



## ECOMID® A H D9 M15 GY 7002/2

### **ECOMID®**

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Resin Identification	(PA66+I)-MD15	ISO 1043
Part Marking Code	>(PA66+I)-MD15<	ISO 11469
Continuous Service Temperature	120 °C	IEC 60216-1

#### Rheological properties

Moulding shrinkage range, parallel	0.4 - 0.8 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.8 - 1.2 %	ISO 294-4, 2577

dry/cond.

#### Typical mechanical properties

Tensile modulus	2900/-	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	65/-	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	15/-	%	ISO 527-1/-2
Flexural modulus	2600/-	MPa	ISO 178
Flexural strength	85/-	MPa	ISO 178
Charpy impact strength, 23°C	120/-	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	5/-	kJ/m²	ISO 179/1eA
Poisson's ratio	0.37/- <sup>[C]</sup>		

[C]: Calculated

#### Thermal properties

Melting temperature, 10°C/min	260/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	67/*	°C	ISO 75-1/-2

dry/cond.

dry/cond.

#### Physical/Other properties

Humidity absorption, 2mm	1.6/*	%	Sim. to ISO 62
Water absorption, 2mm	5.8/*	%	Sim. to ISO 62
Density	1220/-	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	295	°C
Min. melt temperature	285	°C
Max. melt temperature	305	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	80	°C
Min. mould temperature	50	°C
Max. mould temperature	100	°C
Ejection temperature	222	°C

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





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#### Characteristics

Processing Injection Moulding

Delivery form Granules

Additives Mineral Filler

Special characteristics High impact or impact modified, Heat stabilised or stable to heat

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