Celanese
The chemistry inside innovation™

ECOMID® A HH GF30 BK 9004/2A

ECOMID®

General purpose grade, suitable for many technical applications.

Product information

Resin Identification	PA66-GF30	ISO 1043
Part Marking Code	>PA66-GF30<	ISO 11469

Rheological properties

Moulding shrinkage range, parallel	0.3 - 0.6	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 - 0.9	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	9600 / 6500	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	150 / 105	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5 / 4	%	ISO 527-1/-2
Charpy impact strength, 23°C	45 / 50	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	5.5 / 7.5	kJ/m²	ISO 179/1eA
Poisson's ratio	0.34 / 0.35[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	260 / *	°C	ISO 11357-1/-3

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.6 / *	%	Sim. to ISO 62
Water absorption, 2mm	5.8 / *	%	Sim. to ISO 62
Density	1360 / -	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

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	Heat stabilised or stable to heat

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Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Stellantis	B62 0300 / 61/215M/217E/H0412(Bradol497)/13	01994_16_00799
VW Group	VW 50127	*Best Fitting Grade To PA66-7, Not Officially Approved
VW Group	VW 50133	*Best Fitting Grade To PA66-6-A, Not Officially Approved

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