

CELANYL® A3 HH J6 GF18 BK 9005/1 - PA66

Description

(OMNILON® PA6/6 GR18 IM6 HS)
18% Glass Reinforced, Impact Modified, Heat Stabilized, PA66

Physical properties	Value	Unit	Test Standard
Density	75.5	lb/ft ³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile stress at yield, 23°C	15500	psi	ASTM D638
Tensile strain at break, 23°C	4	%	ASTM D638
Flexural modulus, 23°C	700000	psi	ASTM D790
Flexural stress, 23°C	23400	psi	ASTM D790
Izod impact notched, 23°C	2.6	ft-lb/in	ASTM D256

Thermal properties	Value	Unit	Test Standard
DTUL at 1.8 MPa	469	°F	ISO 75-1, -2
DTUL at 0.45 MPa	500	°F	ISO 75-1, -2

Typical injection molding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	0.15	%
Drying time	4 - 8	h
Drying temperature	176 - 194	°F

Temperature	Value	Unit
Zone1 temperature	500 - 518	°F
Zone2 temperature	509 - 527	°F
Zone3 temperature	527 - 545	°F
Zone4 temperature	527 - 554	°F
Nozzle temperature	545 - 572	°F
Melt temperature	536 - 563	°F
Mold temperature	140 - 176	°F
Hot runner temperature	545 - 572	°F

Characteristics

Special Characteristics	Heat resistant
Product Categories	Impact modified
Processing	Injection molding