

CELANYL® B3 GF20 BK 9005/E

CELANYL®

Car industry, Household appliances, Electrical devices.

Product information

Resin Identification	PA6-GF20	ISO 1043
Part Marking Code	>PA6-GF20<	ISO 11469

Rheological properties

Moulding shrinkage range, parallel	0.4 - 0.5 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 - 0.8 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	6800/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	135/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5/-	%	ISO 527-1/-2
Flexural modulus	5800/-	MPa	ISO 178
Flexural strength	200/-	MPa	ISO 178
Charpy impact strength, 23°C	50/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	9/-	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	9/-	kJ/m ²	ISO 180/1A
Poisson's ratio	0.35/- ^[C]		
[C]: Calculated			

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	195/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	215/*	°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	1.9/*	%	Sim. to ISO 62
Water absorption, 2mm	6.8/*	%	Sim. to ISO 62
Density	1270/-	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

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Characteristics

Processing

Injection Moulding

Automotive

OEM

VW Group

STANDARD

VW 50134