

CELANYL® B3 W MGF2515 NC 1102/1B

CELANYL®

Product information

Resin Identification	PA6-(GF+MD)4 0	ISO 1043
Part Marking Code	>PA6-(GF+MD)40<	ISO 11469

Typical mechanical properties

Izod notched impact strength, 23 °C	dry/cond. 5.3 / -	kJ/m ²	ISO 180/1A
-------------------------------------	----------------------	-------------------	------------

Thermal properties

Temperature of deflection under load, 1.8 MPa	dry/cond. 191 / *	°C	ISO 75-1/-2
---	----------------------	----	-------------

Physical/Other properties

Density	dry/cond. 1480 / -	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
Min. mould temperature	60 °C
Max. mould temperature	120 °C

Characteristics

Processing	Injection Moulding
Special characteristics	Heat stabilised or stable to heat, Low Warpage