Celanese
The chemistry inside innovation™

ECOMID® A H D9 M15 GY 7002/2

ECOMID®

Product information

Resin Identification	(PA66+I)-MD15	ISO 1043
Part Marking Code	>(PA66+I)-MD15<	ISO 11469
Continuous Service Temperature	120 °C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	0.4 - 0.8 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.8 - 1.2 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	2900 / -	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	65 / -	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	15 / -	%	ISO 527-1/-2
Flexural modulus	2600 / -	MPa	ISO 178
Flexural strength	85 / -	MPa	ISO 178
Charpy impact strength, 23 °C	120 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23 °C	5 / -	kJ/m²	ISO 179/1eA
Poisson's ratio	0.37 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	260 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	67 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.6 / *	%	Sim. to ISO 62
Water absorption, 2mm	5.8 / *	%	Sim. to ISO 62
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	295	°C
Min. melt temperature	285	°C
Max. melt temperature	305	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	80	°C
Min. mould temperature	50	°C
Max. mould temperature	100	°C
Ejection temperature	222	°C

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Characteristics

Processing	Injection Moulding
Delivery form	Granules
Additives	Mineral Filler
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat