

ECOMID® B HH GF30 BK 9005/1P

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Product information

Resin Identification	PA6-GF30	ISO 1043
Part Marking Code	>PA6-GF30<	ISO 11469

Rheological properties

	dry/cond.		
Melt volume-flow rate	40/*	cm ³ /10min	ISO 1133
Temperature	275/*	°C	
Load	5/*	kg	
Moulding shrinkage, parallel	0.2/-	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.7/-	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	10000/6000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	137/85	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.8/8	%	ISO 527-1/-2
Flexural modulus	8500/5000	MPa	ISO 178
Flexural strength	210/120	MPa	ISO 178
Charpy impact strength, 23°C	50/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	6/12	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -40°C	5.5/-	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	6/-	kJ/m ²	ISO 180/1A
Izod impact strength, 23°C	40/-	kJ/m ²	ISO 180/1U
Hardness, Rockwell, M-scale	95/-		ISO 2039-2
Poisson's ratio	0.39/- ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	220/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	204/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	219/*	°C	ISO 75-1/-2

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB/*	class	IEC 60695-11-10
FMVSS Class	B		ISO 3795 (FMVSS 302)
Burning rate, Thickness 1 mm	48.4	mm/min	ISO 3795 (FMVSS 302)

Physical/Other properties

	dry/cond.		
Water absorption, Immersion 24h	1.54/*	%	Sim. to ISO 62
Density	1360/-	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 %

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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	Heat stabilised or stable to heat

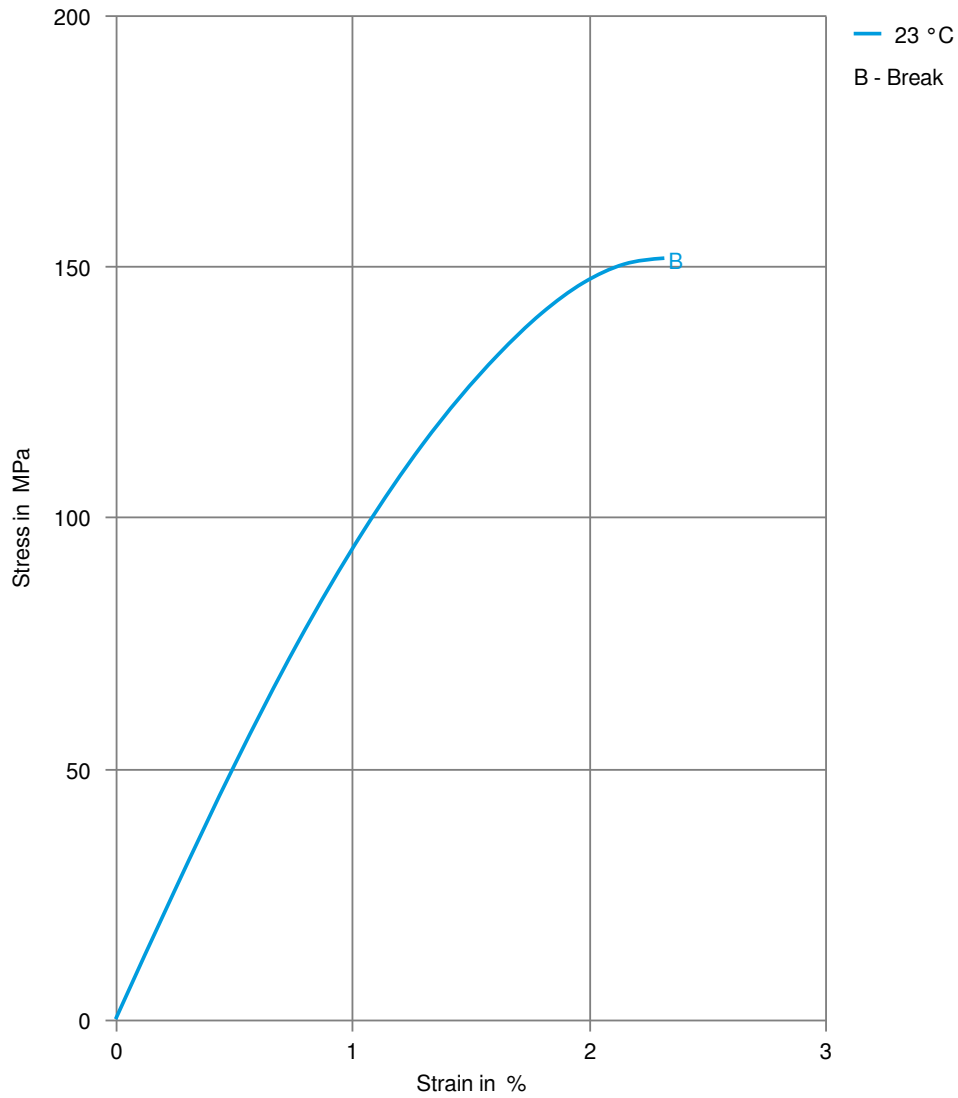
Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
VW Group	VW 50125	*Best Fitting Grade To PA6-7, Not Officially Approved
VW Group	VW 50134	*Best Fitting Grade To PA6-7-A, Not Officially Approved

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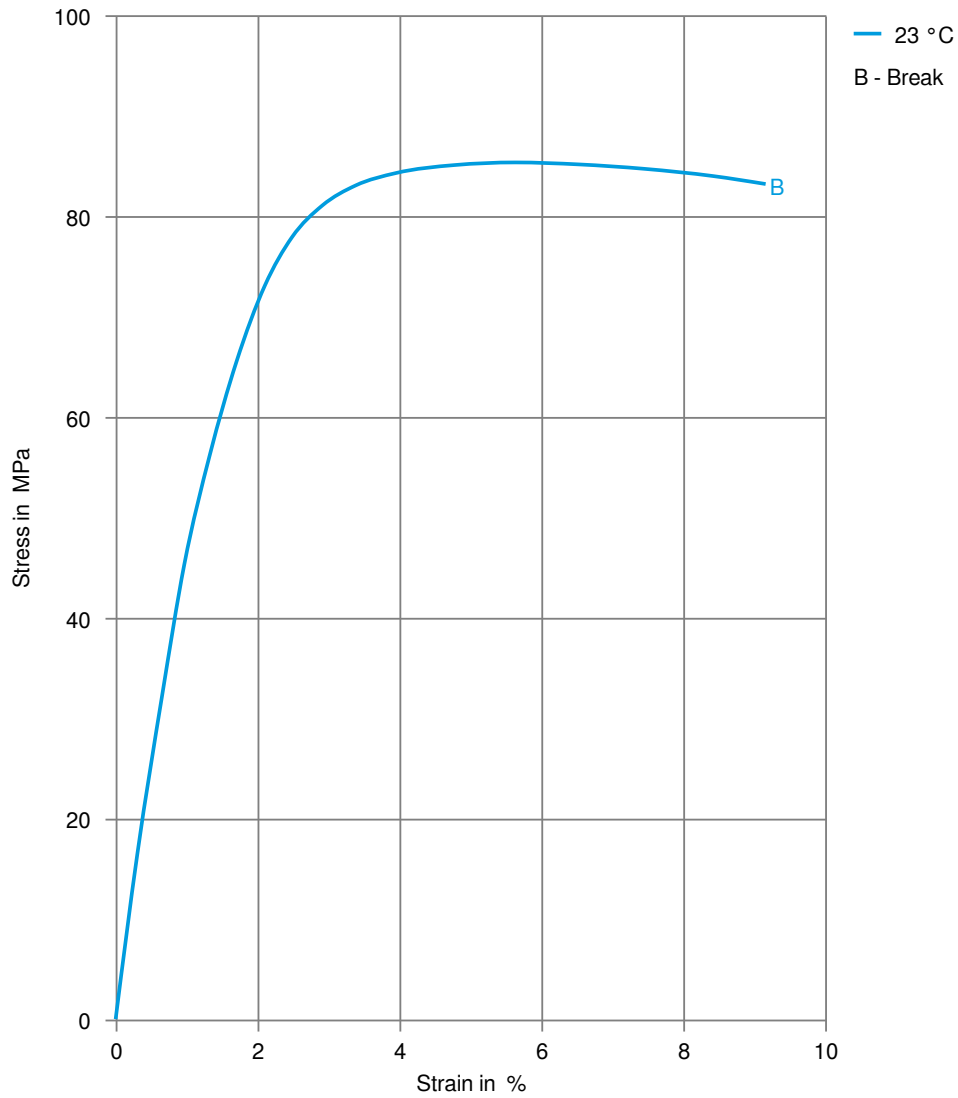
Stress-strain (dry)



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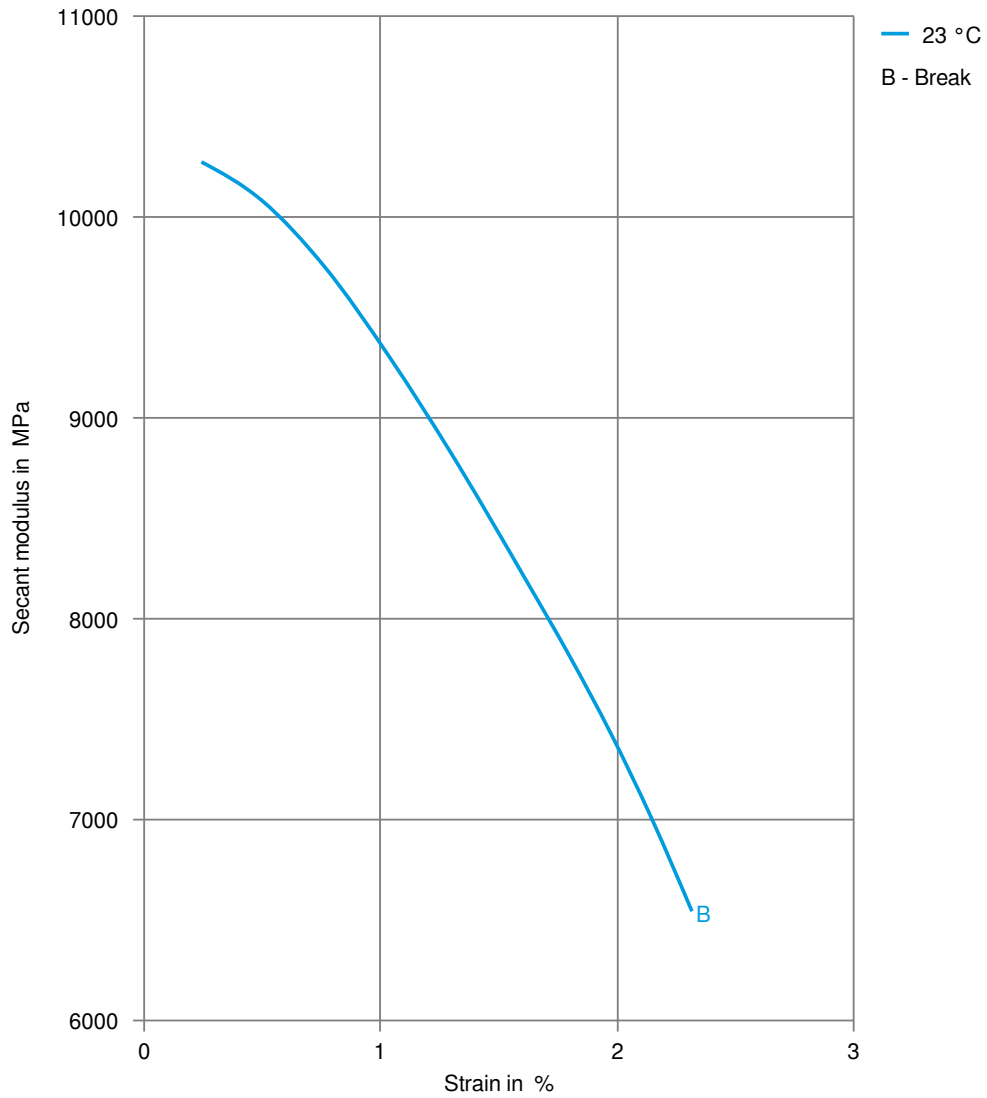
Stress-strain (cond.)



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Secant modulus-strain (dry)



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Secant modulus-strain (cond.)

