Celanese
The chemistry inside innovation™

ECOMID® A HH BK 9005/1

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Product information

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

Typical mechanical properties

	dry/cond.		
Tensile modulus	3300 / 1800	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	70 / 45	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	10 / 10	%	ISO 527-1/-2
Flexural modulus	2900 / -	MPa	ISO 178
Flexural strength	120 / -	MPa	ISO 178
Charpy notched impact strength, 23 °C	4.5 / 11	kJ/m²	ISO 179/1eA
Poisson's ratio	0.37 / 0.41[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	66 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	204 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2.4 / *	%	Sim. to ISO 62
Water absorption, 2mm	8.2 / *	%	Sim. to ISO 62
Density	1140 / -	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	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

Characteristics

Processing	Injection Moulding
Special characteristics	Heat stabilised or stable to heat

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Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
VW Group	VW 50127	*Best Fitting Grade To PA66-1, Not Officially Approved
VW Group	VW 50133	*Best Fitting Grade To PA66-1-A, Not Officially Approved