Celanese
The chemistry inside innovation™

CELANYL® A3 HH GF30 BK 9005/F

CELANYL®

Car industry, Household appliances, Electrical devices.

Product information

Resin Identification	PA66-GF30	ISO 1043
Part Marking Code	>PA66-GF30<	ISO 11469

Rheological properties

	dry/cond.		
Melt volume-flow rate	40 / *	cm^3/10min	ISO 1133
Temperature	270 / *	°C	
Load	5 / *	kg	
Viscosity number	135 / *	cm^3/g	ISO 307, 1628
Moulding shrinkage, parallel	0.2 / -	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.8 / -	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	9100 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	175 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5 / -	%	ISO 527-1/-2
Charpy impact strength, 23°C	75 / -	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	10.5 / -	kJ/m^2	ISO 179/1eA
Charpy notched impact strength, -30°C	11 / -	kJ/m^2	ISO 179/1eA
Izod notched impact strength, 23°C	10 / -	kJ/m^2	ISO 180/1A
Izod impact strength, 23°C	65 / -	kJ/m^2	ISO 180/1U
Poisson's ratio	0.34 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	250 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Density	1350 / -	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	295	°C
Min. melt temperature	285	°C
Max. melt temperature	305	°C
Screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	100	°C
Min. mould temperature	70	°C
Max. mould temperature	120	°C
Ejection temperature	202	°C

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Characteristics

Processing	Injection Moulding
Special characteristics	Heat stabilised or stable to heat, Specialty appearance, High Flow