CELANYL® A3 HH M25 NC 1102/UV/2

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General purpose grade, easy processing, low warpage and good surface quality. Suitable for outdoor use.

Product information

Resin Identification	(PA66+PA6)-MF25	ISO 1043
Part Marking Code	>(PA66+PA6)-MF25<	ISO 11469
Infrared spectrum	available	
TGA curve	available	ISO 11358-1
Continuous Service Temperature	248 °F	IEC 60216-1

Rheological properties

Molding shrinkage range, parallel	0.6 - 1 %	ISO 294-4, 2577
Molding shrinkage range, normal	0.7 - 1.1 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	653000 / -	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	12300 / -	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	10 / -	%	ISO 527-1/-2
Flexural modulus	580000 / -	psi	ISO 178
Flexural strength	18100 / -	psi	ISO 178
Charpy impact strength, 23°C	>100 / -	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	1.9 / -	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	2.62 / -	ftlb/in²	ISO 180/1A
Izod notched impact strength, -30°C	1.9 / -	ftlb/in²	ISO 180/1A

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	507 / *	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	169 / *	°F	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	0.47 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), Parallel, 23-55°C(73-130°F)	0.344 / -	E-4/°F	ASTM E 831
Coefficient of linear thermal expansion (CLTE), parallel, -40-23°C	0.294 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), parallel, 55-160°C	0.606 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	0.561 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), Normal,23-55°C (73-130°F)	0.383 / -	E-4/°F	ASTM E 831
Coefficient of linear thermal expansion (CLTE), normal, -40-23°C	0.383 / *	E-4/°F	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal, 55-160°C	0.722 / *	E-4/°F	ISO 11359-1/-2

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Flammability

	dry/cond.		
Burning Behav. at 1.5mm nom. thickn.	HB / *	class	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.8 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.5 / *	%	Sim. to ISO 62
Density	0.0477 / -	lb/in³	ISO 1183

Emissions

Odor test	2	class	VDA 270

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

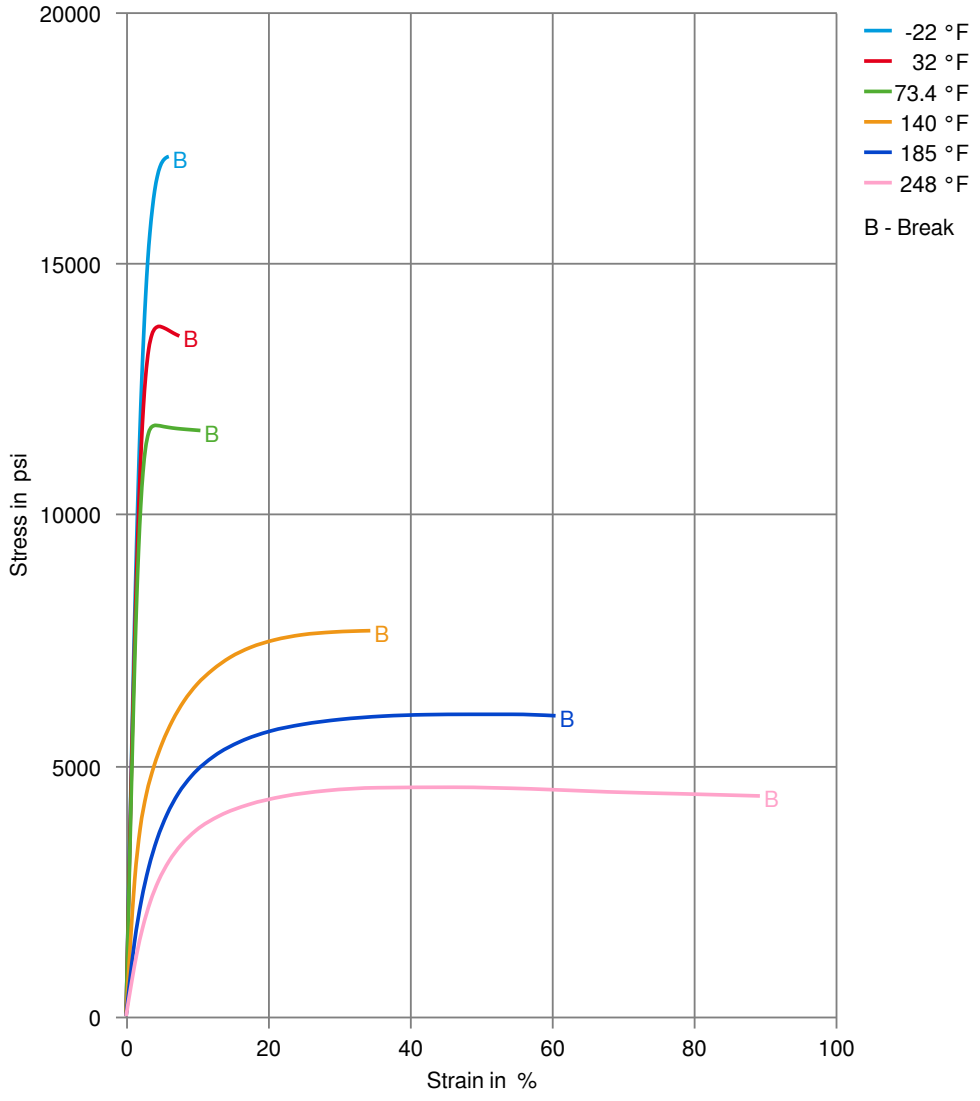
Characteristics

Processing	Injection Molding
Special characteristics	U.V. stabilized or stable to weather, Heat stabilized or stable to heat, High Flow, Low Warpage

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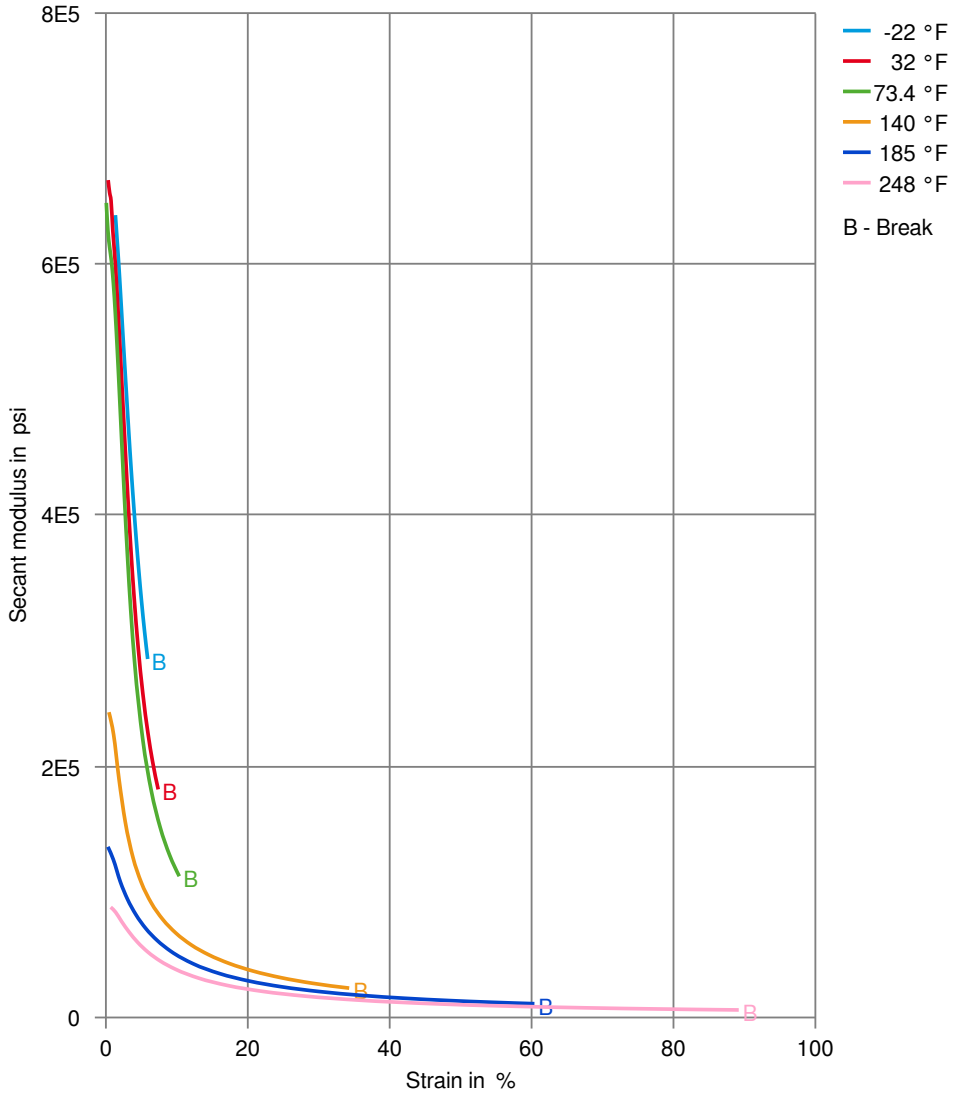
Stress-strain (dry)



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Secant modulus-strain (dry)



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