

ECOMID® B GF33 BK 9005/1A

ECOMID®

Product information

Resin Identification	PA6-GF33	ISO 1043
Part Marking Code	>PA6-GF33<	ISO 11469

Typical mechanical properties

	dry/cond.	
Tensile modulus	11500 / -	MPa
Tensile stress at break, 5mm/min	155 / -	MPa
Tensile strain at break, 5mm/min	2.1 / -	%
Flexural modulus	10800 / -	MPa
Flexural strength	240 / -	MPa
Charpy notched impact strength, 23°C	8.5 / -	kJ/m²
Poisson's ratio	0.33 / - ^[C]	

[C]: Calculated

Thermal properties

	dry/cond.	
Temperature of deflection under load, 1.8 MPa	210 / * °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	218 / * °C	ISO 75-1/-2

Physical/Other properties

	dry/cond.	
Density	1390 / - 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
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