



ISO 294-4, 2577

CELANYL® A4 E GF25 BK 9005

CELANYL®

Designed as 'all in one solution' specifically for the thermal break insulation profiles extrusion.

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Resin Identification Part Marking Code Continuous Service Temperature	(PA66+PA6)-GF >(PA66+PA6)-G 10	ISO 1043 ISO 11469 IEC 60216-1	
Rheological properties	dry/cond.		
Melt volume-flow rate	14/*	cm ³ /10min	ISO 1133
Temperature	275/*	°C	
Load	5/*	kg	
Moulding shrinkage range, parallel	0.3 - 0.6	%	ISO 294-4, 2577

0.6 - 0.9

dry/cond.

Typical mechanical properties

Moulding shrinkage range, normal

7700/5400	MPa	ISO 527-1/-2
140/95	MPa	ISO 527-1/-2
4/6.5	%	ISO 527-1/-2
7700/-	MPa	ISO 178
200/-	MPa	ISO 178
65/80	kJ/m²	ISO 179/1eU
11.5/15	kJ/m²	ISO 179/1eA
12/-	kJ/m²	ISO 180/1A
0.34/0.35 ^[C]		
	140/95 4/6.5 7700/- 200/- 65/80 11.5/15 12/-	140/95 MPa 4/6.5 % 7700/- MPa 200/- MPa 65/80 kJ/m² 11.5/15 kJ/m²

Thermal properties

Melting temperature, 10°C/min	260/*	°C	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	245/*	°C	ISO 75-1/-2

dry/cond.

dry/cond.

Physical/Other properties

Humidity absorption, 2mm	1.6/*	%	Sim. to ISO 62
Water absorption, 2mm	6/*	%	Sim. to ISO 62
Density	1310/-	kg/m³	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
Max. mould temperature	120 °C

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Revised: 2024-08-16 Source: Celanese Materials Database

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Characteristics

Processing Injection Moulding, Extrusion

Delivery form Granules

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