

CELANYL® B3 HH J10 GF15 BK 9005/UV/2

CELANYL®

Injection molding grade designed for Automotive parts, good impact resistance even at low temperature and excellent surface quality. Suitable for exterior parts.

Product information

Resin Identification	PA6-I-GF15	ISO 1043
Part Marking Code	>PA6-I-GF15<	ISO 11469
Continuous Service Temperature	120 °C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	0.5 - 0.9 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.9 - 1.3 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	5200/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	100/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3/-	%	ISO 527-1/-2
Flexural modulus	4600/-	MPa	ISO 178
Flexural strength	150/-	MPa	ISO 178
Charpy impact strength, 23°C	60/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	17/-	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	17/-	kJ/m ²	ISO 180/1A
Poisson's ratio	0.35/- ^[C]		
[C]: Calculated			

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	225/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	180/*	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	200/*	°C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel, -40-23°C	28/*	E-6/K	ISO 11359-1/-2
CLTE, Parallel, 23-55°C(73-130°F)	30/-	E-6/K	ASTM E 831
Coeff. of linear therm. expansion, parallel, 55-160°C	25/*	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, -40-23°C	78/*	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal, 55-160°C	160/*	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, Normal, 23-55°C (73-130°F)	98/-	E-6/K	ASTM E 831

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB/*	class	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.8/*	%	Sim. to ISO 62
Water absorption, 2mm	6.3/*	%	Sim. to ISO 62
Density	1190/-	kg/m ³	ISO 1183

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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	50 °C
Max. mould temperature	120 °C

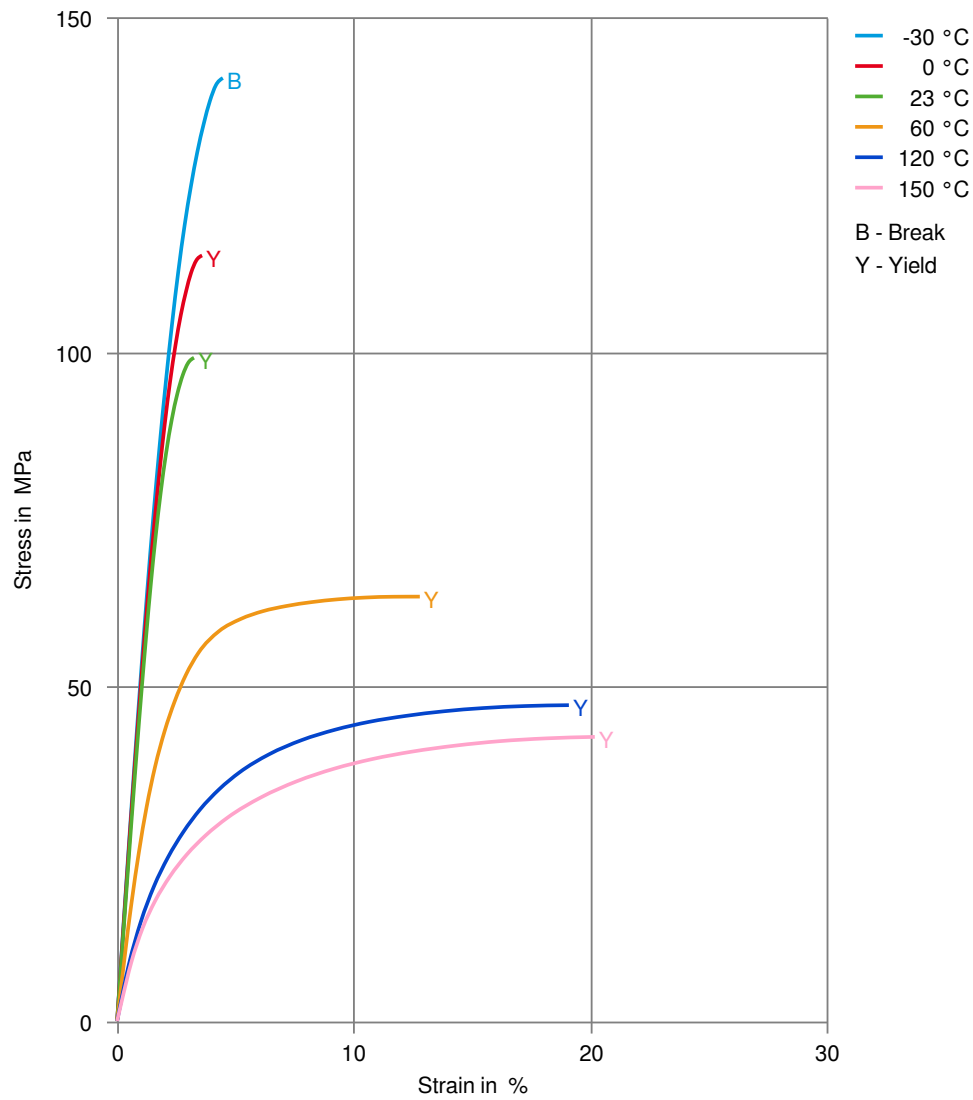
Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	High impact or impact modified, U.V. stabilised or stable to weather, Heat stabilised or stable to heat

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Stress-strain (dry)



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Secant modulus-strain (dry)

