



## ECOMID® ARX H D05 BK 9011/S

### **ECOMID®**

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

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Resin Identification	PA66-I	ISO 1043
Part Marking Code	>PA66-I<	ISO 11469
Continuous Service Temperature	110 °C	IEC 60216-1

#### 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

dry/cond.

#### Typical mechanical properties

Tensile modulus	2200/-	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	55/-	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	14/-	%	ISO 527-1/-2
Charpy impact strength, 23°C	50/-	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	4.5/-	kJ/m²	ISO 179/1eA
Ball indentation hardness, H 961/30	110/-	MPa	ISO 2039-1
Poisson's ratio	0.39/- <sup>[C]</sup>		

#### [C]: Calculated

Thermal properties dry	y/cond
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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

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

dry/cond.

#### Physical/Other properties

Humidity absorption, 2mm	2/*	%	Sim. to ISO 62
Water absorption, 2mm	8/*	%	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
Max. mould temperature	100 °C

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





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#### Characteristics

Processing Injection Moulding

Delivery form Granules

Special characteristics High impact or impact modified, Heat stabilised or stable to heat

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