

# ECOMID® B GF33 BK 269/1

ECOMID®

## Product information

Resin Identification	PA6-GF33	ISO 1043
Part Marking Code	>PA6-GF33<	ISO 11469

## Typical mechanical properties

Tensile modulus	11000 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	145 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.2 %	ISO 527-1/-2
Flexural modulus	10000 MPa	ISO 178
Flexural strength	230 MPa	ISO 178
Charpy notched impact strength, 23°C	8 kJ/m <sup>2</sup>	ISO 179/1eA
Poisson's ratio	0.34 <sup>[C]</sup>	

[C]: Calculated

## Thermal properties

Temperature of deflection under load, 1.8 MPa	210 °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	218 °C	ISO 75-1/-2

## Physical/Other properties

Density	1380 kg/m <sup>3</sup>	ISO 1183
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## 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
Special characteristics	Specialty appearance

## Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
VW Group	VW 50125	*Best Fitting Grade To PA6-8, Not Officially Approved