Celanese
The chemistry inside innovation™

ECOMID® ARX H D05 BK 9011/A

ECOMID®

General purpose grade, based on recycled polyamide, good flexibility and toughness.

Product information

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

[C]: Calculated

Rheological properties

Moulding shrinkage range, parallel	1.4 - 1.8	%	ISO 294-4, 2577
Moulding shrinkage range, normal	1.4 - 1.8	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	2250 / -	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	55 / -	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	20 / -	%	ISO 527-1/-2
Charpy impact strength, 23°C	45 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	5 / -	kJ/m²	ISO 179/1eA
Ball indentation hardness, H 961/30	110 / -	MPa	ISO 2039-1
Poisson's ratio	0.39 / -[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	65 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	155 / *	°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	2 / *	%	Sim. to ISO 62
Water absorption, 2mm	7.9 / *	%	Sim. to ISO 62
Density	1110 / -	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

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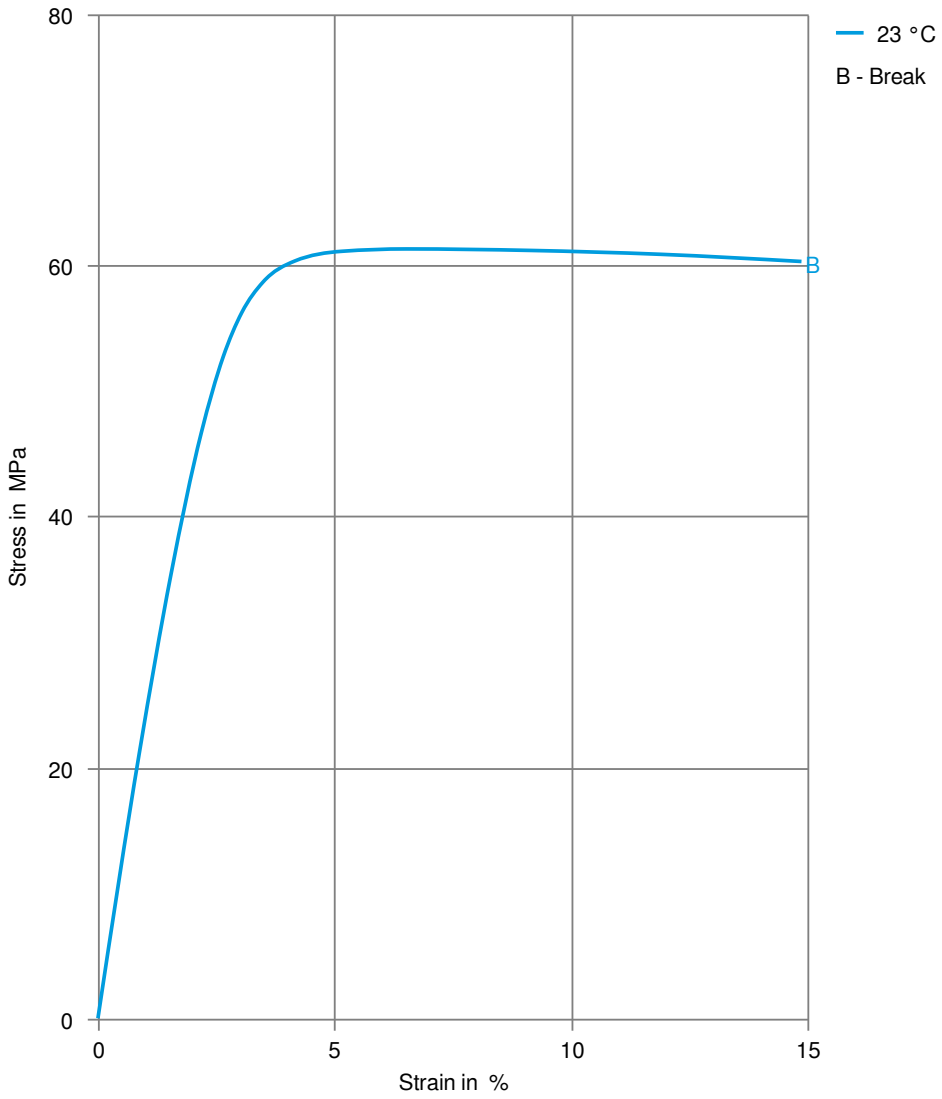
Max. mould temperature	100 °C

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat

Stress-strain (dry)



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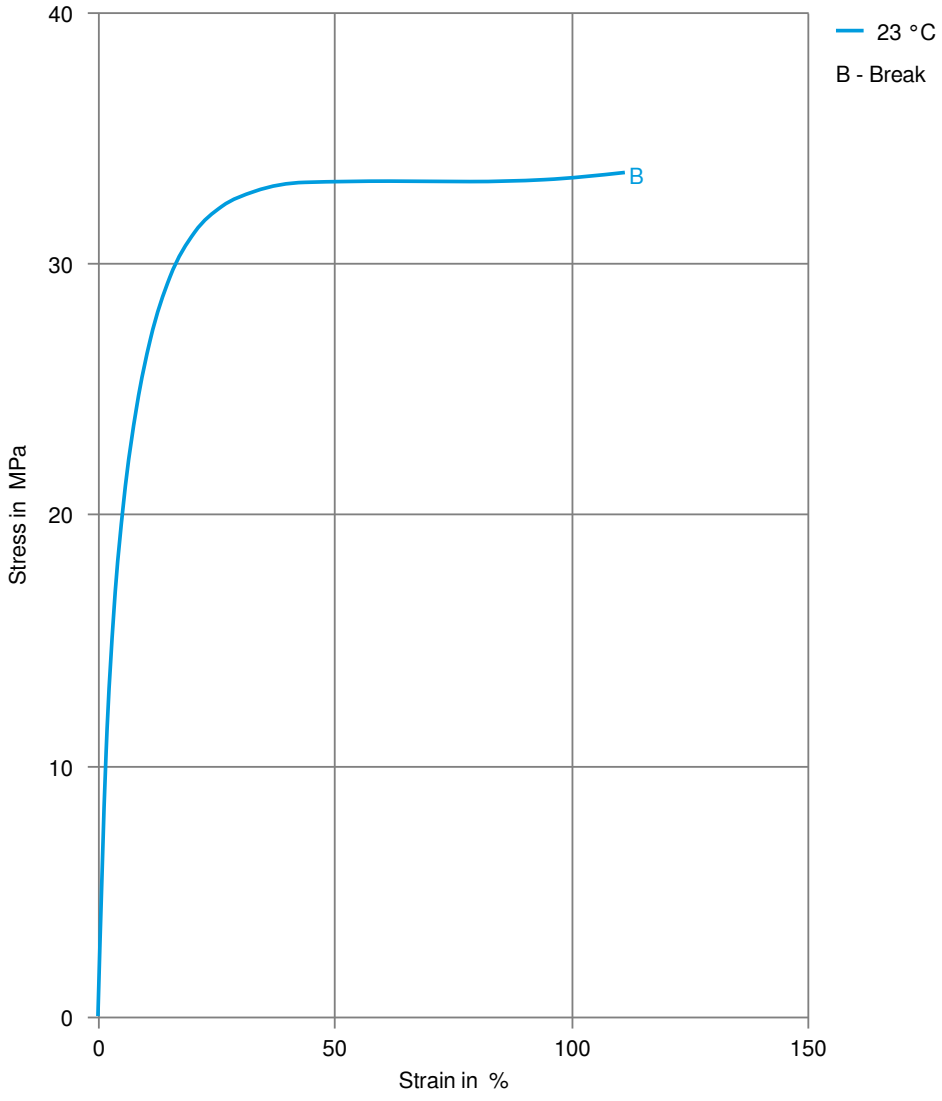
Stress-strain (cond.)



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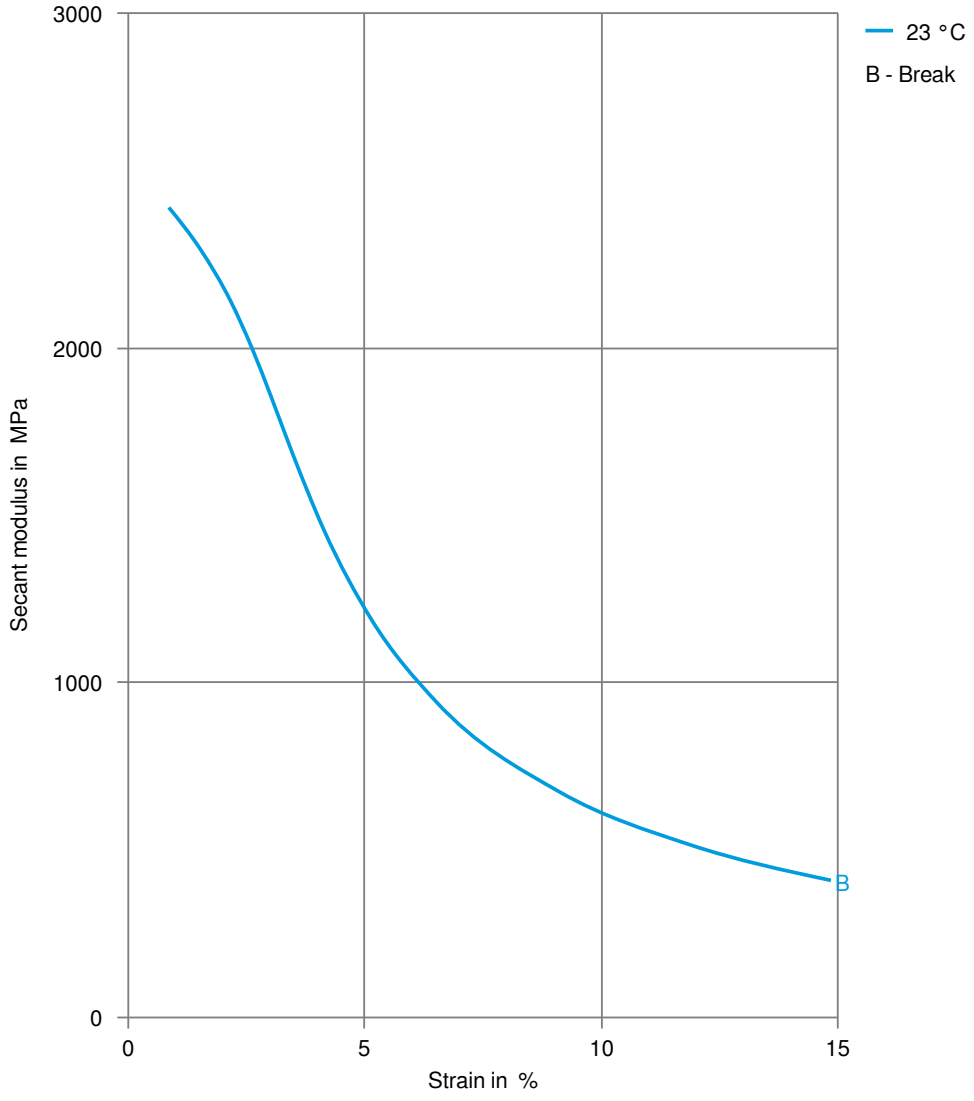
Secant modulus-strain (dry)



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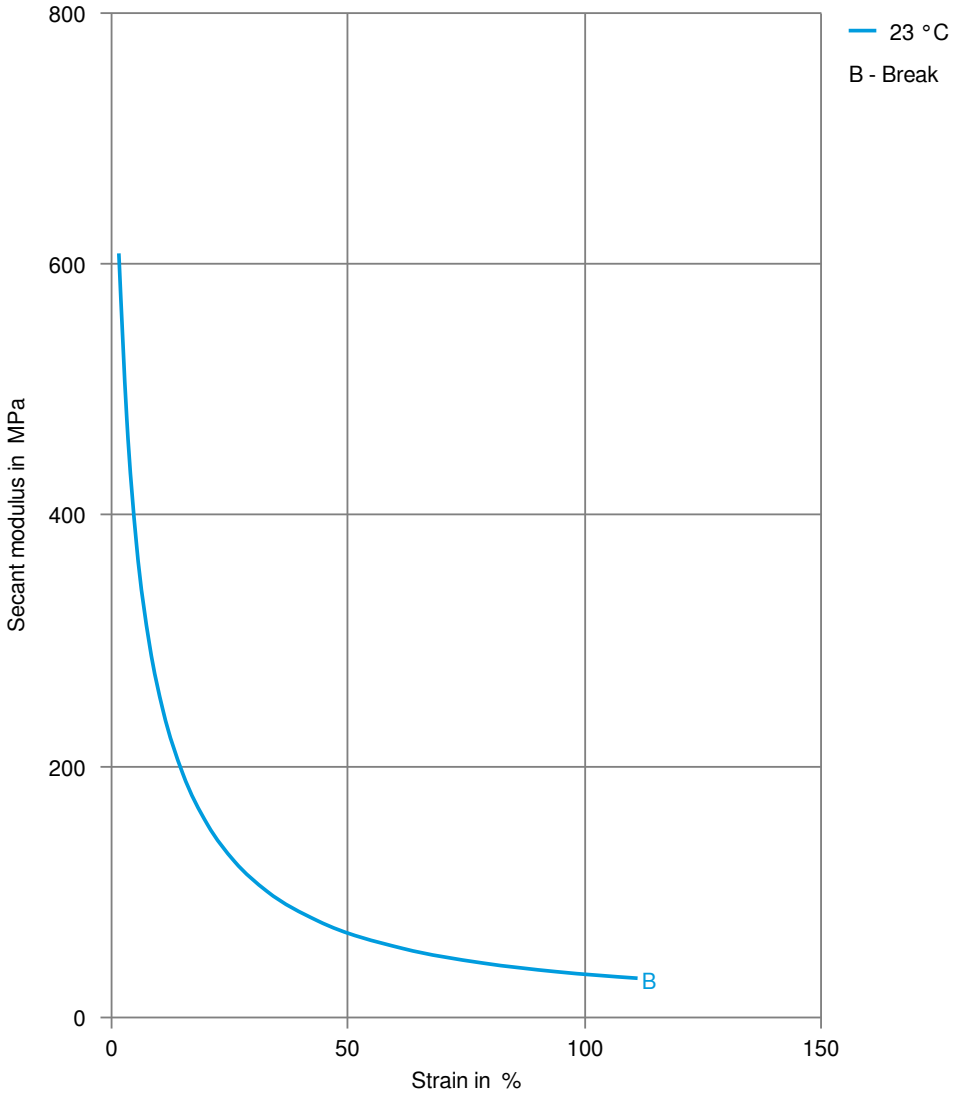
Secant modulus-strain (cond.)



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