

CELANYL® B3 GFB1020 WT 9001/F

CELANYL®

General purpose grade, easy flowing, low warpage.

Product information

Resin Identification	PA6-(GF+GB)30	ISO 1043
Part Marking Code	>PA6-(GF+GB)30<	ISO 11469
Continuous Service Temperature	90 °C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	0.3 - 0.7 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.5 - 0.9 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	5500 /-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	80 /-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3 /-	%	ISO 527-1/-2
Charpy impact strength, 23°C	25 /-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	2.5 /-	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	2 /-	kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 961/30	180 /-	MPa	ISO 2039-1
Poisson's ratio	0.35 /- ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	225 /*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	210 /*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	220 /*	°C	ISO 75-1/-2

Electrical properties

	dry/cond.		
Volume resistivity	1E13 /-	Ohm.m	IEC 62631-3-1
Comparative tracking index	550 /-		IEC 60112

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2 /*	%	Sim. to ISO 62
Water absorption, 2mm	6.5 /*	%	Sim. to ISO 62
Density	1350 /-	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	260 °C
Min. melt temperature	240 °C
Max. melt temperature	290 °C
Screw tangential speed	≤0.2 m/s
Mold Temperature Optimum	80 °C

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Min. mould temperature	60 °C
Max. mould temperature	120 °C
Ejection temperature	177 °C

Characteristics

Processing	Injection Moulding
Delivery form	Granules