

# CELANYL® B3 HH J40 NC 1102/3

## CELANYL®

Suitable for making mono and multilayer flexible pipes and other profiles via extrusion process.

### Product information

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

### Rheological properties

	dry/cond.		
Melt mass-flow rate	3.5/*	g/10min	ISO 1133
Melt mass-flow rate, Temperature	235/*	°C	
Melt mass-flow rate, Load	5/*	kg	
Moulding shrinkage range, parallel	0.7 - 1	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 - 1	%	ISO 294-4, 2577

### Typical mechanical properties

	dry/cond.		
Tensile modulus	1050/-	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	30/-	MPa	ISO 527-1/-2
Tensile strain at yield, 50mm/min	15/-	%	ISO 527-1/-2
Tensile stress at break, 50mm/min	33/-	MPa	ISO 527-1/-2
Flexural modulus	1100/-	MPa	ISO 178
Flexural strength	35/-	MPa	ISO 178
Charpy impact strength, 23°C	N/-	kJ/m <sup>2</sup>	ISO 179/1eU
Izod notched impact strength, 23°C	70/-	kJ/m <sup>2</sup>	ISO 180/1A
Poisson's ratio	0.45/- <sup>[C]</sup>		

[C]: Calculated

### Thermal properties

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

### Flammability

Burning rate, Thickness 1 mm	120	mm/min	ISO 3795 (FMVSS 302)
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### Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.4/*	%	Sim. to ISO 62
Water absorption, 2mm	4.9/*	%	Sim. to ISO 62
Density	1010/-	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	270 °C
Screw tangential speed	≤0.25 m/s
Mold Temperature Optimum	70 °C

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Min. mould temperature	50 °C
Max. mould temperature	90 °C

### Characteristics

Processing	Injection Moulding, Extrusion, Coextrusion
Delivery form	Granules
Special characteristics	High impact or impact modified, Heat stabilised or stable to heat