

ECOMID® A H J10 NC 1102/A

ECOMID®

General purpose grade, designed for Automotive industry, medium toughness. Typically used for fitting elements.

Product information

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

Rheological properties

| | | | |
|------------------------------|-----------|---|-----------------|
| | dry/cond. | | |
| Moulding shrinkage, parallel | 1.4/- | % | ISO 294-4, 2577 |
| Moulding shrinkage, normal | 1.4/- | % | ISO 294-4, 2577 |

Typical mechanical properties

| | | | |
|-------------------------------------|-----------------------|-------------------|--------------|
| | dry/cond. | | |
| Tensile modulus | 2200/- | MPa | ISO 527-1/-2 |
| Tensile stress at yield, 50mm/min | 50/- | MPa | ISO 527-1/-2 |
| Tensile strain at yield, 50mm/min | 5/- | % | ISO 527-1/-2 |
| Tensile strain at break, 50mm/min | 30/- | % | ISO 527-1/-2 |
| Flexural modulus | 2000/- | MPa | ISO 178 |
| Flexural strength | 75/- | MPa | ISO 178 |
| Charpy impact strength, 23°C | N/- | kJ/m ² | ISO 179/1eU |
| Izod notched impact strength, 23°C | 18/- | kJ/m ² | ISO 180/1A |
| Izod notched impact strength, -30°C | 9.0/- | kJ/m ² | ISO 180/1A |
| Poisson's ratio | 0.39/- ^[C] | | |

[C]: Calculated

Thermal properties

| | | | |
|------------------------------------------------|-----------|----|-------------|
| | dry/cond. | | |
| Temperature of deflection under load, 1.8 MPa | 65/* | °C | ISO 75-1/-2 |
| Temperature of deflection under load, 0.45 MPa | 190/* | °C | ISO 75-1/-2 |

Physical/Other properties

| | | | |
|--------------------------|-----------|-------------------|----------------|
| | dry/cond. | | |
| Humidity absorption, 2mm | 1.8/* | % | Sim. to ISO 62 |
| Water absorption, 2mm | 7/* | % | Sim. to ISO 62 |
| Density | 1080/- | 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 | 290 °C |
| Min. melt temperature | 280 °C |
| Max. melt temperature | 300 °C |
| Screw tangential speed | ≤0.4 m/s |
| Mold Temperature Optimum | 70 °C |
| Min. mould temperature | 50 °C |
| Max. mould temperature | 90 °C |

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Characteristics

Processing

Injection Moulding

Special characteristics

High impact or impact modified, Heat stabilised or stable to heat