Celanese
The chemistry inside innovation™

ECOMID® A H GF30 BK 9004/2B

ECOMID®

Designed for Automotive Industry, suitable for many other technological applications.Good combination of mechanical and thermal performances.

Product information

Resin Identification	PA66-GF30	ISO 1043
Part Marking Code	>PA66-GF30<	ISO 11469

Rheological properties

	dry/cond.		
Melt volume-flow rate	30 / *	cm^3/10min	ISO 1133
Temperature	275 / *	°C	
Load	5 / *	kg	
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	9800 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	150 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5 / -	%	ISO 527-1/-2
Charpy impact strength, 23°C	45 / -	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	6 / -	kJ/m^2	ISO 179/1eA
Poisson's ratio	0.34 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	265 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	240 / *	°C	ISO 75-1/-2

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.6 / *	%	Sim. to ISO 62
Water absorption, 2mm	5.8 / *	%	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	%
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

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Max. mould temperature	120	°C

Characteristics

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