

CELANYL® A3 H BK 9005

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Injection molding grade, easy flowing, suitable for any technical application requiring long term temperature resistance.

Product information

Resin Identification	(PA66+PA6)	ISO 1043
Part Marking Code	>(PA66+PA6)<	ISO 11469
Continuous Service Temperature	140 °C	IEC 60216-1

Rheological properties

	dry/cond.		
Viscosity number	145 / *	cm ³ /g	ISO 307, 1628
Moulding shrinkage range, parallel	1.5 - 1.9	%	ISO 294-4, 2577
Moulding shrinkage range, normal	1.5 - 1.9	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	3000 / -	MPa	ISO 527-1/-2
Tensile stress at yield, 50mm/min	80 / 50 ^[C]	MPa	ISO 527-1/-2
Tensile strain at break, 50mm/min	20 / - ^[C]	%	ISO 527-1/-2
Charpy impact strength, 23 °C	50 / >50	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23 °C	4.8 / 15 ^[C]	kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 961/30	150 / -	MPa	ISO 2039-1
Poisson's ratio	0.37 / - ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	265 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	80 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	210 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2.4 / *	%	Sim. to ISO 62
Water absorption, 2mm	8.4 / *	%	Sim. to ISO 62
Density	1130 / -	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	290 °C
Min. melt temperature	280 °C
Max. melt temperature	300 °C
Screw tangential speed	≤0.4 m/s
Mold Temperature Optimum	70 °C
Min. mould temperature	50 °C
Max. mould temperature	90 °C

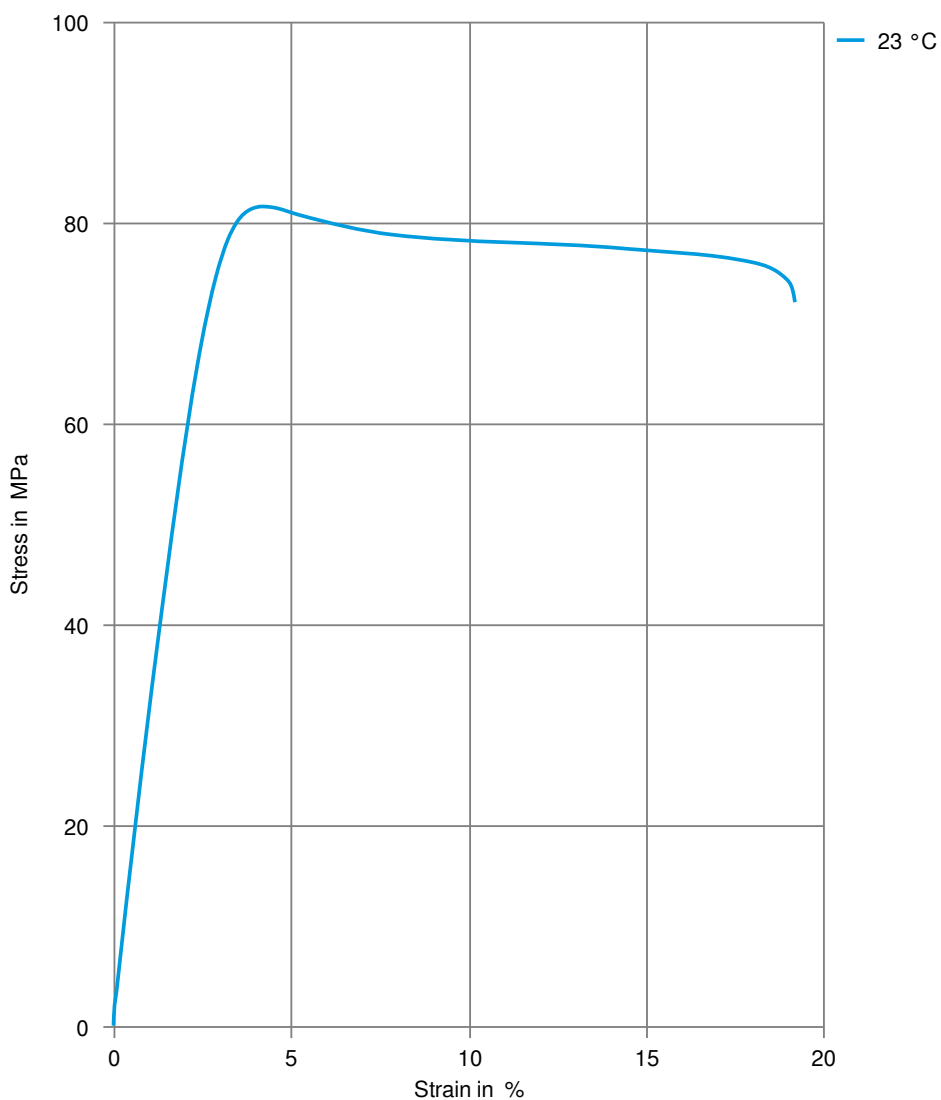
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Characteristics

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

Stress-strain (dry)



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Secant modulus-strain (dry)

