

# CELANYL® B3 GFB1515 BK 9005/U

## CELANYL®

General purpose grade, for low warpage, suitable for technical applications.

### Product information

Resin Identification	PA6-(GF+GB)30	ISO 1043
Part Marking Code	>PA6-(GF+GB)30<	ISO 11469

### Rheological properties

	dry/cond.		
Melt volume-flow rate	10/*	cm <sup>3</sup> /10min	ISO 1133
Temperature	230/*	°C	
Load	5/*	kg	
Viscosity number	160/*	cm <sup>3</sup> /g	ISO 307, 1628
Moulding shrinkage range, parallel	0.3 - 0.6	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 - 0.9	%	ISO 294-4, 2577

### Typical mechanical properties

	dry/cond.		
Tensile modulus	6750/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	125/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.7/-	%	ISO 527-1/-2
Charpy impact strength, 23°C	50/-	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	5/-	kJ/m <sup>2</sup>	ISO 179/1eA
Poisson's ratio	0.35/- <sup>[C]</sup>		

[C]: Calculated

### Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	220/*	°C	ISO 11357-1/-3

### Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB/*	class	IEC 60695-11-10

### Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.8/*	%	Sim. to ISO 62
Water absorption, 2mm	6/*	%	Sim. to ISO 62
Density	1360/-	kg/m <sup>3</sup>	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

# CELANYL® B3 GFB1515 BK 9005/U

## CELANYL®

### Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	Low Warpage