Celanese
The chemistry inside innovation™

ECOMID® A H BK 9004/2

Polyamide 66 compound, unfilled. Based on recycled polymers.
Injection molding grade, easy flowing, suitable for many technical application.

Product information

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

Rheological properties

Moulding shrinkage range, parallel	1.5 - 1.9	%	ISO 294-4, 2577
Moulding shrinkage range, normal	1.5 - 1.9	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile Modulus	3100 / -	MPa	ISO 527-1/-2
Yield stress, 50mm/min	76 / -	MPa	ISO 527-1/-2
Strain at break, 50mm/min	4 / -	%	ISO 527-1/-2
Charpy impact strength, 23°C	55 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	4.5 / -	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	3.8 / -	kJ/m²	ISO 180/1A
Izod impact strength, 23°C	35 / -	kJ/m²	ISO 180/1U

Thermal properties

Melting temperature, 10°C/min	265	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	75	°C	ISO 75-1/-2

Other properties

Humidity absorption, 2mm	2.4	%	Sim. to ISO 62
Water absorption, 2mm	8.4	%	Sim. to ISO 62
Density	1130	kg/m³	ISO 1183

Characteristics

Additives	Contains Recycle

Additional information

Injection molding	The following conditions apply to a standard injection molding process. Machine temperatures: barrel 265-290°C (PA66), 235-270°C (PA6), nozzle and hot runners up to 300°C (up to 290°C products with flame retardants). Mold temperatures: 60-80°C, (80-100°C highly reinforced grades). Back pressure: typically, 5-10 bar (hydraulic pressure). Temperatures exceeding 300°C and long residence time could lead to additives degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the molded part characteristics. For further details, please refer to the document 'Instructions for injection molding' or contact our technical support team.

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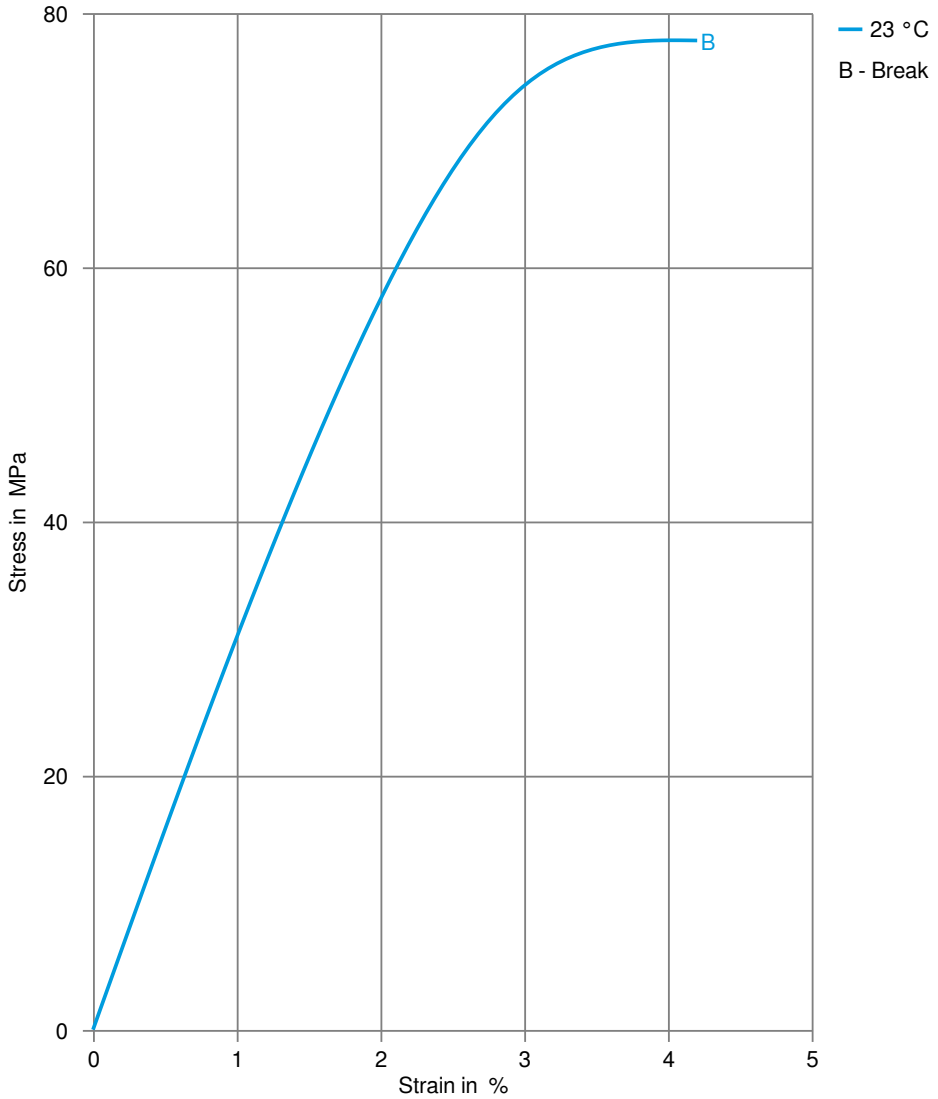
Stress-strain



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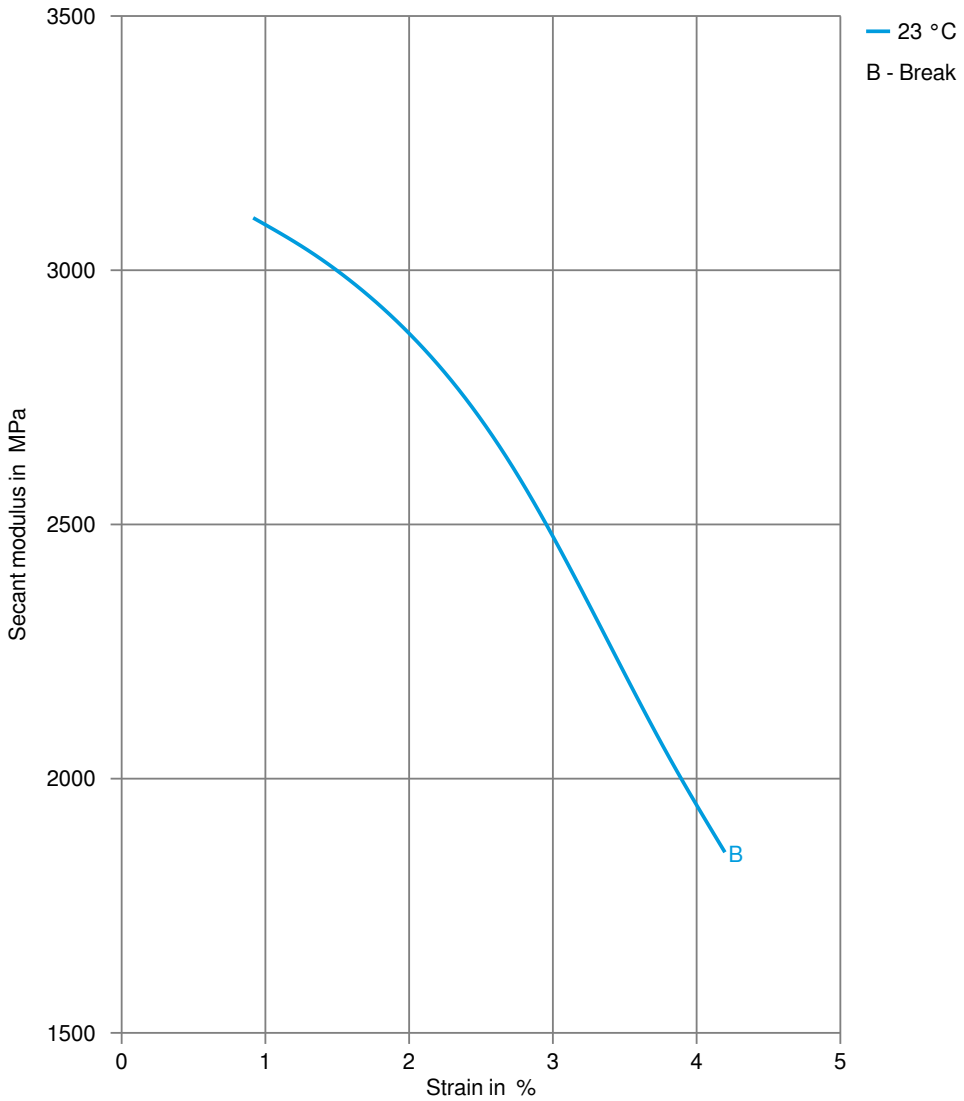
Secant modulus-strain



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Processing Texts

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Injection molding Preprocessing	PA materials, stocked in a moisture-proof packaging, can be processed without drying; however, it is always recommended drying the product that comes from a large package (e.g. Octabin). The moisture content suggested for the injection molding process should be lower than 0.15%, according to the grade and to the molded part characteristics. The materials containing flame retardants should have moisture content below 0.10%. Red phosphorous containing grades must always be dried below 0.08%. The drying time depends on the moisture content and the drying conditions. Typically, 4-8 hours at 80-90°C using dehumidified air (dew point of -20°C) are suitable conditions for a starting moisture content of 0.20%-0.40%.
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 absorbs 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.