Celanese
The chemistry inside innovation™

ECOMID® B HH MGF3010 BK 2000/UV/1

ECOMID®

Product information

Resin Identification	PA6-(MD+GF)40	ISO 1043
Part Marking Code	>PA6-(MD+GF)40<	ISO 11469

Typical mechanical properties

	dry/cond.		
Tensile modulus	10000 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	110 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2 / -	%	ISO 527-1/-2
Flexural modulus	9000 / -	MPa	ISO 178
Flexural strength	170 / -	MPa	ISO 178
Charpy impact strength, 23°C	43 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	5.3 / -	kJ/m²	ISO 179/1eA
Poisson's ratio	0.34 / -[C]		

[C]: Calculated

Physical/Other properties

	dry/cond.		
Density	1480 / -	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	285	°C
Min. melt temperature	275	°C
Max. melt temperature	295	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	100	°C
Min. mould temperature	70	°C
Max. mould temperature	120	°C

Characteristics

Processing	Injection Moulding
Special characteristics	U.V. stabilised or stable to weather, Heat stabilised or stable to heat, Low Warpage