Celanese
The chemistry inside innovation™

CELANYL® B2 HH J8 GF33 BK 9005/1

CELANYL®

Product information

Resin Identification	PA6-GF33	ISO 1043
Part Marking Code	>PA6-GF33<	ISO 11469

Typical mechanical properties

	dry/cond.		
Tensile modulus	11200 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	150 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.6 / -	%	ISO 527-1/-2
Flexural modulus	10400 / -	MPa	ISO 178
Flexural strength	240 / -	MPa	ISO 178
Charpy notched impact strength, 23 °C	17 / -	kJ/m²	ISO 179/1eA
Poisson's ratio	0.33 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	194 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Density	1350 / -	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	260	°C
Min. melt temperature	240	°C
Max. melt temperature	290	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	80	°C
Min. mould temperature	60	°C
Max. mould temperature	120	°C

Characteristics

Processing	Injection Moulding
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat, Low wear / Low friction, High Flow