

**CELANYL® B3 J6 GF40 NC 1102/1 - PA6**
**Description**

(OMNILON® PA6 GR40 IM6 NA)  
 40% Glass Reinforced, Impact Modified, PA6

<b>Physical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	89.3	lb/ft <sup>3</sup>	ISO 1183

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Tensile stress at yield, 23°C	23500	psi	ASTM D638
Tensile strain at break, 23°C	4	%	ASTM D638
Flexural modulus, 23°C	1.4E6	psi	ASTM D790
Flexural stress, 23°C	37000	psi	ASTM D790
Izod impact notched, 23°C	3.5	ft-lb/in	ASTM D256

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
DTUL at 1.8 MPa	396	°F	ISO 75-1, -2
DTUL at 0.45 MPa	415	°F	ISO 75-1, -2

**Typical injection molding processing conditions**

<b>Pre Drying</b>	<b>Value</b>	<b>Unit</b>
Necessary low maximum residual moisture content	0.15	%
Drying time	4 - 8	h
Drying temperature	176 - 194	°F

<b>Temperature</b>	<b>Value</b>	<b>Unit</b>
Zone1 temperature	428 - 446	°F
Zone2 temperature	437 - 455	°F
Zone3 temperature	455 - 473	°F
Zone4 temperature	473 - 491	°F
Nozzle temperature	491 - 518	°F
Melt temperature	482 - 518	°F
Mold temperature	140 - 176	°F
Hot runner temperature	491 - 518	°F

**Characteristics**

**Product Categories** Glass reinforced, Impact modified

**Processing** Injection molding