

UBE UBESTA® 3035LU1 Rigid Piping Grade Nylon 12

Category : Polymer , Thermoplastic , Nylon , Nylon 12

Material Notes:

Description: UBESTA contributes to the field of Utilities such as plastic pipe system evolutionary developed for gas industry. It is used for both burial and for rehabilitation of existing cast iron and steel gas mains. The excellent performance, especially creep and chemical resistance UBESTA supports industry as one of the most reliable materials. Comments: heat resistance, black color Information provided by UBE.

Order this product through the following link:

http://www.lookpolymers.com/polymer_UBE-UBESTA-3035LU1-Rigid-Piping-Grade-Nylon-12.php

Physical Properties	Metric	English	Comments
Density	1.02 g/cc	0.0368 lb/in ³	ASTM D792
Melt Flow	1.3 g/10 min @Load 2.16 kg, Temperature 235 °C	1.3 g/10 min @Load 4.76 lb, Temperature 455 °F	ASTM D1238R

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	112	112	ASTM D785
Tensile Strength at Break	>= 56.0 MPa	>= 8120 psi	ASTM D638
Tensile Strength, Yield	46.0 MPa	6670 psi	ASTM D638
Elongation at Break	>= 250 %	>= 250 %	ASTM D638
Flexural Strength	61.0 MPa	8850 psi	ASTM D790
Flexural Modulus	1.59 GPa	231 ksi	ASTM D790
Izod Impact, Notched	0.900 J/cm	1.69 ft-lb/in	ASTM D256

Thermal Properties	Metric	English	Comments
Melting Point	178 °C	352 °F	ASTM D3418
Deflection Temperature at 0.46 MPa (66 psi)	149 °C	300 °F	ASTM D648

Processing Properties	Metric	English	Comments
Processing Temperature	230 °C	446 °F	Flange Temperature for T-Die Cast Film Extrusion
Feed Temperature	40.0 °C	104 °F	Injection Molding
Zone 1	190 °C	374 °F	For T-Die Cast Film Extrusion

Processing Properties	Metric 230 °C	English 446 °F	Comments For 8x1 mm Tube Extrusion
Zone 2	210 °C	410 °F	For T-Die Cast Film Extrusion
	225 °C	437 °F	For 8x1 mm Tube Extrusion
Zone 3	220 °C	428 °F	For 8x1 mm Tube Extrusion
	230 °C	446 °F	For T-Die Cast Film Extrusion
Zone 4	215 °C	419 °F	For 8x1 mm Tube Extrusion
Die Temperature	230 °C	446 °F	For T-Die Cast Film Extrusion
Mold Temperature	40.0 - 60.0 °C	104 - 140 °F	Injection Molding
Injection Velocity	100 mm/sec	3.94 in/sec	Injection Molding
Die Opening	0.0400 cm	0.0157 in	For T-Die Cast Film Extrusion
Roll Temperature	50.0 °C	122 °F	Chill Roll Temperature for T-Die Cast Film Extrusion
Drying Temperature	80.0 °C	176 °F	Option 1
	100 °C	212 °F	Option 2
	110 °C	230 °F	Option 3
Dry Time	2 - 4 hour	2 - 4 hour	Option 3
	4 - 6 hour	4 - 6 hour	Option 2
	6 - 8 hour	6 - 8 hour	Option 1
Injection Pressure	40.0 - 50.0 MPa	5800 - 7250 psi	Injection Molding (Injection pressure should be increased when molding thin wall parts. Pressure up to 75 bar can be used here.)
Hold Pressure	25.0 - 50.0 MPa	3630 - 7250 psi	Injection Molding
Back Pressure	5.00 MPa	725 psi	Injection Molding
Screw Speed	15 - 76 rpm	15 - 76 rpm	For 8x1 mm Tube Extrusion

Descriptive Properties	Value	Comments
C/R	3-3.5:1	For 8x1 mm Tube Extrusion
Calibrating Vacuum	100 mbar	For 8x1 mm Tube Extrusion
Calibration	9.95 mm	For 8x1 mm Tube Extrusion
Compression Ratio	2.5-3.5:1	Injection Molding

Descriptive Properties	Value min 3:1	Comments For 8x1 mm Tube Extrusion
Die Diameter	16 mm	For 8x1 mm Tube Extrusion
Die Width	300 mm	For T-Die Cast Film Extrusion
Extruder	Barmag, Screw Diameter = 30 mm	For T-Die Cast Film Extrusion
Extruder Characteristics	65 mm screw diameter	For 8x1 mm Tube Extrusion
Film Thickness	60 microns	For T-Die Cast Film Extrusion
Flight Depth in the Feeding Zone	10-15% of Screw Diameter	Injection Molding
Flight Depth in the Metering Zone	5-7% of Screw Diameter	Injection Molding
Haul Off Speed	5 m/min	For T-Die Cast Film Extrusion
Haul Speed	10-55 m/min	For 8x1 mm Tube Extrusion
L/D Ratio	25:1	For 8x1 mm Tube Extrusion
	min 20:1	Injection Molding
Length of Compression Zone	25-45% of total screw length	Injection Molding
	30% of screw length	For 8x1 mm Tube Extrusion
Length of Feeding Zone	20-40% of total screw length	Injection Molding
	30-40% of screw length	For 8x1 mm Tube Extrusion
Length of Metering Zone	30-45% of screw length	For 8x1 mm Tube Extrusion
	35-45% of total screw length	Injection Molding
Mandrel Diameter	12 mm	For 8x1 mm Tube Extrusion
Peripheral screw speed	10 m/min	Injection Molding
Water Temperature	10-18°C	For 8x1 mm Tube Extrusion

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