

ECOMID® B BK 9005/1

ECOMID®

Product information

| | | |
|----------------------|-------|-----------|
| Resin Identification | PA6 | ISO 1043 |
| Part Marking Code | >PA6< | ISO 11469 |

Typical mechanical properties

| | dry/cond. | | |
|--------------------------------------|----------------------------|-------------------|--------------|
| Tensile modulus | 3300 / 1400 | MPa | ISO 527-1/-2 |
| Tensile stress at yield, 50mm/min | 70 / 40 | MPa | ISO 527-1/-2 |
| Tensile strain at break, 50mm/min | 16 / 20 | % | ISO 527-1/-2 |
| Flexural modulus | 2800 / - | MPa | ISO 178 |
| Flexural strength | 100 / - | MPa | ISO 178 |
| Charpy notched impact strength, 23°C | 5 / 10 | kJ/m ² | ISO 179/1eA |
| Poisson's ratio | 0.37 / 0.43 ^[C] | | |

[C]: Calculated

Physical/Other properties

| | dry/cond. | | |
|--------------------------|-----------|-------------------|----------------|
| Humidity absorption, 2mm | 2.6 / * | % | Sim. to ISO 62 |
| Water absorption, 2mm | 9.3 / * | % | Sim. to ISO 62 |
| Density | 1130 / - | kg/m ³ | ISO 1183 |

Injection

| | |
|---------------------------------|----------|
| Drying Recommended | yes |
| Drying Temperature | 80 °C |
| Drying Time, Dehumidified Dryer | 2 - 4 h |
| Processing Moisture Content | ≤0.15 % |
| Melt Temperature Optimum | 260 °C |
| Min. melt temperature | 235 °C |
| Max. melt temperature | 270 °C |
| Screw tangential speed | ≤0.3 m/s |
| Mold Temperature Optimum | 70 °C |
| Min. mould temperature | 50 °C |
| Max. mould temperature | 100 °C |

Characteristics

| | |
|------------|--------------------|
| Processing | Injection Moulding |
|------------|--------------------|

Automotive

| OEM | STANDARD | ADDITIONAL INFORMATION |
|----------|----------|---|
| VW Group | VW 50125 | *Best Fitting Grade To PA6-1, Not Officially Approved |
| VW Group | VW 50134 | *Best Fitting Grade To PA6-1, Not Officially Approved |