

# CELANYL® B2 GF33 BK 9005/1

## CELANYL®

### Product information

Resin Identification	PA6-GF33	ISO 1043
Part Marking Code	>PA6-GF33<	ISO 11469

### Typical mechanical properties

	dry/cond.	
Tensile modulus	11200 / -	MPa
Tensile stress at break, 5mm/min	170 / -	MPa
Tensile strain at break, 5mm/min	2.6 / -	%
Flexural modulus	9700 / -	MPa
Flexural strength	270 / -	MPa
Charpy notched impact strength, 23°C	11 / -	kJ/m²
Izod notched impact strength, 23°C	12 / -	kJ/m²
Poisson's ratio	0.33 / - <sup>[C]</sup>	

[C]: Calculated

### Thermal properties

	dry/cond.	
Temperature of deflection under load, 1.8 MPa	210 / * °C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	218 / * °C	ISO 75-1/-2

### Physical/Other properties

	dry/cond.	
Density	1380 / - kg/m³	ISO 1183

### Injection

Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	$\leq 0.15$ %
Melt Temperature Optimum	260 °C
Min. melt temperature	240 °C
Max. melt temperature	290 °C
Screw tangential speed	$\leq 0.2$ m/s
Mold Temperature Optimum	80 °C
Min. mould temperature	60 °C
Max. mould temperature	120 °C

### Characteristics

Processing	Injection Moulding
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