Celanese
The chemistry inside innovation™

CELANYL® A3 H GF25 BK 9005/P

CELANYL®

General purpose grade for any technical use. Easy flow.

Product information

Resin Identification	(PA66+PA6)-GF25	ISO 1043
Part Marking Code	>(PA66+PA6)-GF25<	ISO 11469
Continuous Service Temperature	130 °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	7900 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	140 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5 / -	%	ISO 527-1/-2
Flexural modulus	8200 / -	MPa	ISO 178
Flexural strength	230 / -	MPa	ISO 178
Charpy impact strength, 23°C	50 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23°C	6.5 / -	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	7.5 / -	kJ/m²	ISO 180/1A
Izod notched impact strength, -30°C	6.0 / -	kJ/m²	ISO 180/1A
Ball indentation hardness, H 961/30	170 / -	MPa	ISO 2039-1
Poisson's ratio	0.34 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	260 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	235 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	250 / *	°C	ISO 75-1/-2

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	2 / *	%	Sim. to ISO 62
Water absorption, 2mm	7.2 / *	%	Sim. to ISO 62
Density	1310 / -	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	295	°C
Min. melt temperature	285	°C
Max. melt temperature	305	°C

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Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	80	°C
Min. mould temperature	50	°C
Max. mould temperature	100	°C

Characteristics

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