Celanese
The chemistry inside innovation™

CELANYL® B3 W MGF2010 NC 1102

CELANYL®

Designed for good surface quality and low warpage.

Product information

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

Rheological properties

Moulding shrinkage range, parallel	0.4 - 0.9	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.5 - 1	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	5900 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	110 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.2 / -	%	ISO 527-1/-2
Charpy impact strength, 23 °C	38 / -	kJ/m²	ISO 179/1eU
Charpy notched impact strength, 23 °C	3.7 / -	kJ/m²	ISO 179/1eA
Poisson's ratio	0.35 / -[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	220 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	200 / *	°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 thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	IEC 60695-11-10
UL recognition	yes / *		UL 94

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.9 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.5 / *	%	Sim. to ISO 62
Density	1400 / -	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

Celanese
The chemistry inside innovation™

CELANYL® B3 W MGF2010 NC 1102

CELANYL®

Max. mould temperature	120	°C

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	Heat stabilised or stable to heat, Specialty appearance, Low Warpage