

#### Produktbeschreibung

Elastomermodifizierte Spritzgussmarke mit hohem Zähigkeitsniveau für Clipse, Schnapp- und Befestigungselemente sowie schlagbeanspruchte Bauteile.

Abgekürzte Bezeichnung gemäß ISO 1043-1: POM-HI  
Bezeichnung gemäß ISO 29988-POM-K,,M-GCPR,3-1

#### Lieferform und Lagerung

Ultraform® is supplied in the form of granules having a bulk density of approx. 850 g/l. Standard packs are 25 kg PE bag and 800 kg Octabin (octagonal container). Ultraform® is not subject to change when it is stored in dry, ventilated rooms. After relatively long storage (>1 year) or when handling material from previously opened containers, preliminary drying is recommended in order to remove any moisture which has been absorbed.

#### Produktsicherheit

If Ultraform® is processed properly little or no formaldehyde occurs in the region of the processing machine. Measures should be taken to ensure ventilation and venting of the work area, preferably by means of an extraction hood over the barrel unit.

Ultraform® decomposes when subjected to excessive heat. The decomposition products formed in this case consist almost exclusively of formaldehyde, a gas which has a pungent smell even at very low concentrations and irritates the mucous membranes. Decomposition can rapidly result in the build-up of a high gas pressure in the barrel of the processing unit. If the die is sealed there may be a sudden release of pressure via the filling hopper.

Contamination of Ultraform® by thermoplastics that cause decomposition of polyacetals, e.g. PVC or plastics containing halogenated fire protection agents, must be avoided under all circumstances. Even small quantities can cause uncontrolled and rapid decomposition of Ultraform® during processing.

If processing with color masterbatches or functional batches is intended, the compatibility of the components must be established by suitable trials. Processing with incompatible masterbatches may result in decomposition and release of gaseous formaldehyde.

Pellets and finished parts must not be allowed to come into contact with strong acids especially concentrated hydrochloric acid) since they cause Ultraform® to decompose. Detailed safety and environmental information are contained in the Ultraform® brochure and the material safety data sheet. Both are available from the PlasticsPortal, [www.plasticsportal.net](http://www.plasticsportal.net), or the NAInfopoint under phone +1-734-324-5150 or e-mail [Infopoint.NorthAmerica@basf.com](mailto:Infopoint.NorthAmerica@basf.com).

#### Zur Beachtung

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## Verarbeitungshinweise

	Prüfnorm	Einheit	Werte
<b>Produktmerkmale</b>			
Kurzzeichen	-	-	<b>POM + PUR</b>
Dichte	ISO 1183	kg/m <sup>3</sup>	<b>1380</b>
MFR bei 190 °C und 2.16 kg	ISO 1133	g/10min	<b>7.3</b>
<b>Trocknung</b>			
Feuchte, max.	-	%	<b>0.2</b>
Trocknertemperatur <sup>1)</sup>	-	°C	<b>100</b>
Trocknungszeit	-	h	<b>3</b>
<b>Spritzgießen</b>			
Massetemperaturbereich	-	°C	<b>190 - 215</b>
Massetemperatur, optimal	-	°C	<b>200</b>
Werkzeugtemperaturbereich	-	°C	<b>60 - 80</b>
Werkzeugtemperatur, optimal	-	°C	<b>60</b>
Verweilzeit, max.	-	min	<b>10</b>
<b>Maschineneinstellungen</b>			
Temperatur Flansch (Trichter)	-	°C	<b>80</b>
Zylindertemperatur 1 (Einzug)	-	°C	<b>200</b>
Zylindertemperatur 2 (Kompression)	-	°C	<b>200</b>
Zylindertemperatur 3 (Metering-Bereich, Schneckenorraum)	-	°C	<b>200</b>
Zylindertemperatur 4 (Düse)	-	°C	<b>200</b>
Schneckenumfangsgeschwindigkeit	-	m/s	<b>0.3</b>
<b>Angaben zur Schwindung</b>			
Verarbeitungsschwindung parallel	ISO 294-4	%	<b>1.70</b>
Verarbeitungsschwindung senkrecht	ISO 294-4	%	<b>1.70</b>

### Fußnoten

1) Originalverpacktes Granulat kann grundsätzlich ohne Trocknung verarbeitet werden. Durch längere oder unsachgemäße Lagerung feucht gewordenen Granulat muss in geeigneten Trockengeräten, z.B. Trockenlufttrocknern, getrocknet werden.