Celanese
The chemistry inside innovation™

# ECOMID® B HH MGF3010 BK 2000/UV/1

ECOMID®

## Product information

| | | |
|---|---|---|
| Resin Identification | PA6-(MD+GF)40 | ISO 1043 |
| Part Marking Code | >PA6-(MD+GF)40< | ISO 11469 |

## Typical mechanical properties

| | dry/cond. | | |
|---|---|---|---|
| Tensile modulus | 10000 / - | MPa | ISO 527-1/-2 |
| Tensile stress at break, 5mm/min | 110 / - | MPa | ISO 527-1/-2 |
| Tensile strain at break, 5mm/min | 2 / - | % | ISO 527-1/-2 |
| Flexural modulus | 9000 / - | MPa | ISO 178 |
| Flexural strength | 170 / - | MPa | ISO 178 |
| Charpy impact strength, 23°C | 43 / - | kJ/m² | ISO 179/1eU |
| Charpy notched impact strength, 23°C | 5.3 / - | kJ/m² | ISO 179/1eA |
| Poisson's ratio | 0.34 / -[C] | | |

[C]: Calculated

## Physical/Other properties

| | dry/cond. | | |
|---|---|---|---|
| Density | 1480 / - | 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 | 285 | °C |
| Min. melt temperature | 275 | °C |
| Max. melt temperature | 295 | °C |
| Screw tangential speed | ≤0.2 | m/s |
| Mold Temperature Optimum | 100 | °C |
| Min. mould temperature | 70 | °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, Low Warpage |