

CELANYL® B3 H GCF2406 BK 9005

CELANYL®

Technical grade designed for applications that require a static dissipative behaviour.

Product information

Resin Identification	PA6-(GF+CF)30	ISO 1043
Part Marking Code	>PA6-(GF+CF)30<	ISO 11469

Rheological properties

	dry/cond.		
Viscosity number	135 / *	cm ³ /g	ISO 307, 1628
Moulding shrinkage range, parallel	0.2 - 0.5	%	ISO 294-4, 2577
Moulding shrinkage, normal	0.7 / -	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.5 - 0.9	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	11800 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	170 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5 / -	%	ISO 527-1/-2
Charpy impact strength, 23 °C	60 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23 °C	9 / -	kJ/m ²	ISO 179/1eA
Poisson's ratio	0.33 / - ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	225 / *	°C	ISO 11357-1/-3

Electrical properties

	dry/cond.		
Volume resistivity	100000 / -	Ohm.m	IEC 62631-3-1

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.5 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.5 / *	%	Sim. to ISO 62
Density	1330 / -	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

Special characteristics

Static dissipative, Heat stabilised or stable to heat