

CELANYL[®] A3 GB30 NC 1102

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General purpose grade, easy processing, low warpage.

Product information

Resin Identification	(PA66+PA6)-GB30	ISO 1043
Part Marking Code	>(PA66+PA6)-GB30<	ISO 11469
Continuous Service Temperature	90 °C	IEC 60216-1

Rheological properties

	dry/cond.		
Viscosity number	145 / *	cm ³ /g	ISO 307, 1628
Moulding shrinkage range, parallel	1 - 1.4	%	ISO 294-4, 2577
Moulding shrinkage range, normal	1 - 1.4	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	4100 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	80 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	5 / -	%	ISO 527-1/-2
Charpy impact strength, 23 °C	22 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23 °C	2.2 / -	kJ/m ²	ISO 179/1eA
Ball indentation hardness, H 961/30	190 / -	MPa	ISO 2039-1
Poisson's ratio	0.36 / - ^[C]		
[C]: Calculated			

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	260 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	90 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	220 / *	°C	ISO 75-1/-2

Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.5 / *	%	Sim. to ISO 62
Water absorption, 2mm	7 / *	%	Sim. to ISO 62
Density	1350 / -	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	295 °C
Min. melt temperature	285 °C
Max. melt temperature	305 °C
Screw tangential speed	≤0.2 m/s
Mold Temperature Optimum	100 °C
Min. mould temperature	70 °C

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Max. mould temperature

120 °C

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Special characteristics	High Flow, Low Warpage