Celanese
The chemistry inside innovation™

CELANYL® B3 HH MGF2515 BK 9005/1A

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Product information

Resin Identification	PA6-(GF+MD)40	ISO 1043
Part Marking Code	>PA6-(GF+MD)40<	ISO 11469

Typical mechanical properties

	dry/cond.		
Tensile modulus	10300 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	120 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.2 / -	%	ISO 527-1/-2
Flexural modulus	9760 / -	MPa	ISO 178
Flexural strength	190 / -	MPa	ISO 178
Charpy impact strength, 23 °C	42 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23 °C	6 / -	kJ/m²	ISO 179/1eA
Poisson's ratio	0.4 / -		

Thermal properties

Thermal conductivity, flow	0.76	W/(m K)	ISO 22007-2
Thermal conductivity, crossflow	0.67	W/(m K)	ISO 22007-2
Thermal conductivity, through plane	0.62	W/(m K)	ISO 22007-2

Physical/Other properties

	dry/cond.		
Density	1480 / -	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, Low Warpage

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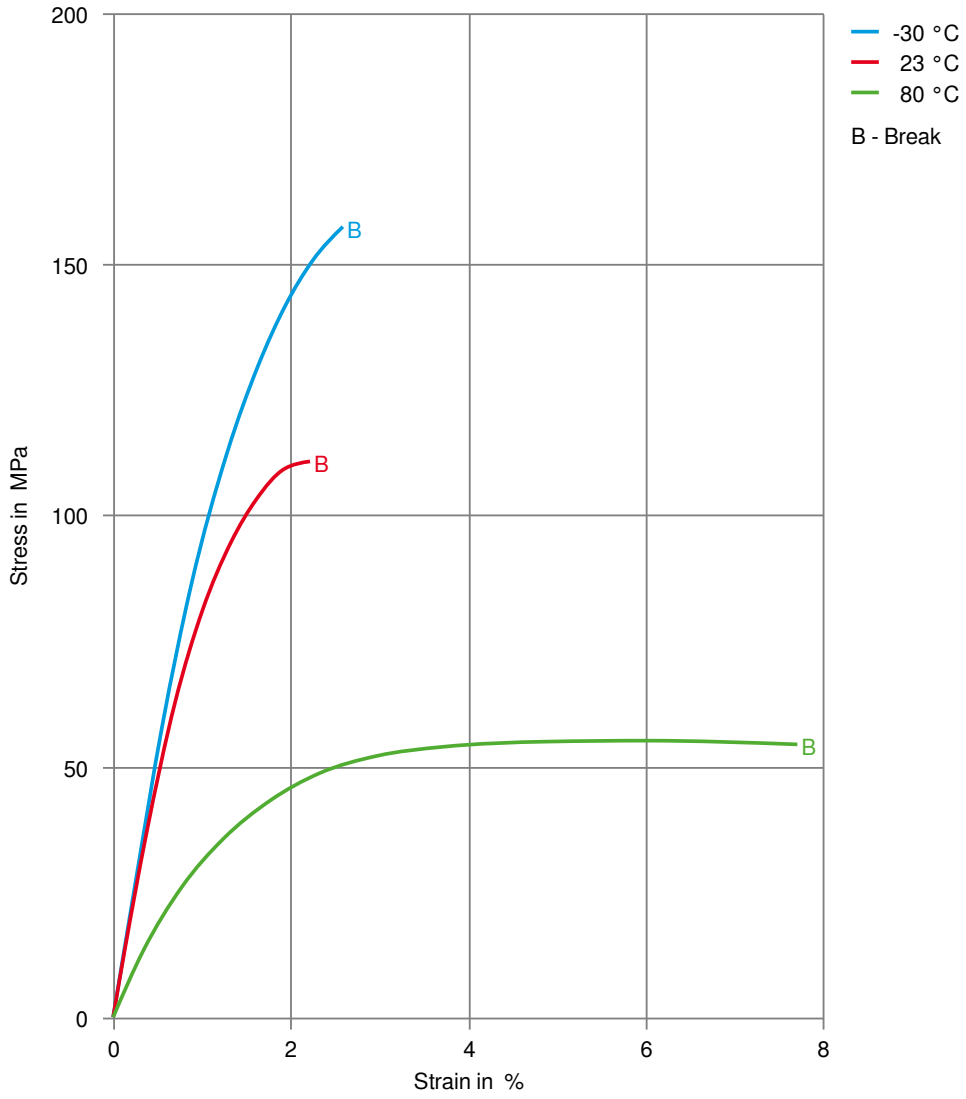
Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
VW Group	VW 50125	*Best Fitting Grade To PA6-13, Not Officially Approved
VW Group	VW 50134	*Best Fitting Grade To PA6-5-A, Not Officially Approved

Stress-strain (dry)



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Secant modulus-strain (dry)