Celanese
The chemistry inside innovation™

ECOMID® A H J12 BK 9004/2

ECOMID®

General purpose grade, designed for Automotive industry, maximum toughness.

Product information

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

Rheological properties

Moulding shrinkage range, parallel	1.3 - 1.9 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.3 - 1.9 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	1600 / -	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	45 / -	MPa	ISO 527-1/-2
Charpy impact strength, 23 °C	N / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23 °C	>80 / -	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23 °C	80 / -	kJ/m²	ISO 180/1A
Poisson's ratio	0.42 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	260 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	60 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.7 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.3 / *	%	Sim. to ISO 62
Density	1060 / -	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	≤0.3	m/s
Mold Temperature Optimum	80	°C
Min. mould temperature	50	°C
Max. mould temperature	100	°C

Characteristics

Processing	Injection Moulding
Additives	Nucleated
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat

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Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Mercedes-Benz	DBL5416	Daimler- EQ Models-Schwanden- Jack Pads Plugs

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