CELANYL® A3 H GF25 BK 9005/P

CELANYL®

General purpose grade for any technical use. Easy flow.

Product information

Resin Identification	(PA66+PA6)-GF25	ISO 1043
Part Marking Code	>(PA66+PA6)-GF25<	ISO 11469
Continuous Service Temperature	266 °F	IEC 60216-1

Rheological properties

Molding shrinkage range, parallel	0.4 - 0.7 %	ISO 294-4, 2577
Molding shrinkage range, normal	0.7 - 1 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	1.15E6 / -	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	20300 / -	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5 / -	%	ISO 527-1/-2
Flexural modulus	1.19E6 / -	psi	ISO 178
Flexural strength	33400 / -	psi	ISO 178
Charpy impact strength, 23 °C	23.8 / -	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23 °C	3.09 / -	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23 °C	3.57 / -	ftlb/in²	ISO 180/1A
Izod notched impact strength, -30 °C	2.85 / -	ftlb/in²	ISO 180/1A
Ball indentation hardness, H 961/30	24700 / -	psi	ISO 2039-1

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	500 / *	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	455 / *	°F	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	482 / *	°F	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	2 / *	%	Sim. to ISO 62
Water absorption, 2mm	7.2 / *	%	Sim. to ISO 62
Density	0.0473 / -	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	176	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.15	%
Melt Temperature Optimum	563	°F
Min. melt temperature	545	°F
Max. melt temperature	581	°F
Max. screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	176	°F

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

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Min. mold temperature	122	°F
Max. mold temperature	212	°F

Characteristics

Processing	Injection Molding
Special characteristics	Heat stabilized or stable to heat, High Flow

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