

# ECOMID® A HH M25 GY 7046

## ECOMID®

Specially designed for Automotive components requiring long term heat ageing resistance, easy processing, low warpage and high stiffness.

### Product information

Resin Identification	PA66-MF25	ISO 1043
Part Marking Code	>PA66-MF25<	ISO 11469
Continuous Service Temperature	130 °C	IEC 60216-1

### Rheological properties

Moulding shrinkage range, parallel	0.4 - 0.7 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 - 0.9 %	ISO 294-4, 2577

### Typical mechanical properties

	dry/cond.		
Tensile modulus	7200 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	80 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5 / -	%	ISO 527-1/-2
Charpy impact strength, 23 °C	30 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23 °C	4 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23 °C	3.5 / -	kJ/m <sup>2</sup>	ISO 180/1A
Poisson's ratio	0.35 / - <sup>[C]</sup>		
[C]: Calculated			

### Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	125 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	245 / *	°C	ISO 75-1/-2

### Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10

### Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.6 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.2 / *	%	Sim. to ISO 62
Density	1350 / -	kg/m <sup>3</sup>	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
Additives	Mineral Filler
Special characteristics	Heat stabilised or stable to heat, Low Warpage