CELANYL® A3 HH GF30 BK 9005/F

CELANYL®

Car industry, Household appliances, Electrical devices.

Product information

Resin Identification	PA66-GF30	ISO 1043
Part Marking Code	>PA66-GF30<	ISO 11469

Rheological properties

	dry/cond.		
Melt volume-flow rate	40 / *	cm^3/10min	ISO 1133
Temperature	518 / *	°F	
Load	11 / *	lb	
Viscosity number	3740 / *	in^3/lb	ISO 307, 1628
Molding shrinkage, parallel	0.2 / -	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / -	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	1.32E6 / -	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	25400 / -	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	3.5 / -	%	ISO 527-1/-2
Charpy impact strength, 23°C	35.7 / -	$ftlb/in^2$	ISO 179/1eU
Charpy notched impact strength, 23°C	4.99 / -	$ftlb/in^2$	ISO 179/1eA
Charpy notched impact strength, -30°C	5.23 / -	$ftlb/in^2$	ISO 179/1eA
Izod notched impact strength, 23°C	4.76 / -	$ftlb/in^2$	ISO 180/1A
Izod impact strength, 23°C	30.9 / -	$ftlb/in^2$	ISO 180/1U

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	482 / *	°F	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Density	0.0487 / -	lb/in^3	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	212	°F
Min. mold temperature	158	°F
Max. mold temperature	248	°F
Ejection temperature	396	°F

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

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Characteristics

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

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