

Product description

Ultramid® STAR AF 218 V35 Black 21N is a polyamide 6.6, high flow, reinforced with 35% of glass fiber, heat stabilized, for injection moulding. Due to its outstanding flow characteristics, this grade shows exceptional processing behaviour and excellent surface aspect of the finished part. This grade is ideal for use in the automotive industry for engine components. This grade is ideal for Mucell® injection moulding technology.

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:

- For reinforced polyamides, BASF SE recommends the use of steel with a high content of carbon, and purified for polishing, to avoid or limit the abrasion. For example: X38CrMoV5-1 (EN Norm) - 1.2367 /1.2343 (DIN Norm) or X160CrMoV12 (EN Norm) - 1.2601 /1.2379 (DIN Norm). 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.

This grade complies with RoHS Directive 2011/65/EU, 2015/863 and local regulations as amended.

Grades produced or imported in Europe comply with REACH directive 1907/2006/EC as amended.

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

Processing Data Sheet

| | Test method | Unit | Values |
|---|-------------|-------------------|------------------|
| Properties | | | |
| Polymer abbreviation | - | - | PA66-GF35 |
| Density | ISO 1183 | kg/m ³ | 1410 |
| Drying | | | |
| Moisture, max. | - | % | 0.2 |
| Dryer temperature ¹⁾ | - | °C | 80 |
| Injection molding | | | |
| Mold temperature range | - | °C | 60 - 90 |
| Machine Settings | | | |
| Cylinder temperature 1 (feed zone) | - | °C | 265 - 275 |
| Cylinder temperature 2 (compression) | - | °C | 270 - 280 |
| Cylinder temperature 3 (metering-zone, in front of the screw) | - | °C | 280 - 290 |
| Shrinkage | | | |
| Molding shrinkage (parallel) | ISO 294-4 | % | 0.30 |
| Molding shrinkage (normal) | ISO 294-4 | % | 1.00 |

Footnotes

1) Dry air dryer; drying time is dependent on the initial moisture content of the granules, drying temperature and the dew point of the dried air.

BASF SE

67056 Ludwigshafen, Germany