

ECOMID® B H D11 NC 1102/2

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General purpose grade with recycled polymer content, fast cycles. Suitable for any application requiring an average impact resistance at room temperature.

Product information

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

Rheological properties

Moulding shrinkage range, parallel	1.6 - 2 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.6 - 2 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	2500 / 1100	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	61 / 35	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	40 / -	%	ISO 527-1/-2
Charpy notched impact strength, 23°C	11 / 15	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	7.5 / -	kJ/m ²	ISO 180/1A
Poisson's ratio	0.38 / 0.45 ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	225 / *	°C	ISO 11357-1/-3

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2.3 / *	%	Sim. to ISO 62
Water absorption, 2mm	7.9 / *	%	Sim. to ISO 62
Density	1100 / -	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	260 °C
Min. melt temperature	240 °C
Max. melt temperature	270 °C
Screw tangential speed	≤0.25 m/s
Mold Temperature Optimum	70 °C
Min. mould temperature	50 °C
Max. mould temperature	90 °C

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Additives	Nucleated
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat