CELANYL® A3 J GF15 BK 9005/U

CELANYL®

Injection molding grade designed for Automotive parts, good impact resistance even at low temperature and good surface quality.

Product information

Resin Identification	PA66-I-GF15	ISO 1043
Part Marking Code	>PA66-I-GF15<	ISO 11469

Rheological properties

Molding shrinkage range, parallel	0.5 - 0.9	%	ISO 294-4, 2577
Molding shrinkage range, normal	0.9 - 1.3	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	682000 / -	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	13800 / -	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	4.8 / -	%	ISO 527-1/-2
Flexural modulus	609000 / -	psi	ISO 178
Flexural strength	18900 / -	psi	ISO 178
Charpy impact strength, 23 °C	N / -	ftlb/in²	ISO 179/1eU
Charpy impact strength, -30 °C	21.4 / -	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23 °C	4.99 / -	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30 °C	2.28 / -	ftlb/in²	ISO 179/1eA

Thermal properties

	dry/cond.		
Melting temperature, 10 °C/min	509 / *	°F	ISO 11357-1/-3

Flammability

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

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.7 / *	%	Sim. to ISO 62
Water absorption, 2mm	6.1 / *	%	Sim. to ISO 62
Density	0.0426 / -	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
Min. mold temperature	122	°F
Max. mold temperature	212	°F

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

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Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Mercedes-Benz	DBL5410	DAIMLER - ELFO AG - Short Circuit Isolation - CNL A3 J GF15 BK9005/U

Characteristics

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

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