Celanese
The chemistry inside innovation™

CELANYL® A4 E GF25 BK 9005/P

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

Product information

Resin Identification	(PA66+PA6)-GF25		ISO 1043
Part Marking Code	>(PA66+PA6)-GF25<		ISO 11469
Continuous Service Temperature	100	°C	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
Moulding shrinkage range, normal	0.6 - 0.9	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	8000 / 5500	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	145 / 95	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	4 / 6.5	%	ISO 527-1/-2
Flexural modulus	8000 / -	MPa	ISO 178
Flexural strength	220 / -	MPa	ISO 178
Charpy impact strength, 23°C	65 / 80	kJ/m^2	ISO 179/1eU
Charpy notched impact strength, 23°C	12 / 15	kJ/m^2	ISO 179/1eA
Izod notched impact strength, 23°C	12 / -	kJ/m^2	ISO 180/1A
Izod impact strength, 23°C	68 / -	kJ/m^2	ISO 180/1U
Poisson's ratio	0.34 / 0.35[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	245 / *	°C	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.6 / *	%	Sim. to ISO 62
Water absorption, 2mm	6 / *	%	Sim. to ISO 62
Density	1310 / -	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, Extrusion
Delivery form	Granules

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