

CELANYL® A3 HH GF33 NC 1102/HW

CELANYL®

Car industry, Household appliances, Electrical devices.

Product information

Resin Identification	PA66-GF33	ISO 1043
Part Marking Code	>PA66-GF33<	ISO 11469
Continuous Service Temperature	140 °C	IEC 60216-1

Rheological properties

	dry/cond.		
Viscosity number	140/*	cm ³ /g	ISO 307, 1628
Moulding shrinkage, parallel	0.3/-	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.5/-	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	10300/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	195/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.7/-	%	ISO 527-1/-2
Charpy impact strength, 23°C	87/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	10.9/-	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	12/-	kJ/m ²	ISO 180/1A
Izod impact strength, 23°C	>60/-	kJ/m ²	ISO 180/1U
Poisson's ratio	0.34/- ^[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	250/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	260/*	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.4/*	%	Sim. to ISO 62
Water absorption, 2mm	5.9/*	%	Sim. to ISO 62
Density	1390/-	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

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Characteristics

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