

CELANYL® A3 HH M25 NC 1102/UV/2

CELANYL®

General purpose grade, easy processing, low warpage and good surface quality. Suitable for outdoor use.

Product information

Resin Identification	(PA66+PA6)-MF25	ISO 1043
Part Marking Code	>(PA66+PA6)-MF25<	ISO 11469
Continuous Service Temperature	120 °C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	0.6 - 1 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 - 1.1 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	4500/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	85/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	10/-	%	ISO 527-1/-2
Flexural modulus	4000/-	MPa	ISO 178
Flexural strength	120/-	MPa	ISO 178
Charpy impact strength, 23°C	>100/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4/-	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	5.5/-	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C	4.0/-	kJ/m ²	ISO 180/1A
Poisson's ratio	0.35/- ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	264/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	76/*	°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	1.8/*	%	Sim. to ISO 62
Water absorption, 2mm	6.5/*	%	Sim. to ISO 62
Density	1320/-	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

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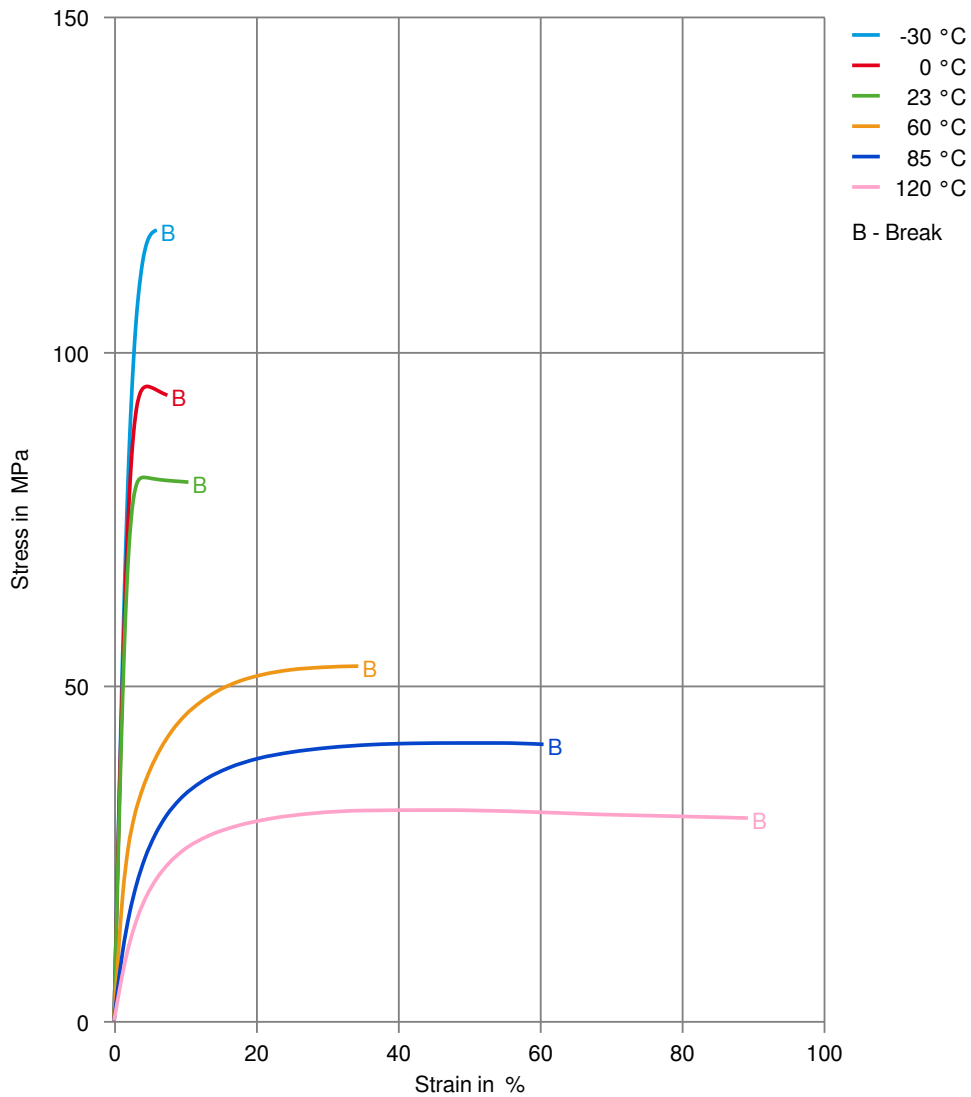
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Min. mould temperature 70 °C
Max. mould temperature 120 °C

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Additives	Mineral Filler
Special characteristics	U.V. stabilised or stable to weather, Heat stabilised or stable to heat, High Flow, Low Warpage

Stress-strain (dry)



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Secant modulus-strain (dry)

