

CELANYL® B2 HH GF33 BK 269/UV/1

CELANYL®

Product information

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

Rheological properties

	dry/cond.		
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	11500 / 6300	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	190 / 100	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.3 / 6.5	%	ISO 527-1/-2
Flexural modulus	9600 / 5600	MPa	ISO 178
Flexural strength	280 / 130	MPa	ISO 178
Charpy impact strength, 23°C	80 / 85	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	13 / 20	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	16 / -	kJ/m ²	ISO 180/1A
Poisson's ratio	0.33 / 0.35 ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	221 / *	°C	ISO 11357-1/-3

Physical/Other properties

	dry/cond.		
Density	1380 / -	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	260 °C
Min. melt temperature	240 °C
Max. melt temperature	290 °C
Screw tangential speed	≤0.2 m/s
Mold Temperature Optimum	80 °C
Min. mould temperature	60 °C
Max. mould temperature	120 °C
Ejection temperature	161 °C

Characteristics

Processing	Injection Moulding
Special characteristics	U.V. stabilised or stable to weather, Heat stabilised or stable to heat, Low wear / Low friction