



ISO 294-4, 2577

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## ECOMID® ARX H GF30 BK 9005/N

**ECOMID®** 

This compound is intended for injection molding. It is suitable for the Automotive or other Industrial applications.

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Resin Identification	PA66-GF30	ISO 1043
Part Marking Code	>PA66-GF30<	ISO 11469
Continuous Service Temperature	125 °C	IEC 60216-1
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Rheological properties		

0.3 - 0.7 %

0.8 - 1.2 %

### Typical mechanical properties

Moulding shrinkage range, parallel

Moulding shrinkage range, normal

Typical mechanical properties	dry/cond.		
Tensile modulus	8400/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	125/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3/-	%	ISO 527-1/-2
Charpy impact strength, 23°C	46/-	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	7/-	kJ/m²	ISO 179/1eA
Ball indentation hardness, H 961/30	180/-	MPa	ISO 2039-1
Poisson's ratio	0.34/- <sup>[C]</sup>		

[C]: Calculated

Thermal properties	dry/cond
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Melting temperature, 10°C/min	260/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 0.45 MPa	250/*	°C	ISO 75-1/-2

#### Physical/Other properties dry/cond.

Humidity absorption, 2mm	1.5/*	%	Sim. to ISO 62
Water absorption, 2mm	5/*	%	Sim. to ISO 62
Density	1340/-	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

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





# ECOMID® ARX H GF30 BK 9005/N

#### Characteristics

Processing Injection Moulding

Delivery form Granules

Special characteristics Heat stabilised or stable to heat

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