Celanese
The chemistry inside innovation™

ECOMID® B GF30 BK 9011/U

ECOMID®

General purpose grade designed for Automotive and Industrial applications

Product information

Resin Identification	PA6-GF30		ISO 1043
Part Marking Code	>PA6-GF30<		ISO 11469
Continuous Service Temperature	100	°C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	0.3 - 0.7	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 - 1.1	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	9000 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	130 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5 / -	%	ISO 527-1/-2
Charpy impact strength, 23°C	35 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	5 / -	kJ/m²	ISO 179/1eA
Ball indentation hardness, H 961/30	165 / -	MPa	ISO 2039-1
Poisson's ratio	0.34 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	225 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	200 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	215 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.8 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.3 / *	%	Sim. to ISO 62
Density	1350 / -	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	250	°C
Min. melt temperature	235	°C
Max. melt temperature	280	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	80	°C
Min. mould temperature	60	°C
Max. mould temperature	120	°C

Characteristics

Processing	Injection Moulding
Delivery form	Granules