CELANYL® B3 J GF30 BK 9005/X

CELANYL®

Car industry, Household appliances, Electrical devices.

产品信息

树脂鉴别	PA6-I-GF30		ISO 1043
制品标识码	>PA6-I-GF30<		ISO 11469
连续使用温度	95	°C	IEC 60216-1

流变性能

	dry/cond.		
粘数	140/*	cm^3/g	ISO 307, 1628
模塑收缩率范围, 平行	0.2 - 0.5	%	ISO 294-4, 2577
模塑收缩率范围, 垂直	0.8 - 1.1	%	ISO 294-4, 2577

机械性能

	dry/cond.		
拉伸模量	7800/-	MPa	ISO 527-1/-2
拉伸断裂应力, 5mm/min	115/-	MPa	ISO 527-1/-2
断裂伸长率, 5mm/min	3/-	%	ISO 527-1/-2
简支梁无缺口冲击强度, 23°C	65/-	kJ/m^2	ISO 179/1eU
简支梁无缺口冲击强度, -30°C	55/-	kJ/m^2	ISO 179/1eU
简支梁缺口冲击强度, 23°C	12/-	kJ/m^2	ISO 179/1eA

热性能

	dry/cond.		
熔融温度, 10°C/min	225/*	°C	ISO 11357-1/-3

其它性能

	dry/cond.		
吸湿率, 2mm	1.5/*	%	类似ISO 62
吸水率, 2mm	6.5/*	%	类似ISO 62
密度	1280/-	kg/m^3	ISO 1183

特性

加工方法	注塑
特殊性能	抗冲改性

其他信息

注塑

Preprocessing

PA materials, stocked in a moisture-proof packaging, can be processed without drying; however, it is always recomended drying the product that comes from a large package (e.g. Octabin). The moisture content suggested for the injection moulding process should be lower than 0.15%, according to the grade and to the moulded part characteristics. The materials containing flame retardants should have moisture content below 0.10%. Red phosphorous containing grades must always be dried below 0.08%. The drying time depends on the moisture content and the drying conditions. Typically 4-8 hours at 80-90C using dehumidified air (dew point of -20C) are suitable conditions for a starting moisture content of 0.20%-0.40%.

Revised: 2025-07-08 Source: Celanese Materials Database

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Processing

The following conditions apply to a standard injection moulding process. Machine temperatures: barrel 265-290C (PA66), 235-270C (PA6), nozzle and hot runners up to 300C (up to 290C products with flame retardants). Mould temperatures: 60-80C, (80-100C highly reinforced grades). Back pressure: typically 5-10 bar (hydraulic pressure). Temperatures exceeding 300C and long residence time could lead to additives degradation and brittleness of the material. In case of gas generation in the melt, please verify moisture content and processing temperatures. Usage of regrind is possible depending on the moulded part characteristics. For further details, please refer to the document 'Instructions for injection moulding' or contact our technical support team.

Postprocessing

PA materials reach their final performance with a water content of about 1.5 to 3.5% by weight, depending on the type. This percentage corresponds to the point of equilibrium between the rates of absorption and desorption of moisture. After moulding, in favourable environmental conditions, a part can quickly absorbs moisture up to 0.5-1.0%, while the equilibrium will be reached during its life. A conditioning treatment can accelerate further the initial water absorption of the moulded parts. Conditioning is usually carried out in hot and humid environment (for example 50C, 100% RH), inside climatic chambers. Slight dimensional variations (increase in volume due to the water absorbed) must be taken into account, especially in unfilled grades. Post-treatments of parts may also include the annealing (60-80C in oven, up to four hours). This procedure can be useful to relax any internal stresses.

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