Celanese
The chemistry inside innovation™

ECOMID® B H GF30 BK 9004/2

ECOMID®

General purpose grade designed for Automotive and Industrial applications. Based on recycled polyamide resin.

Product information

Resin Identification	PA6-GF30		ISO 1043
Part Marking Code	>PA6-GF30<		ISO 11469
Continuous Service Temperature	110	°C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	0.3 - 0.6	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 - 0.9	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	9300 / 5500	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	140 / 85	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5 / 4	%	ISO 527-1/-2
Charpy impact strength, 23°C	50 / >50	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	7 / 12	kJ/m²	ISO 179/1eA
Poisson's ratio	0.34 / 0.35[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	205 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	218 / *	°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	1360 / -	kg/m³	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

Celanese
The chemistry inside innovation™

ECOMID® B H GF30 BK 9004/2

ECOMID®

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	Heat stabilised or stable to heat