

# Ultramid® T KR 4355 G8 FC BK23262

Polyamide 6/6T Copolymer

BASF Corporation

## Message:

The BASF Ultramid® FC (Food Contact) grades enable the industry to develop products for food contact applications which are in compliance with multiple regional food contact regulations including FDA, European Food Contact (EU) Nr. 11/2011 and GMP (EC) n°2023/2006.

Additional food contact compliances may also be available. Please contact your local representative or plastics safety (E-Mail: [plastics.safety@basf.com](mailto:plastics.safety@basf.com), Fax: +49 621-60-93253).

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Features	Compliance of Food Exposure		
Uses	Non-specific food applications		
Agency Ratings	EC 1907/2006 (REACH)		
	EC 2023/2006		
	FDA Food Exposure, Not Rated		
	European food contact, not rated		
RoHS Compliance	RoHS compliance		
Appearance	Black		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.90	%	ISO 294-4
Flow direction	0.30	%	ISO 294-4
Mold Shrinkage - constrained <sup>1</sup>	0.45	%	
Maximum operating temperature-short cycle operation	260	°C	
Screw Speed		mm/sec	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13500	MPa	ISO 527-2
Tensile Stress (Break)	230	MPa	ISO 527-2
Tensile Strain (Break)	2.5	%	ISO 527-2
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.0	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	80	kJ/m <sup>2</sup>	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	250	°C	ISO 75-2/A
Melting Temperature	294	°C	ISO 11357-3

Injection	Nominal Value	Unit
Drying Temperature	110	°C
Drying Time	8.0	hr
Suggested Max Moisture	0.15	%
Hopper Temperature	80.0	°C
Rear Temperature	300	°C
Middle Temperature	310	°C
Front Temperature	320	°C
Nozzle Temperature	320	°C
Processing (Melt) Temp	310 - 330	°C
Mold Temperature	80.0 - 120	°C

#### Injection instructions

Residence Time: <10 min.

#### NOTE

1. Test box with central gating,  
dimensions of base (107\*47\*1,5)  
mm, processing condition: TM =  
320°C (unreinforced) or 330°C  
(reinforced), TW = 80°C

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#### Recommended distributors for this material

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