Celanese
The chemistry inside innovation™

ECOMID® A H J10 NC 1102/A

ECOMID®

General purpose grade, designed for Automotive industry, medium toughness. Typically used for fitting elements.

Product information

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

Rheological properties

	dry/cond.		
Moulding shrinkage, parallel	1.4 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	1.4 / -	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	2200 / -	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	50 / -	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	5 / -	%	ISO 527-1/-2
Tensile strain at break, 50mm/min	30 / -	%	ISO 527-1/-2
Flexural modulus	2000 / -	MPa	ISO 178
Flexural strength	75 / -	MPa	ISO 178
Charpy impact strength, 23°C	N / -	kJ/m²	ISO 179/1eU
Izod notched impact strength, 23°C	18 / -	kJ/m²	ISO 180/1A
Izod notched impact strength, -30°C	9.0 / -	kJ/m²	ISO 180/1A
Poisson's ratio	0.39 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	65 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	190 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.8 / *	%	Sim. to ISO 62
Water absorption, 2mm	7 / *	%	Sim. to ISO 62
Density	1080 / -	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
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat

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