Celanese
The chemistry inside innovation™

ECOMID® B HH GF13 BK 2000/UV/1

ECOMID®

Product information

Resin Identification	PA6-GF13	ISO 1043
Part Marking Code	>PA6-GF13<	ISO 11469

Typical mechanical properties

Tensile modulus	6200	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	110	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.2	%	ISO 527-1/-2
Flexural modulus	5550	MPa	ISO 178
Flexural strength	180	MPa	ISO 178
Charpy notched impact strength, 23 °C	4.1	kJ/m²	ISO 179/1eA
Poisson's ratio	0.35[C]		

[C]: Calculated

Physical/Other properties

Density	1220	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

Characteristics

Processing	Injection Moulding
Special characteristics	U.V. stabilised or stable to weather, Heat stabilised or stable to heat