Celanese
The chemistry inside innovation™

CELANYL® B2 HH GF35 BK 9005/1

CELANYL®

Product information

Resin Identification	PA6-GF35		ISO 1043
Part Marking Code	>PA6-GF35<		ISO 11469

Typical mechanical properties

	dry/cond.		
Tensile modulus	12200 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	195 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.8 / -	%	ISO 527-1/-2
Flexural modulus	10600 / -	MPa	ISO 178
Flexural strength	290 / -	MPa	ISO 178
Izod notched impact strength, 23 °C	13 / -	kJ/m²	ISO 180/1A
Poisson's ratio	0.33 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	197 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Density	1390 / -	kg/m³	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

Characteristics

Processing	Injection Moulding
Special characteristics	Heat stabilised or stable to heat