

ECOMID® B GF30 BK 9011/U

ECOMID®

General purpose grade designed for Automotive and Industrial applications

Product information

Resin Identification	PA6-GF30	ISO 1043
Part Marking Code	>PA6-GF30<	ISO 11469
Continuous Service Temperature	100 °C	IEC 60216-1

Rheological properties

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	9000/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	130/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5/-	%	ISO 527-1/-2
Charpy impact strength, 23°C	35/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	5/-	kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 961/30	165/-	MPa	ISO 2039-1
Poisson's ratio	0.34/- ^[C]		

[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	200/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	215/*	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.8/*	%	Sim. to ISO 62
Water absorption, 2mm	6.3/*	%	Sim. to ISO 62
Density	1350/-	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	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

Characteristics

Processing	Injection Moulding
Delivery form	Granules