

ECOMID® ARX H D05 BK 9011/S

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	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

Typical mechanical properties

	dry/cond.		
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/m ²	ISO 179/1eU
Charpy notched impact strength, 23 °C	4.5 / -	kJ/m ²	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	8 / *	%	Sim. to ISO 62
Density	1110 / -	kg/m ³	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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Characteristics

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