

CELANYL® DEV B3 J8 GF33 NJ5057 BOLT GREEN (PRELIMINARY)
CELANYL®

Product information

Resin Identification	PA6-GF33	ISO 1043
Part Marking Code	>PA6-GF33<	ISO 11469

Typical mechanical properties

	dry/cond.		
Tensile modulus	10300/-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	148/-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	5/-	%	ISO 527-1/-2
Flexural modulus	8800/-	MPa	ISO 178
Flexural strength	220/-	MPa	ISO 178
Charpy notched impact strength, 23°C	27.6/-	kJ/m ²	ISO 179/1eA
Poisson's ratio	0.34/- ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	205/*	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Density	1360/-	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	235 °C
Max. melt temperature	270 °C
Screw tangential speed	≤0.3 m/s
Mold Temperature Optimum	70 °C
Min. mould temperature	50 °C
Max. mould temperature	100 °C

Characteristics

Processing	Injection Moulding
Special characteristics	High impact or impact modified