

ECOMID® ARX H GF30 BK 9005/N

ECOMID®

This compound is intended for injection molding. It is suitable for the Automotive or other Industrial applications.

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

Moulding shrinkage range, parallel	0.3 - 0.7 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.8 - 1.2 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	8400/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	125/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3/-	%	ISO 527-1/-2
Charpy impact strength, 23°C	46/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	7/-	kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 961/30	180/-	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, 0.45 MPa	250/*	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.5/*	%	Sim. to ISO 62
Water absorption, 2mm	5/*	%	Sim. to ISO 62
Density	1340/-	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
Max. mould temperature	120 °C

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Characteristics

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