Celanese
The chemistry inside innovation™

ECOMID® A H GF15 BK 9004/2

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

Product information

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

Typical mechanical properties

	dry/cond.		
Tensile modulus	5700 / 4000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	100 / 70	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2 / 7	%	ISO 527-1/-2
Flexural modulus	4500 / -	MPa	ISO 178
Flexural strength	140 / -	MPa	ISO 178
Charpy impact strength, 23°C	30 / >50	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	3 / 5	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	3.5 / -	kJ/m²	ISO 180/1A
Poisson's ratio	0.35 / 0.36[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	240 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	250 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2 / *	%	Sim. to ISO 62
Water absorption, 2mm	7.2 / *	%	Sim. to ISO 62
Density	1230 / -	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	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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Characteristics

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

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