

ECOMID® B GF33 BK 9005/1A

ECOMID®

Product information

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

Typical mechanical properties

	dry/cond.		
Tensile modulus	11500/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	155/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.1/-	%	ISO 527-1/-2
Flexural modulus	10800/-	MPa	ISO 178
Flexural strength	240/-	MPa	ISO 178
Charpy notched impact strength, 23°C	8.5/-	kJ/m ²	ISO 179/1eA
Poisson's ratio	0.33/- ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
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

	dry/cond.		
Density	1390/-	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
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