing is done under conditions as recommended (cf. processing data sheet) melts are thermally stable and do not generate hazards by molecular degradation or the evolution of gases and vapors. Like all thermoplastic polymers the product decomposes on exposure to excessive thermal load, e.g. when it is overheated or as a result of cleaning by burning off. Further information is available from the safety data sheet.

Safety instructions

Provide suitable exhaust ventilation at the drying process and in the area surrounding the melt outlet of processing machines.
Closed containers should only be opened in well-ventilated areas.
Ensure thorough ventilation of stores and work areas.

When incorrectly processing an unpleasant odour can be produced, especially when the recommended processing parameters are exceeded.
Check
- Moisture content of pellets
- Melt temperature
- Residence time

When there is a strong odour, immediately check processing parameters, ventilate the area well and recheck moisture content of material. If necessary stop processing and redry the material.

Any short stoppages in production, it is recommended that you inject material into the mould not purge an air shot.
It is advisable to dispose of purgings etc into water containers.

Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.
In order to check the availability of products please contact us or our sales agency.

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67056 Ludwigshafen, Germany

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	Test method	Unit	Values
Properties			
Polymer abbreviation	-	-	**PA66-I-CF15 FR(52)**
Density	ISO 1183	kg/m³	**1190**
Melt volume rate MVR 300 °C/10 kg	ISO 1133	cm³/10min	**7**
Injection molding			
Melt temperature range	-	°C	**280 - 300**
Mold temperature range	-	°C	**80 - 90**
Shrinkage			
Molding shrinkage (parallel)	ISO 294-4	%	**0.50**
Molding shrinkage (normal)	ISO 294-4	%	**0.55**
Processing shrinkage, constrained, longitudinal (TM = 290 °C, TW = 80 °C) [1)]	-	%	**0.4**

Footnotes
1) Model housing with central sprue, measures of the base: 107 x 47 x 1.5 mm.

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