

#### Product description

Heat stabilized, partially aromatic polyphthalamide for injection molding with strong mechanical properties especially at elevated temperatures and excellent chemical resistance for highly stressed parts. Ultramid® Advanced T1000 HG7 can be characterized as compound with high strength and stiffness, very low water absorption and outstanding dimensional stability. It features a high melting point (320°C) and excellent melt stability.

#### Markets & applications

Automotive: Fuel system, cooling system, powertrain, thermostat housing, pumps, fuel cell

E&E: Sensors, SMT (surface mount technology) applications

Industry goods: Pumps, compressors

Consumer goods: Home appliances, consumer electronics, furniture fittings

#### Physical form and storage

The product is supplied in the form of granules with a bulk density of approx. 0.7 g/cm<sup>3</sup>. 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the containers should be stored in dry rooms and always carefully closed again after partial quantities have been withdrawn.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.

#### 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.

## Product Information

Typical values for uncoloured product at 23 °C <sup>1)</sup>	Test method	Unit	Values <sup>2)</sup>
<b>Properties</b>			
Polymer abbreviation	-	-	PA6T/6I GF35
Density	ISO 1183	kg/m <sup>3</sup>	1490
Viscosity number (0.5% in 96% H <sub>2</sub> SO <sub>4</sub> )	ISO 307, 1157, 1628	cm <sup>3</sup> /g	110
<b>Processing</b>			
Melting temperature, DSC	ISO 11357-1/-3	°C	320
Melt temperature, injection moulding/extrusion	-	°C	335 - 355
Mould temperature, injection moulding	-	°C	140 - 170
Molding shrinkage (parallel)	ISO 294-4	%	0.40
Molding shrinkage (normal)	ISO 294-4	%	0.90
Test specimen production, injection moulding, melt temp.	ISO 294	°C	350
Test specimen production, injection moulding, mould temp.	ISO 294	°C	150
<b>Mechanical properties</b>			
Tensile modulus (23°C)	ISO 527-1/-2	MPa	14000 / 14000
Stress at break (23°C)	ISO 527-1/-2	MPa	240 / 220
Strain at break (23°C)	ISO 527-1/-2	%	2.2 / 2.1
Tensile modulus (80°C)	ISO 527-1/-2	MPa	13000 / -
Stress at break (80°C)	ISO 527-1/-2	MPa	200 / -
Strain at break (80°C)	ISO 527-1/-2	%	2.2 / -
Tensile modulus (120°C)	ISO 527-1/-2	MPa	12000 / -
Stress at break (120°C)	ISO 527-1/-2	MPa	150 / -
Strain at break (120°C)	ISO 527-1/-2	%	2.4 / -
Tensile modulus (170°C)	ISO 527-1/-2	MPa	5000 / -
Stress at break (170°C)	ISO 527-1/-2	MPa	75 / -
Bruchdehnung (170°C)	ISO 527-1/-2	%	6 / -
Charpy unnotched impact strength (-30°C)	ISO 179/1eU	kJ/m <sup>2</sup>	65 / -
Charpy unnotched impact strength (23°C)	ISO 179/1eU	kJ/m <sup>2</sup>	75 / 55
Charpy impact strength (80°C)	ISO 179/1eU	kJ/m <sup>2</sup>	75 / -
Charpy impact strength (120°C)	ISO 179/1eU	kJ/m <sup>2</sup>	75 / -
Charpy impact strength (170°C)	ISO 179/1eU	kJ/m <sup>2</sup>	85 / -
Charpy notched impact strength (-30°C)	ISO 179/1eA	kJ/m <sup>2</sup>	9 / -
Charpy notched impact strength (23°C)	ISO 179/1eA	kJ/m <sup>2</sup>	10 / 7
Flexural modulus (23°C)	ISO 178	MPa	12000 / 12000
Flexural strength	ISO 178	MPa	300 / 270
<b>Thermal properties</b>			
Deflection temp. under load 1.8 MPa (HDT A)	ISO 75-1/-2	°C	> 280
Coefficient of linear thermal expansion, longitudinal (23-55)°C	ISO 11359-1/-2	E-6/K	22 - 22
Coefficient of linear thermal expansion, transverse (23-55)°C	ISO 11359-1/-2	E-6/K	51 - 53
<b>Electrical properties</b>			
Volume resistivity	IEC 62631-3-1	Ohm*m	>1E14 / >1E14
Surface resistivity	IEC 62631-3-2	Ohm	- / >1E15
Electric strength K20/K20, (60*60*1 mm <sup>3</sup> )	IEC 60243-1	kV/mm	48 / -
Comparative tracking index, CTI, test liquid A	IEC 60112	-	600
Dissipation factor (1 MHz)	IEC 62631-2-1	E-4	110 / 20
Relative permittivity (1 MHz)	IEC 62631-2-1	-	4.6 / 3.6

### Footnotes

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

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

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