Celanese
The chemistry inside innovation™

ECOMID® A H BK 9004/2

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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/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	4.5 / -	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	3.8 / -	kJ/m²	ISO 180/1A
Izod impact strength, 23°C	35 / -	kJ/m²	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/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	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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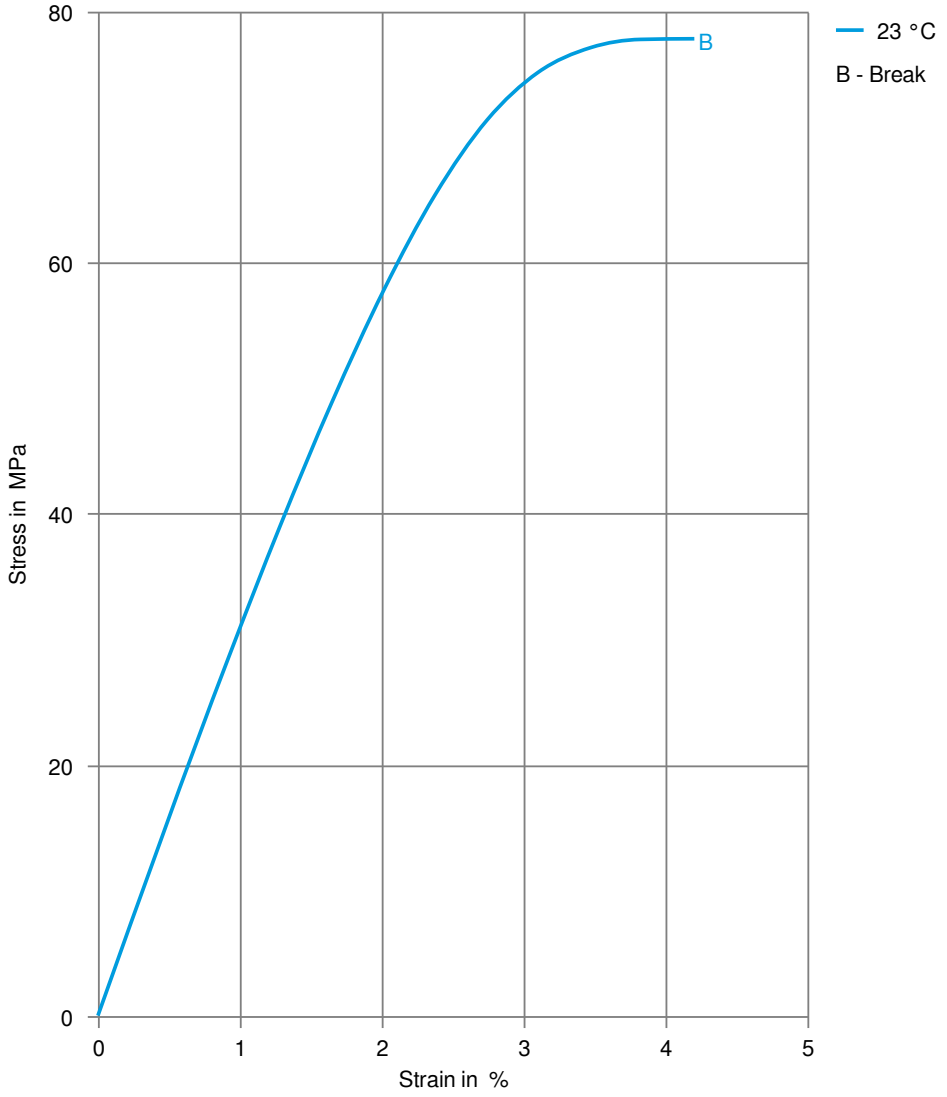
Characteristics

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

Stress-strain



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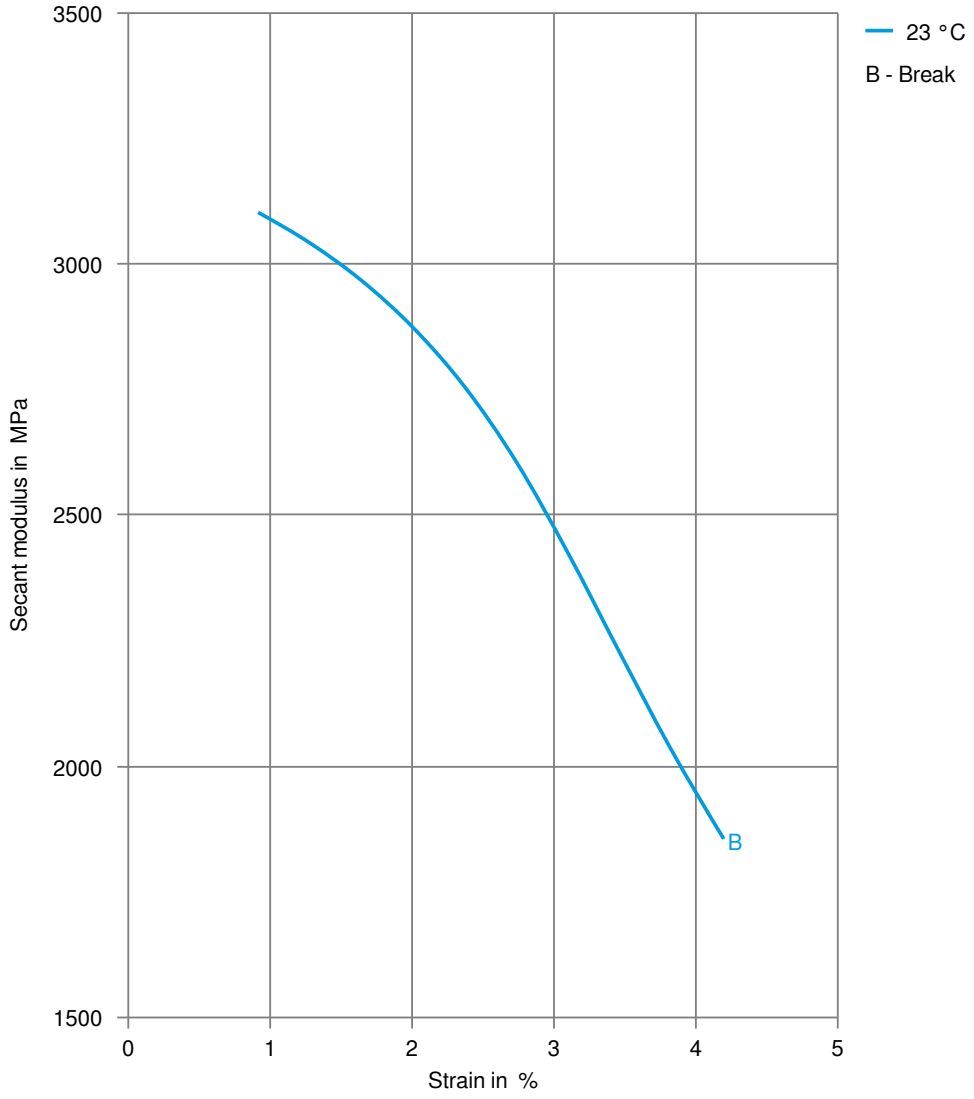
Secant modulus-strain



Revised: 2024-11-26 Source: Celanese Materials Database