Celanese
The chemistry inside innovation™

ECOMID® ARX N BK 9011/C

ECOMID®

This compound is intended for injection molding. It is primarily designed for the Automotive Industry but also suitable for Electrical and Electronic or Industrial & Consumer applications.

Product information

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

Rheological properties

	dry/cond.		
Viscosity number	140 / *	cm^3/g	ISO 307, 1628
Moulding shrinkage range, parallel	1.7 - 2.1	%	ISO 294-4, 2577
Moulding shrinkage range, normal	1.7 - 2.1	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	2300 / -	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	55 / -	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	8 / -	%	ISO 527-1/-2
Charpy impact strength, 23°C	33 / -	kJ/m^2	ISO 179/1eU
Charpy impact strength, -30°C	30 / -	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	3 / -	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	2.5 / -	kJ/m^2	ISO 179/1eA
Ball indentation hardness, H 961/30	125 / -	MPa	ISO 2039-1
Poisson's ratio	0.39 / -[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	75 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	125 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.6 / *	%	Sim. to ISO 62
Water absorption, 2mm	6 / *	%	Sim. to ISO 62
Density	1120 / -	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
Delivery form	Granules
Additives	Nucleated
Special characteristics	High impact or impact modified, High Flow

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Mercedes-Benz	DBL5416	
Stellantis	B62 0300 / H0412	01994_16_00325

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Stress-strain (dry)