

CELANYL® A4 E GF25 BK 9005

CELANYL®

Designed as 'all in one solution' specifically for the thermal break insulation profiles extrusion.

Product information

Resin Identification	(PA66+PA6)-GF25	ISO 1043
Part Marking Code	>(PA66+PA6)-GF25<	ISO 11469
Continuous Service Temperature	100 °C	IEC 60216-1

Rheological properties

	dry/cond.		
Melt volume-flow rate	14/*	cm ³ /10min	ISO 1133
Temperature	275/*	°C	
Load	5/*	kg	
Moulding shrinkage range, parallel	0.3 - 0.6	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 - 0.9	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	7700/5400	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	140/95	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	4/6.5	%	ISO 527-1/-2
Flexural modulus	7700/-	MPa	ISO 178
Flexural strength	200/-	MPa	ISO 178
Charpy impact strength, 23°C	65/80	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	11.5/15	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	12/-	kJ/m ²	ISO 180/1A
Poisson's ratio	0.34/0.35 ^[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	245/*	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.6/*	%	Sim. to ISO 62
Water absorption, 2mm	6/*	%	Sim. to ISO 62
Density	1310/-	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, Extrusion

Delivery form

Granules