

CELANYL® A3 K30 BK 9004

CELANYL®

Product information

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|----------------------|-------------|-----------|
| Resin Identification | PA66-MD30 | ISO 1043 |
| Part Marking Code | >PA66-MD30< | ISO 11469 |

Rheological properties

| | | | |
|-----------------------|-----------|------------------------|----------|
| | dry/cond. | | |
| Melt volume-flow rate | 4/* | cm ³ /10min | ISO 1133 |
| Temperature | 270/* | °C | |
| Load | 5/* | kg | |

Typical mechanical properties

| | | | |
|--------------------------------------|-----------------------|-------------------|--------------|
| | dry/cond. | | |
| Tensile modulus | 3700/- | MPa | ISO 527-1/-2 |
| Tensile stress at break, 5mm/min | 65/- | MPa | ISO 527-1/-2 |
| Tensile strain at break, 5mm/min | 15/- | % | ISO 527-1/-2 |
| Charpy impact strength, 23°C | 120/- | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength, 23°C | 10/- | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength, 23°C | 9/- | kJ/m ² | ISO 180/1A |
| Izod impact strength, 23°C | 135/- | kJ/m ² | ISO 180/1U |
| Poisson's ratio | 0.36/- ^[C] | | |

[C]: Calculated

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 |
| Max. mould temperature | 120 °C |

Characteristics

| | |
|------------|--------------------|
| Processing | Injection Moulding |
|------------|--------------------|

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