



# ECOMID® A H GF15 BK 9004/2

# **ECOMID®**

Suitable for various technical applications, this grade shows a good combination of mechanical and thermal performances.

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Resin Identification	PA66-GF15	ISO 1043
Part Marking Code	>PA66-GF15<	ISO 11469

### 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

5700/4000	MPa	ISO 527-1/-2
100/70	MPa	ISO 527-1/-2
2/7	%	ISO 527-1/-2
4500/-	MPa	ISO 178
140/-	MPa	ISO 178
30/>50	kJ/m²	ISO 179/1eU
3/5	kJ/m²	ISO 179/1eA
3.5/-	kJ/m²	ISO 180/1A
0.35/0.36 <sup>[C]</sup>		
	100/70 2/7 4500/- 140/- 30/>50 3/5 3.5/-	100/70 MPa 2/7 % 4500/- MPa 140/- MPa 30/>50 kJ/m <sup>2</sup> 3/5 kJ/m <sup>2</sup> 3.5/- kJ/m <sup>2</sup>

#### [C]: Calculated

I hermal properties	dry/cond
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Melting temperature, 10°C/min	265/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	240/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	250/*	°C	ISO 75-1/-2

# Physical/Other properties

Humidity absorption, 2mm	2/*	%	Sim. to ISO 62
Water absorption, 2mm	7.2/*	%	Sim. to ISO 62
Density	1230/-	kg/m³	ISO 1183

dry/cond.

## 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

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





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# Characteristics

**ECOMID®** 

Processing Injection Moulding

Delivery form Granules

Special characteristics Heat stabilised or stable to heat

**Automotive** 

OEM STANDARD ADDITIONAL INFORMATION

VW Group VW 50127 \*Best Fitting Grade To PA66-4, Not Officially

Approved

VW Group VW 50133 \*Best Fitting Grade To PA66-3-A, Not Officially

Approved

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

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