Celanese
The chemistry inside innovation™

CELANYL® B3 HH GFB1020 BK 9005/2

CELANYL®

Primarily designed for the Automotive Industry but also suitable for other applications that require, good flowability and low warpage.

Product information

Resin Identification	PA6-(GF+GB)30	ISO 1043
Part Marking Code	>PA6-(GF+GB)30<	ISO 11469
Continuous Service Temperature	110 °C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	0.4 - 0.7 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 - 1 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	6000 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	100 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5 / -	%	ISO 527-1/-2
Flexural modulus	4500 / -	MPa	ISO 178
Charpy impact strength, 23°C	25 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	3.2 / -	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	3.5 / -	kJ/m²	ISO 180/1A
Poisson's ratio	0.35 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	225 / *	°C	ISO 11357-1/-3

Flammability

	dry/cond.		
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	3.2 / *	mm	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.8 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.3 / *	%	Sim. to ISO 62
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

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Max. mould temperature	120	°C

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	Heat stabilised or stable to heat, High Flow, Low Warpage