

CELANYL® A3 HH M25 NC 1102/UV/2

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General purpose grade, easy processing, low warpage and good surface quality. Suitable for outdoor use.

Product information

Resin Identification	(PA66+PA6)-MF25	ISO 1043
Part Marking Code	>(PA66+PA6)-MF25<	ISO 11469
Continuous Service Temperature	120 °C	IEC 60216-1

Rheological properties

Moulding shrinkage range, parallel	0.6 - 1 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.7 - 1.1 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	4500 /-	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	85 /-	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	10 /-	%	ISO 527-1/-2
Flexural modulus	4000 /-	MPa	ISO 178
Flexural strength	120 /-	MPa	ISO 178
Charpy impact strength, 23°C	>100 /-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	4 /-	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	5.5 /-	kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C	4.0 /-	kJ/m ²	ISO 180/1A
Poisson's ratio	0.35 / - ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	264 / *	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	76 / *	°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	1.8 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.5 / *	%	Sim. to ISO 62
Density	1320 / -	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

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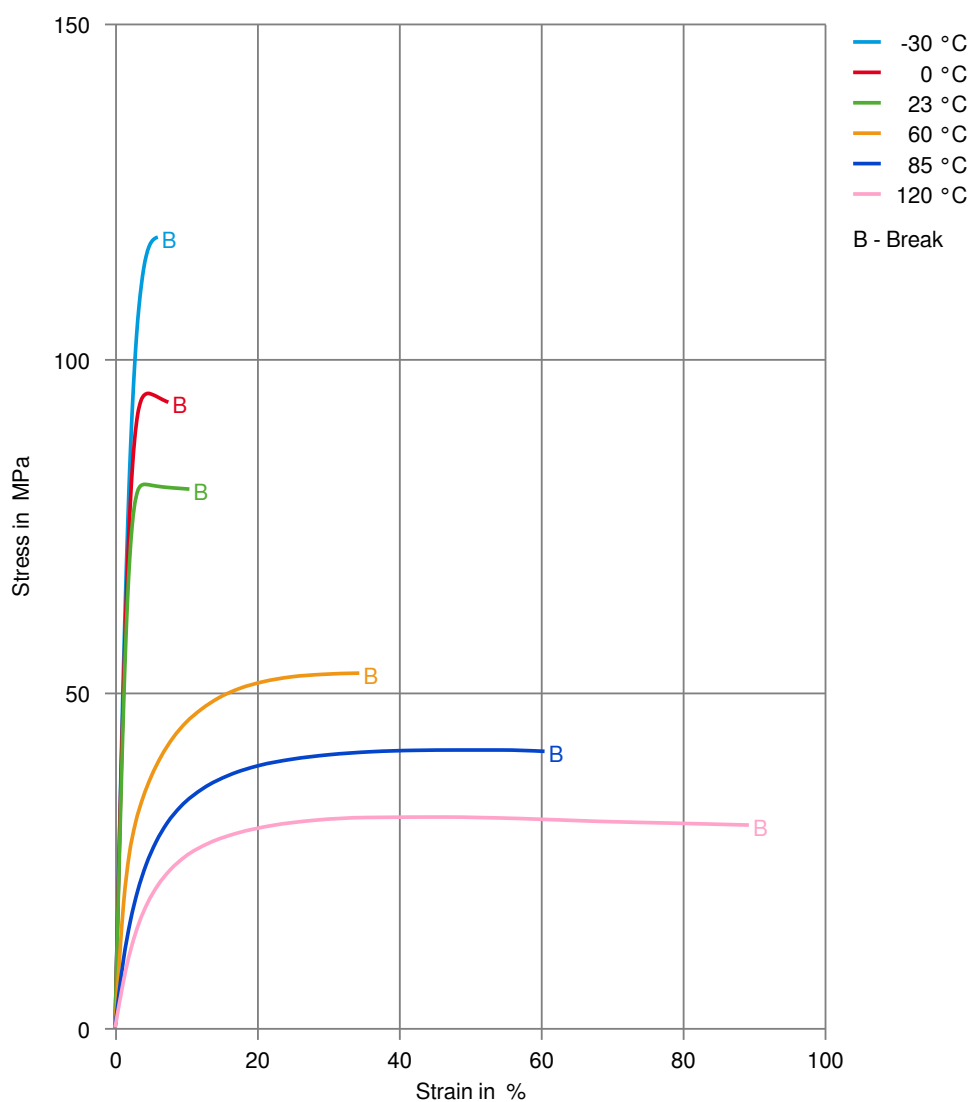
Min. mould temperature
Max. mould temperature

70 °C
120 °C

Characteristics

Processing	Injection Moulding
Delivery form	Granules
Additives	Mineral Filler
Special characteristics	U.V. stabilised or stable to weather, Heat stabilised or stable to heat, High Flow, Low Warp

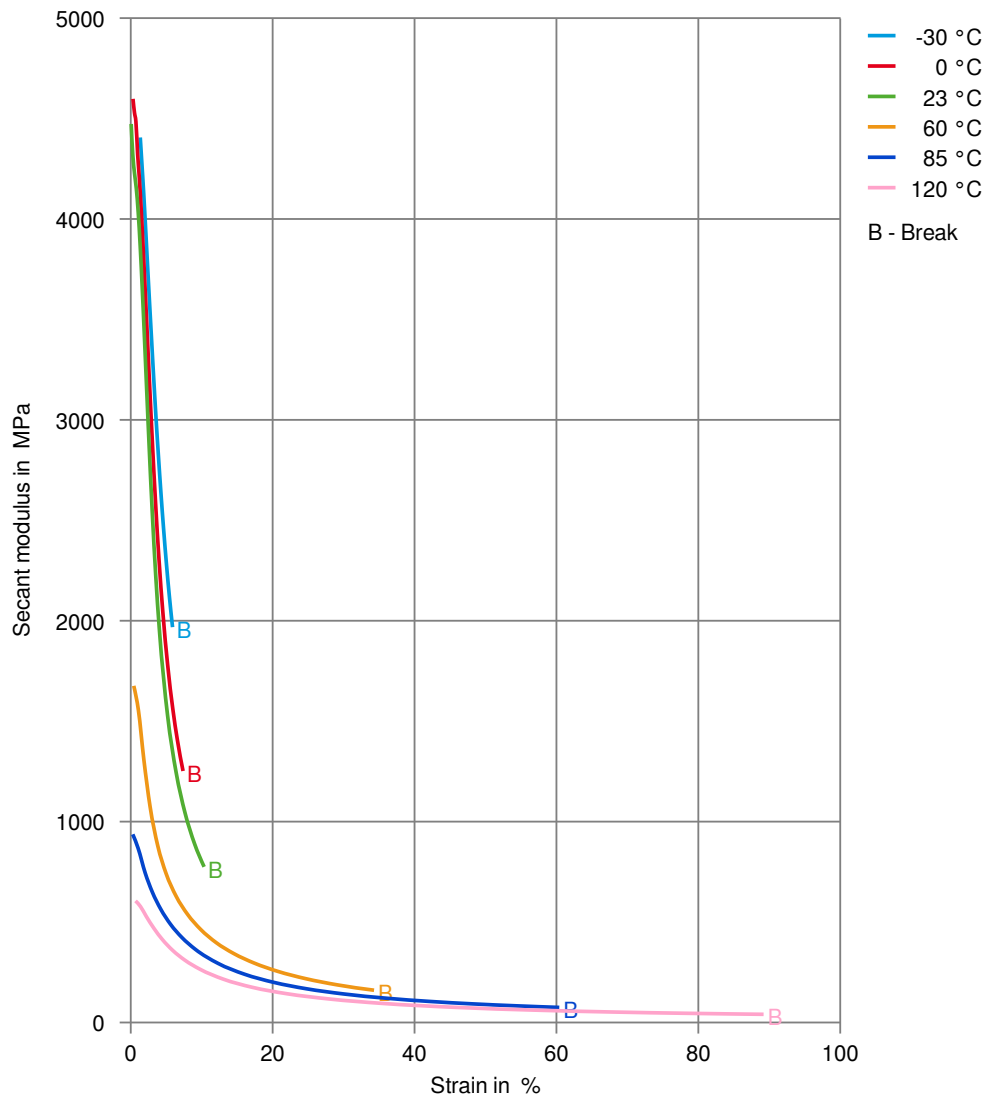
Stress-strain (dry)



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Secant modulus-strain (dry)



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