

ECOMID® B S10 V2 BK 9011/YG (PRELIMINARY)

ECOMID®

Product information

Resin Identification	PA6-MD10 FR(30)	ISO 1043
Part Marking Code	>PA6-MD10 FR(30)<	ISO 11469

Rheological properties

	dry/cond.		
Melt volume-flow rate	25 / *	cm ³ /10min	ISO 1133
Temperature	230 / *	°C	
Load	5 / *	kg	
Viscosity number	140 / *	cm ³ /g	ISO 307, 1628
Moulding shrinkage, parallel	0 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	0 / -	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	4000 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	70 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	5 / -	%	ISO 527-1/-2
Charpy impact strength, 23 °C	50 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23 °C	3 / -	kJ/m ²	ISO 179/1eA
Poisson's ratio	0.36 / - ^[C]		

[C]: Calculated

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	V-2 / *	class	IEC 60695-11-10
Burning Behav. at thickness h	V-2 / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	IEC 60695-11-10
Glow Wire Flammability Index, 0.75mm	850 / -	°C	IEC 60695-2-12
Glow Wire Flammability Index, 1.5mm	960 / -	°C	IEC 60695-2-12
Glow Wire Flammability Index, 3.0mm	960 / -	°C	IEC 60695-2-12

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.7 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.7 / *	%	Sim. to ISO 62
Density	1210 / -	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	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

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Characteristics

Processing	Injection Moulding
Delivery form	Granules
Additives	Flame retardant, Mineral Filler, Non-halogenated/Red phosphorous free flame retardant
Special characteristics	Flame retardant, Heat stabilised or stable to heat, Low Warpage