

# ECOMID® B GF25 BK 9011

## ECOMID®

General purpose grade designed for Automotive and Industrial applications.

### Product information

Resin Identification	PA6-GF25	ISO 1043
Part Marking Code	>PA6-GF25<	ISO 11469

### Rheological properties

	dry/cond.		
Viscosity number	125/*	cm <sup>3</sup> /g	ISO 307, 1628
Moulding shrinkage range, parallel	0.3 - 0.7	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 - 1.1	%	ISO 294-4, 2577

### Typical mechanical properties

	dry/cond.		
Tensile modulus	7600 / 4500	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	125 / 70	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.7 / 5	%	ISO 527-1/-2
Charpy impact strength, 23°C	35 / 45	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	5 / 7	kJ/m <sup>2</sup>	ISO 179/1eA
Ball indentation hardness, H 961/30	160 / -	MPa	ISO 2039-1
Poisson's ratio	0.34 / 0.36 <sup>[C]</sup>		

[C]: Calculated

### Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	225/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	205/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	215/*	°C	ISO 75-1/-2

### Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB/*	class	IEC 60695-11-10

### Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.9/*	%	Sim. to ISO 62
Water absorption, 2mm	6.8/*	%	Sim. to ISO 62
Density	1310 / -	kg/m <sup>3</sup>	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	250 °C
Min. melt temperature	235 °C
Max. melt temperature	280 °C
Screw tangential speed	≤0.2 m/s
Mold Temperature Optimum	80 °C
Min. mould temperature	60 °C
Max. mould temperature	120 °C

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### Characteristics

Processing	Injection Moulding
Delivery form	Granules

### Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
VW Group	VW 50125	*Best Fitting Grade To PA6-6, Not Officially Approved
VW Group	VW 50134	*Best Fitting Grade to PA6-6-A, Not Officially Approved