

ECOMID® ARX H GF30 BK 9005/L

ECOMID®

Car industry, Household appliances, Electrical devices.

Product information

Resin Identification	PA66-GF30	ISO 1043
Part Marking Code	>PA66-GF30<	ISO 11469
Continuous Service Temperature	125 °C	IEC 60216-1

Rheological properties

	dry/cond.		
Viscosity number	135/*	cm ³ /g	ISO 307, 1628
Moulding shrinkage range, parallel	0.3 - 0.7	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.9 - 1.3	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	9200/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	140/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.2/-	%	ISO 527-1/-2
Charpy impact strength, 23°C	40/-	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	35/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	6/-	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	4/-	kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 961/30	190/-	MPa	ISO 2039-1
Poisson's ratio	0.34/- ^[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	235/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	245/*	°C	ISO 75-1/-2

Flammability

	dry/cond.		
Burning Behav. at thickness h	HB/*	class	IEC 60695-11-10
Thickness tested	3.2/*	mm	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.5/*	%	Sim. to ISO 62
Water absorption, 2mm	5.2/*	%	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

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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	Heat stabilised or stable to heat