Celanese
The chemistry inside innovation™

FRIANYL® B3 MGF30 V0 BK 9005/V

Polyamide 6 compound, 30% reinforced, flame retardant, free from Halogens and Red Phosphorus.
Car industry, Household appliances, Electrical devices.

Product information

Part Marking Code	PA6-GF30 FR(40)	ISO 11469

Rheological properties

Viscosity number	150	cm^3/g	ISO 307, 1157, 1628
Moulding shrinkage range, parallel	0.2 - 0.5	%	ISO 294-4, 2577
Moulding shrinkage range, normal	0.6 - 1.0	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile Modulus	9400 / -	MPa	ISO 527-1/-2
Stress at break, 5mm/min	115 / -	MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.2 / -	%	ISO 527-1/-2
Charpy impact strength, 23 °C	40 / -	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23 °C	6 / -	kJ/m^2	ISO 179/1eA
Ball indentation hardness, H 358/30	200	MPa	ISO 2039-1

Thermal properties

Melting temperature, 10 °C/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	200	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	215	°C	ISO 75-1/-2

Flammability

Burning Behav. at 1.5mm nom. thickn.	V-0	class	UL 94
Thickness tested	1.6	mm	UL 94
Thickness tested	3.2	mm	UL 94
Glow Wire Flammability Index, 3mm	960	°C	IEC 60695-2-12

Other properties

Humidity absorption, 2mm	1.6	%	Sim. to ISO 62
Water absorption, 2mm	5.5	%	Sim. to ISO 62
Density	1390	kg/m^3	ISO 1183

Characteristics

Additives	Flame retardant, Non-halogenated/Red phosphorous free flame retardant

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Additional information

Injection molding	The following conditions apply to a standard injection moulding process. Machine temperatures: barrel 265-290C (PA66), 235-270C (PA6), nozzle and hot runners up to 300C (up to 290C products with flame retardants). Mould temperatures: 60-80C, (80-100C highly reinforced grades). Back pressure: typically 5-10 bar (hydraulic pressure). Temperatures exceeding 300C and long residence time could lead to additives degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the moulded part characteristics. For further details, please refer to the document 'Instructions for injection moulding' or contact our technical support team.

Processing Texts

Injection molding	The following conditions apply to a standard injection moulding process. Machine temperatures: barrel 265-290C (PA66), 235-270C (PA6), nozzle and hot runners up to 300C (up to 290C products with flame retardants). Mould temperatures: 60-80C, (80-100C highly reinforced grades). Back pressure: typically 5-10 bar (hydraulic pressure). Temperatures exceeding 300C and long residence time could lead to additives degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the moulded part characteristics. For further details, please refer to the document 'Instructions for injection moulding' or contact our technical support team.
Injection molding Preprocessing	PA materials, stocked in a moisture-proof packaging, can be processed without drying; however, it is always recomended drying the product that comes from a large package (e.g. Octabin). The moisture content suggested for the injection moulding process should be lower than 0.15%, according to the grade and to the moulded part characteristics. The materials containing flame retardants should have moisture content below 0.10%. Red phosphorous containing grades must always be dried below 0.08%. The drying time depends on the moisture content and the drying conditions. Typically 4-8 hours at 80-90C using dehumidified air (dew point of -20C) are suitable conditions for a starting moisture content of 0.20%-0.40%.
Injection molding Postprocessing	PA materials reach their final performance with a water content of about 1.5 to 3.5% by weight, depending on the type. This percentage corresponds to the point of equilibrium between the rates of absorption and desorption of moisture. After moulding, in favourable environmental conditions, a part can quickly absorbs moisture up to 0.5-1.0%, while the equilibrium will be reached during its life. A conditioning treatment can accelerate further the initial water absorption of the moulded parts. Conditioning is usually carried out in hot and humid environment (for example 50C, 100% RH), inside climatic chambers. Slight dimensional variations (increase in volume due to the water absorbed) must be taken into

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account, especially in unfilled grades. Post-treatments of parts may also include the annealing (60-80C in oven, up to four hours). This procedure can be useful to relax any internal stresses.