CELANYL® B3 HH J40 NC 1102/3

CELANYL®

Suitable for making mono and multilayer flexible pipes and other profiles via extrusion process.

Product information

Resin Identification	PA6-I		ISO 1043
Part Marking Code	>PA6-I<		ISO 11469

Rheological properties

	dry/cond.		
Melt mass-flow rate	3.5 / *	g/10min	ISO 1133
Melt mass-flow rate, Temperature	455 / *	°F	
Melt mass-flow rate, Load	11 / *	lb	
Molding shrinkage range, parallel	0.7 - 1	%	ISO 294-4, 2577
Molding shrinkage range, normal	0.7 - 1	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	152000 / -	psi	ISO 527-1/-2
Tensile stress at yield, 50mm/min	4400 / -	psi	ISO 527-1/-2
Tensile strain at yield, 50mm/min	15 / -	%	ISO 527-1/-2
Tensile stress at break, 50mm/min	4790 / -	psi	ISO 527-1/-2
Flexural modulus	160000 / -	psi	ISO 178
Flexural strength	5080 / -	psi	ISO 178
Charpy impact strength, 23°C	N / -	ftlb/in²	ISO 179/1eU
Izod notched impact strength, 23°C	33.3 / -	ftlb/in²	ISO 180/1A

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	437 / *	°F	ISO 11357-1/-3

Flammability

Burning rate, Thickness 1 mm	4.72	in/min	ISO 3795 (FMVSS 302)

Physical/Other properties

	dry/cond.		
Humidity absorption, 2mm	1.4 / *	%	Sim. to ISO 62
Water absorption, 2mm	4.9 / *	%	Sim. to ISO 62
Density	0.0365 / -	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	500	°F
Min. melt temperature	464	°F
Max. melt temperature	518	°F
Max. screw tangential speed	≤0.25	m/s
Mold Temperature Optimum	158	°F
Min. mold temperature	122	°F
Max. mold temperature	194	°F

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

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Characteristics

Processing	Injection Molding, Extrusion, Coextrusion
Special characteristics	High impact or impact modified, Heat stabilized or stable to heat, High viscosity

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