

Product description

Ultramid® A 218W V33 Natural T is a polyamide 66, reinforced with 33% of glass fibre, heat stabilized, for injection moulding. The product is particularly recommended for the moulding of parts where some translucency is required, as well as surface aesthetics is important.

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.

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

	Test method	Unit	Values
Properties			
Polymer abbreviation	-	-	PA66-GF33
Density	ISO 1183	kg/m³	1400
Drying			
Moisture, max.	-	%	0.2
Dryer temperature ¹⁾	-	°C	80
Injection molding			
Mold temperature range	-	°C	70 - 100
Machine Settings			
Cylinder temperature 1 (feed zone)	-	°C	270 - 280
Cylinder temperature 2 (compression)	-	°C	275 - 285
Cylinder temperature 3 (metering-zone, in front of the screw)	-	°C	280 - 290

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.

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