Celanese
The chemistry inside innovation™

# CELANYL® B3 HH J40 NC 1102/3

CELANYL®

*Suitable for making mono and multilayer flexible pipes and other profiles via extrusion process.*

## Product information

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

## Rheological properties

| | dry/cond. | | |
|---|---|---|---|
| Melt mass-flow rate | 3.5 / * | g/10min | ISO 1133 |
| Melt mass-flow rate, Temperature | 235 / * | °C | |
| Melt mass-flow rate, Load | 5 / * | kg | |
| Moulding shrinkage range, parallel | 0.7 - 1 | % | ISO 294-4, 2577 |
| Moulding shrinkage range, normal | 0.7 - 1 | % | ISO 294-4, 2577 |

## Typical mechanical properties

| | dry/cond. | | |
|---|---|---|---|
| Tensile modulus | 1050 / - | MPa | ISO 527-1/-2 |
| Tensile stress at yield, 50mm/min | 30 / - | MPa | ISO 527-1/-2 |
| Tensile strain at yield, 50mm/min | 15 / - | % | ISO 527-1/-2 |
| Tensile stress at break, 50mm/min | 33 / - | MPa | ISO 527-1/-2 |
| Flexural modulus | 1100 / - | MPa | ISO 178 |
| Flexural strength | 35 / - | MPa | ISO 178 |
| Charpy impact strength, 23°C | N / - | kJ/m² | ISO 179/1eU |
| Izod notched impact strength, 23°C | 70 / - | kJ/m² | ISO 180/1A |
| Poisson's ratio | 0.45 / -[C] | | |

[C]: Calculated

## Thermal properties

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

## Flammability

| | | | |
|---|---|---|---|
| Burning rate, Thickness 1 mm | 120 | mm/min | ISO 3795 (FMVSS 302) |

## Physical/Other properties

| | dry/cond. | | |
|---|---|---|---|
| Humidity absorption, 2mm | 1.4 / * | % | Sim. to ISO 62 |
| Water absorption, 2mm | 4.9 / * | % | Sim. to ISO 62 |
| Density | 1010 / - | 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 | 270 | °C |
| Screw tangential speed | ≤0.25 | m/s |
| Mold Temperature Optimum | 70 | °C |

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| | | |
|---|---|---|
| Min. mould temperature | 50 | °C |
| Max. mould temperature | 90 | °C |

## Characteristics

| | |
|---|---|
| Processing | Injection Moulding, Extrusion, Coextrusion |
| Delivery form | Granules |
| Special characteristics | High impact or impact modified, Heat stabilised or stable to heat |