

ECOMID® B HH GF30 BK 9005/1P

Rheological properties

Melt volume-flow rate	40 cm ³ /10min	ISO 1133
Temperature	275 °C	
Load	5 kg	
Moulding shrinkage range, parallel	0.2 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile Modulus	10000/6000	MPa	ISO 527-1/-2
Stress at break, 5mm/min	137/85	MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.8/8	%	ISO 527-1/-2
Flexural Modulus	8500/5000	MPa	ISO 178
Flexural Strength	210/120	MPa	ISO 178
Charpy impact strength, 23°C	50/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	6/12	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -40°C	5.5/-	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	6/-	kJ/m ²	ISO 180/1A
Izod impact strength, 23°C	40/-	kJ/m ²	ISO 180/1U
Hardness, Rockwell, M-scale	95		ISO 2039-2
Poisson's ratio	0.39		

Thermal properties

Melting temperature, 10°C/min	220 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	204 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	219 °C	ISO 75-1/-2

Flammability

Burning Behav. at 1.5mm nom. thickn.	HB class	UL 94
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Other properties

Density	1360 kg/m ³	ISO 1183
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Injection

Drying Temperature	80 - 90 °C
Drying Time, Dehumidified Dryer	4 - 8 h
Processing Moisture Content	0.15 %
Max. mould temperature	60 - 80 °C



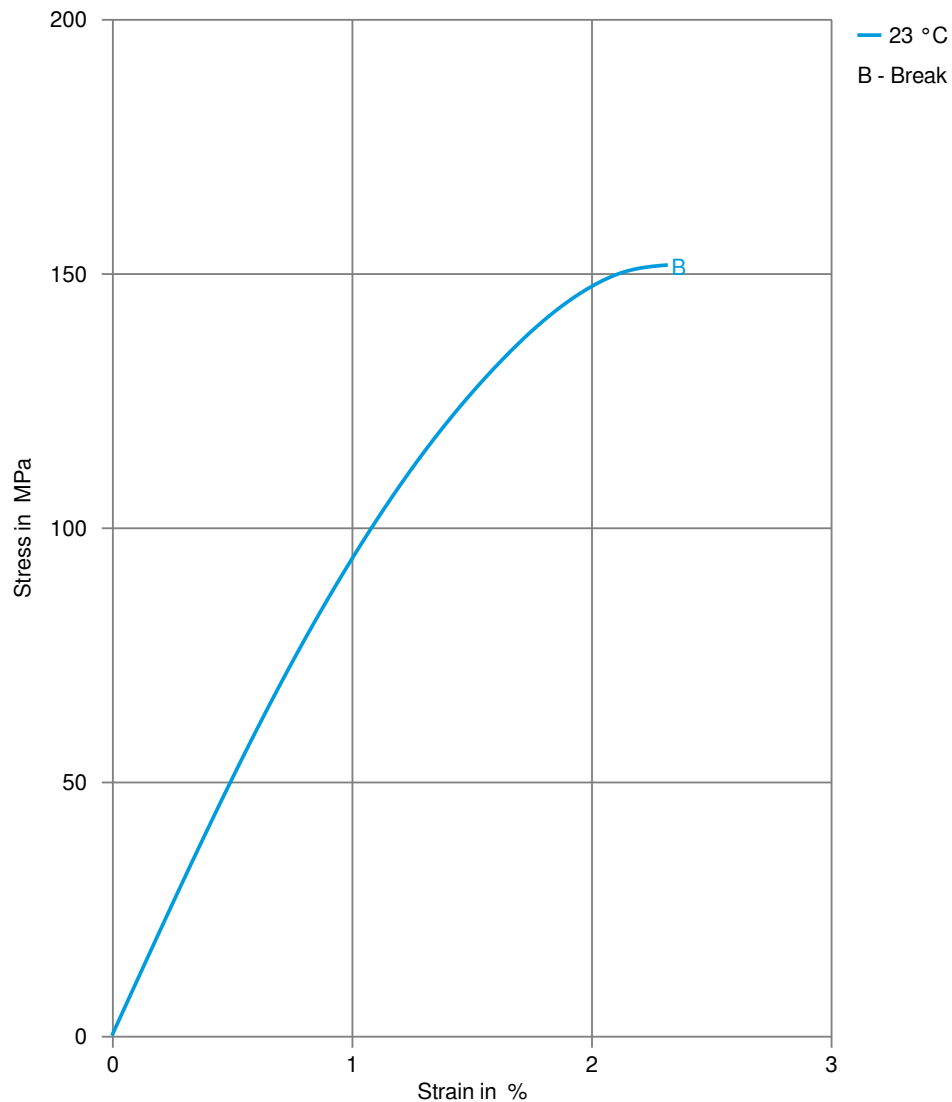
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Characteristics

Additives

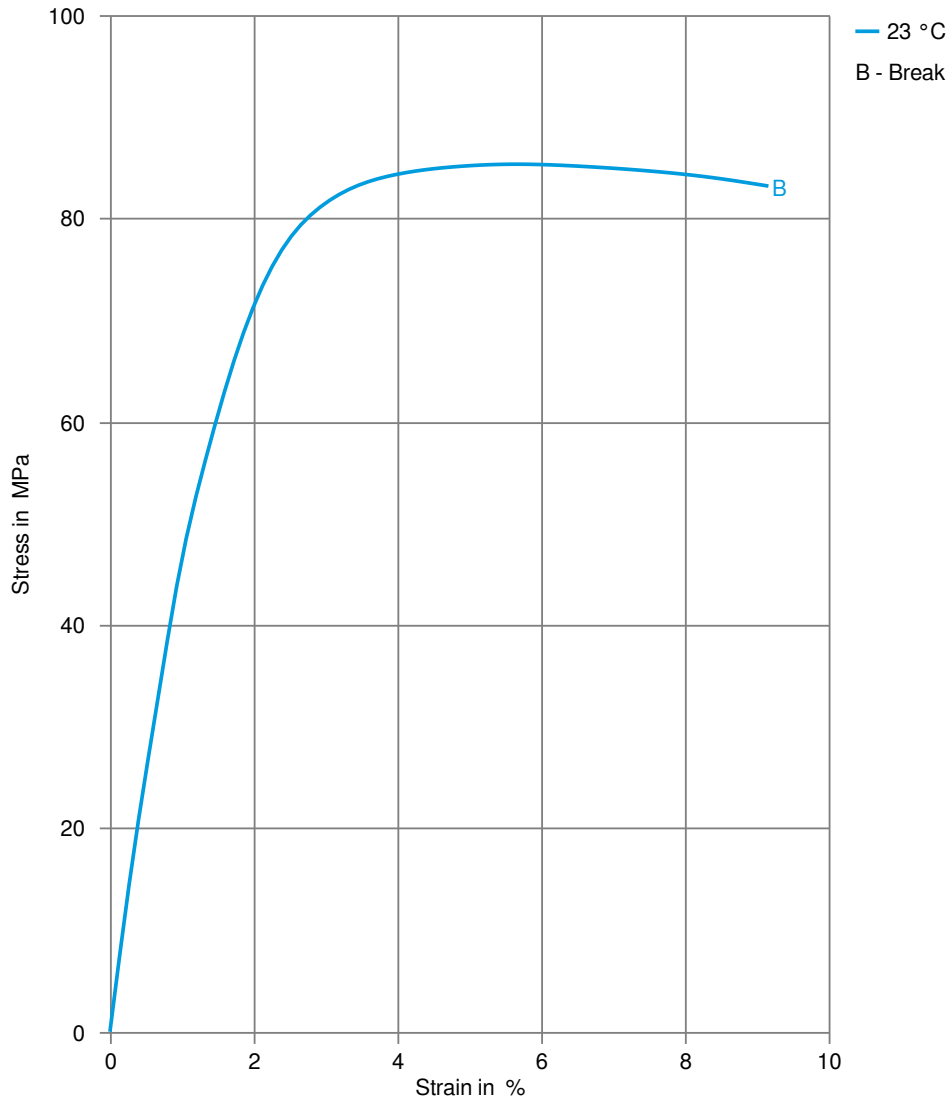
Contains Recycle

Stress-strain (dry)



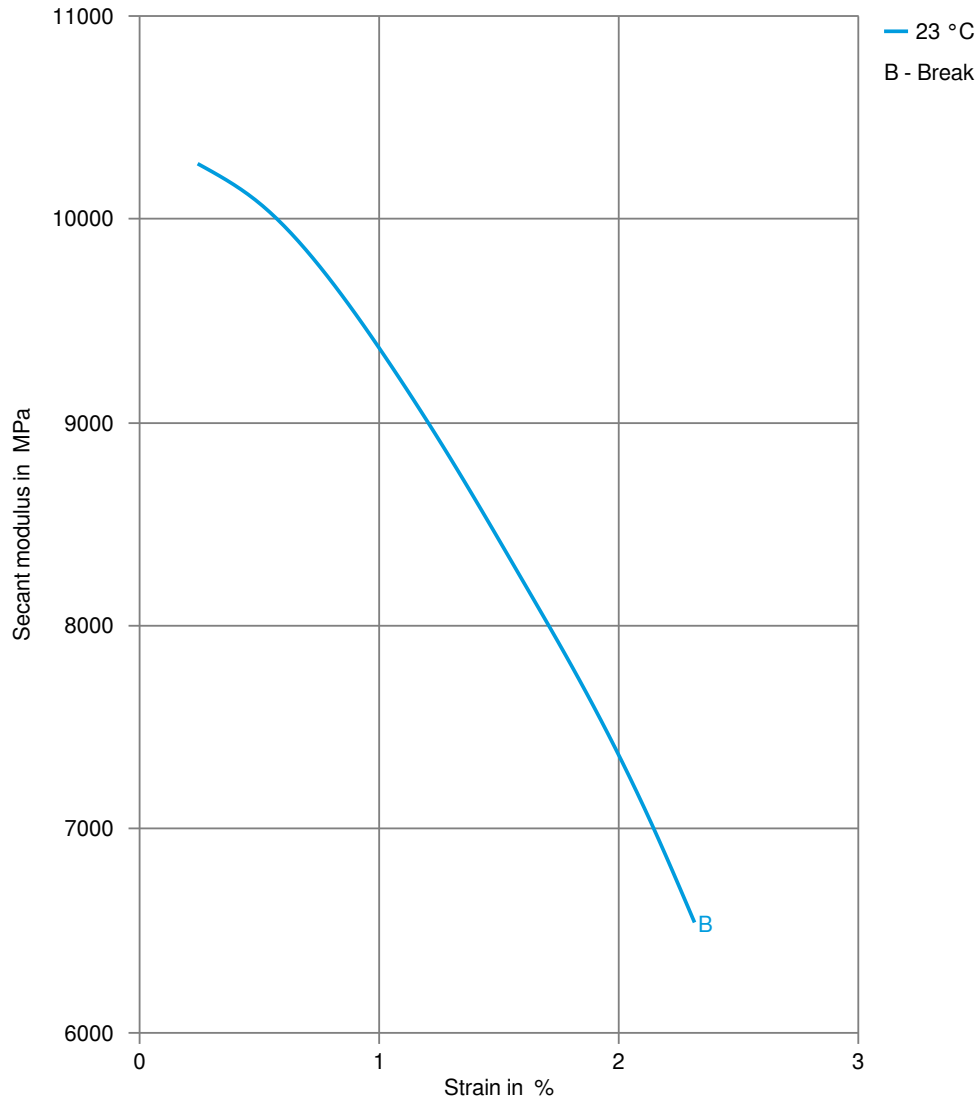
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Stress-strain (cond.)



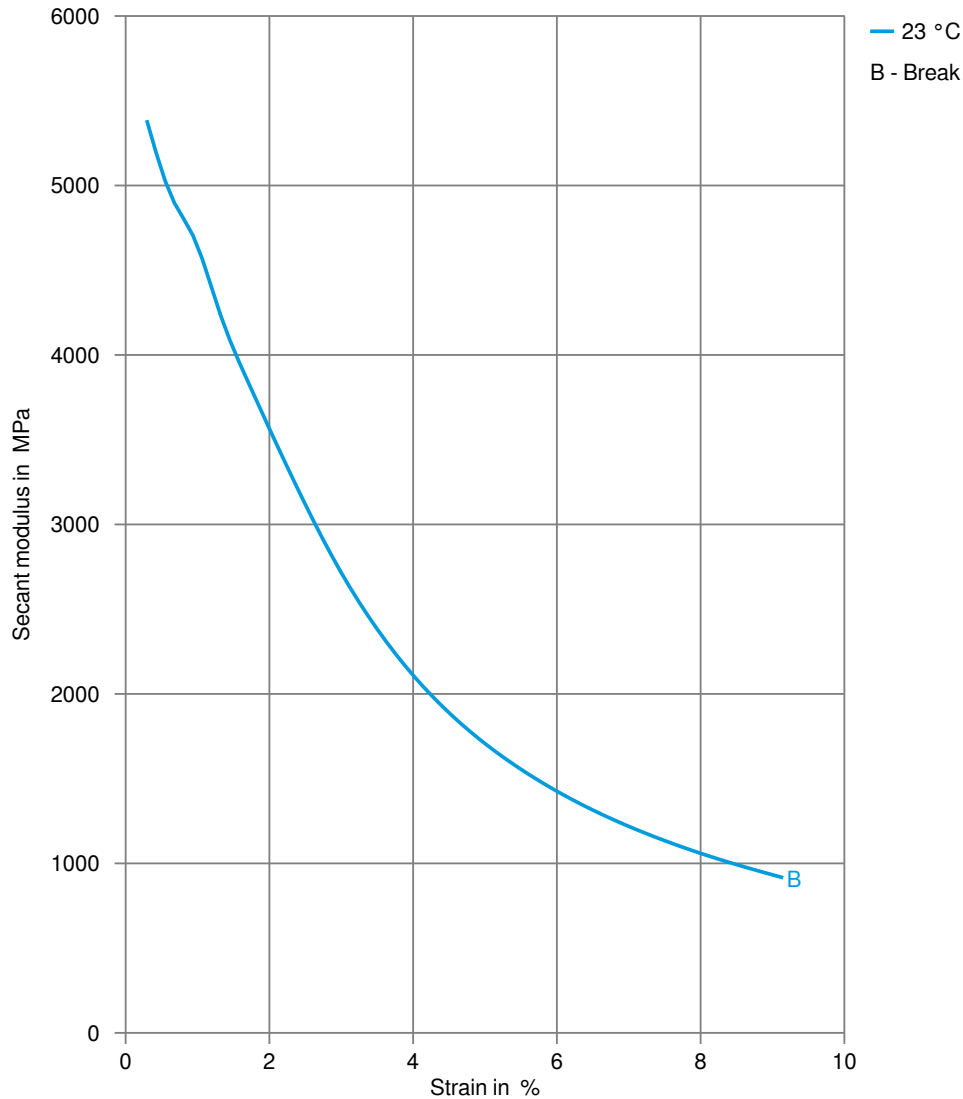
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Secant modulus-strain (dry)



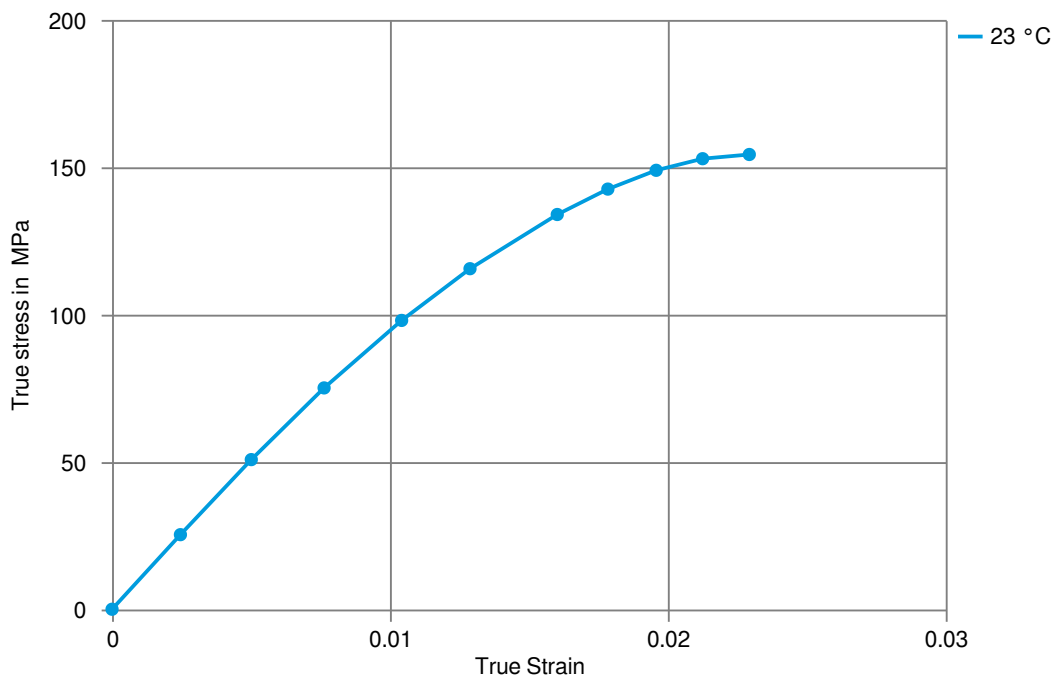
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Secant modulus-strain (cond.)



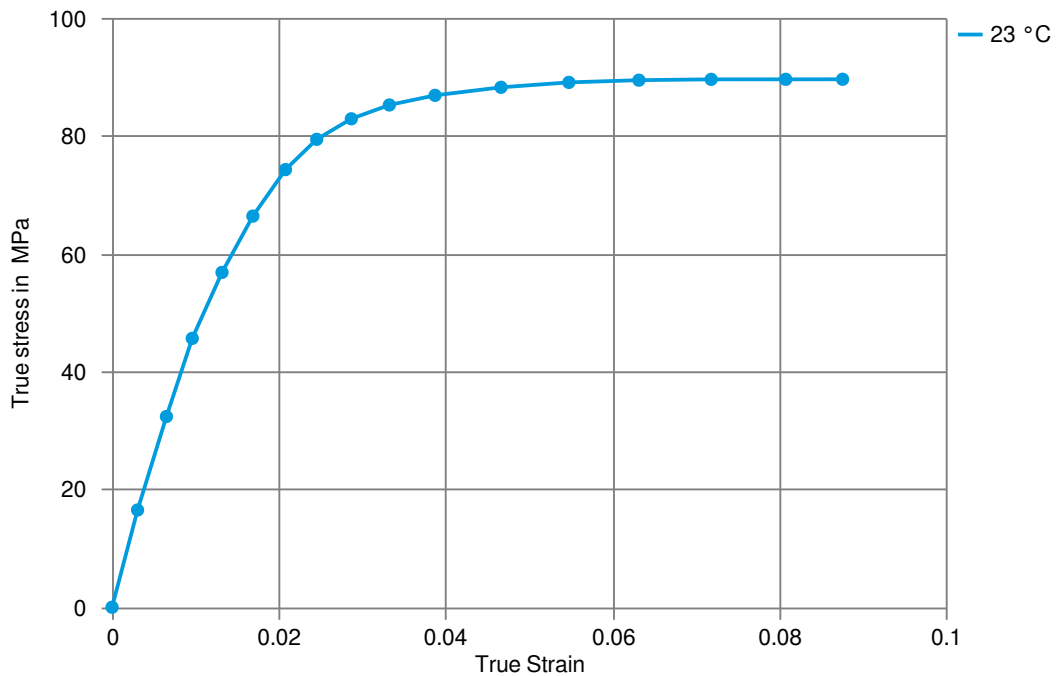
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True stress-strain (dry)



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True stress-strain (cond.)



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Processing Texts

Injection molding Postprocessing

PA materials reach their final performance with a water content of about 1.5 to 3.5% by weight, depending on the type. This percentage corresponds to the point of equilibrium between the rates of absorption and desorption of moisture. After molding, in favorable environmental conditions, a part can quickly absorb moisture up to 0.5-1.0%, while the equilibrium will be reached during its life. A conditioning treatment can accelerate further the initial water absorption of the molded parts. Conditioning is usually carried out in hot and humid environment (for example 50 °C, 100% RH), inside climatic chambers. Slight dimensional variations (increase in volume due to the water absorbed) must be considered, especially in unfilled grades. Post-treatments of parts may also include the annealing (60-80 °C in oven, up to four hours). This procedure can be useful to relax any internal stresses.

Other Approvals

Other Approvals

OEM	Specification	Additional Information
VW Group*	VW50134	* best fitting grade to PA6-7-A, not officially approved
VW Group*	VW50125	* best fitting grade to PA6-7, not officially approved

