

Ultramid® 1503-2 NF2004

Polyamide 66

BASF Corporation

Message:

Ultramid 1503-2 NF2004 is a 33% glass reinforced, heat stabilized injection molding PA6/6.

General Information				
UL YellowCard		E36632-317186		
Filler / Reinforcement		Glass Fiber,33% Filler by Weight		
Additive		Heat Stabilizer		
Features		Heat Stabilized		
Agency Ratings		EC 1907/2006 (REACH)		
RoHS Compliance		RoHS Compliant		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.40	--	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage - Flow (3.18 mm)	0.30	--	%	
Water Absorption				
Saturation	5.7	--	%	ASTM D570
Saturation, 23°C	5.7	--	%	ISO 62
Equilibrium, 50% RH	1.7	--	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.7	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus (23°C)	10800	7400	MPa	ISO 527-2
Tensile Strength				
Break, 23°C	193	--	MPa	ASTM D638
Break, 23°C	210	145	MPa	ISO 527-2
Tensile Elongation				
Break, 23°C	3.0	--	%	ASTM D638
Break, 23°C	3.0	5.0	%	ISO 527-2
Flexural Modulus				
23°C	8280	--	MPa	ASTM D790
23°C	9900	6300	MPa	ISO 178
Flexural Strength (23°C)	276	--	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179
-30°C	11	11	kJ/m ²	

23°C	12	15	kJ/m ²	
Charpy Unnotched Impact Strength				ISO 179
-30°C	75	75	kJ/m ²	
23°C	90	100	kJ/m ²	
Notched Izod Impact				
23°C	120	--	J/m	ASTM D256
23°C	11	15	kJ/m ²	ISO 180
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				
0.45 MPa, Unannealed	297	--	°C	ASTM D648
0.45 MPa, Unannealed	264	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	252	--	°C	ASTM D648
1.8 MPa, Unannealed	255	--	°C	ISO 75-2/A
Peak Melting Temperature	260	--	°C	ASTM D3418, ISO 3146
Injection	Dry	Unit		
Drying Temperature	60.0		°C	
Drying Time	1.0 to 2.0		hr	
Suggested Max Moisture	0.040 to 0.20		%	
Processing (Melt) Temp	288 to 305		°C	
Mold Temperature	60.0 to 100		°C	
Injection Pressure	3.50 to 12.5		MPa	
Injection Rate	Fast			
Back Pressure	0.00 to 0.350		MPa	
Screw Speed	40 to 80		rpm	
Screw Compression Ratio	3.0:1.0 to 4.0:1.0			

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