

# ECOMID® ARX H GF30 BK 9005/V

## ECOMID®

General purpose grade, suitable for many technical applications. Medium term heat ageing resistant, easy flow.

### Product information

Resin Identification	(PA66+PA6)-GF30	ISO 1043
Part Marking Code	>(PA66+PA6)-GF30<	ISO 11469
Continuous Service Temperature	120 °C	IEC 60216-1

### Rheological properties

	dry/cond.		
Viscosity number	140/*	cm <sup>3</sup> /g	ISO 307, 1628
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	8500/5700	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	135/85	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.7/5.5	%	ISO 527-1/-2
Charpy impact strength, 23°C	48/60	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	42/-	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	7.5/10	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	5.5/-	kJ/m <sup>2</sup>	ISO 179/1eA
Ball indentation hardness, H 961/30	188/-	MPa	ISO 2039-1
Poisson's ratio	0.34/0.35 <sup>[C]</sup>		

[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	225/*	°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 1.5mm nom. thickn.	HB/*	class	IEC 60695-11-10

### Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.7/*	%	Sim. to ISO 62
Water absorption, 2mm	5.9/*	%	Sim. to ISO 62
Density	1340/-	kg/m <sup>3</sup>	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

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Mold Temperature Optimum	100 °C
Min. mould temperature	70 °C
Max. mould temperature	120 °C

### Characteristics

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

### Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
VW Group	VW 50133	(With Deviations)