

ECOMID® A H BK 9004/2

ECOMID®

Injection molding grade, easy flowing, suitable for many technical application.

Product information

Resin Identification	PA66	ISO 1043
Part Marking Code	>PA66<	ISO 11469
Continuous Service Temperature	110 °C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	1.5 - 1.9 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.5 - 1.9 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	3100/-	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	76/-	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	4/-	%	ISO 527-1/-2
Charpy impact strength, 23°C	55/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4.5/-	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	3.8/-	kJ/m ²	ISO 180/1A
Izod impact strength, 23°C	35/-	kJ/m ²	ISO 180/1U
Poisson's ratio	0.37/- ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	265/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	75/*	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2.4/*	%	Sim. to ISO 62
Water absorption, 2mm	8.4/*	%	Sim. to ISO 62
Density	1130/-	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	290 °C
Min. melt temperature	280 °C
Max. melt temperature	300 °C
Screw tangential speed	≤0.4 m/s
Mold Temperature Optimum	70 °C
Min. mould temperature	50 °C
Max. mould temperature	90 °C

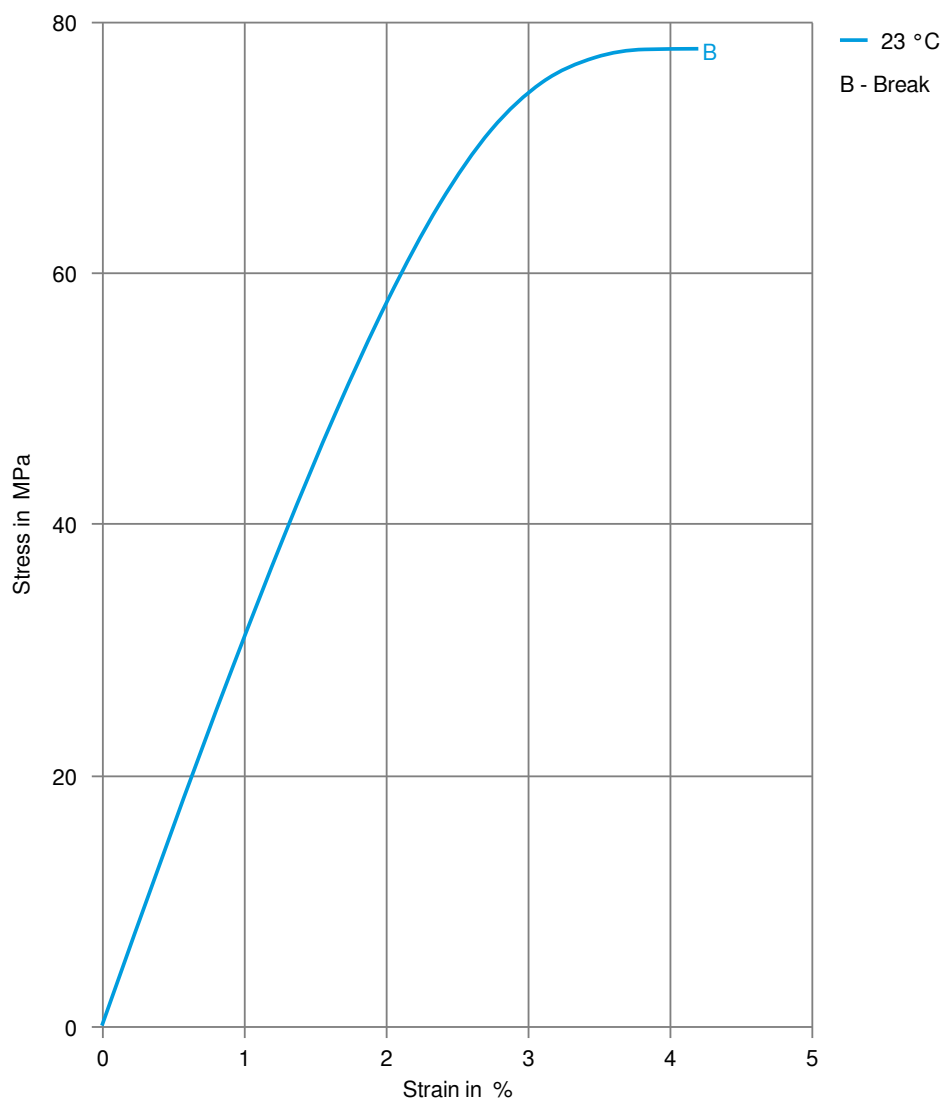
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Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	Heat stabilised or stable to heat, High Flow

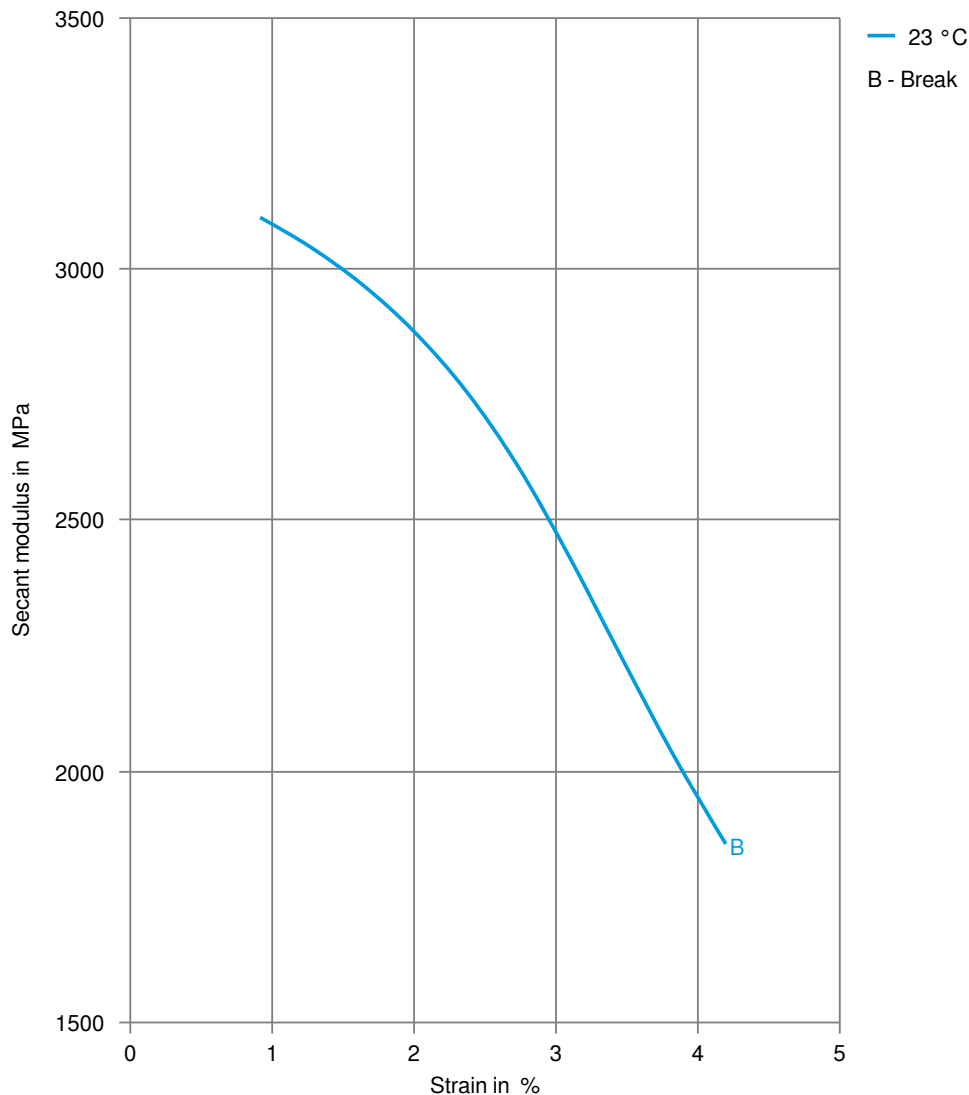
Stress-strain



ECOMID® A H BK 9004/2

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Secant modulus-strain



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Page: 3 of 3

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