CELANYL® XS3 GF60 BK 9005/C EF

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Compound designed for parts with maximu mechanical requirements, typically used to replace metal due to the high stiffness and strength, stable after conditioning. It shows better creep behavior and dimensional stability vs. an equivalent PA66 grade, with lower warpage and excellent surface finish.

Product information

Resin Identification	(PA6I/6T+PA66)-GF60	ISO 1043
Part Marking Code	>(PA6I/6T+PA66)-GF60<	ISO 11469

Rheological properties

Molding shrinkage range, parallel	0.1 - 0.3	%	ISO 294-4, 2577
Molding shrinkage range, normal	0.3 - 0.5	%	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile modulus	3.12E6 / -	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	36300 / -	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2.5 / -	%	ISO 527-1/-2
Flexural strength	42100 / 34800	psi	ISO 178
Charpy impact strength, 23°C	40.4 / -	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	7.14 / -	ftlb/in²	ISO 179/1eA
Izod notched impact strength, 23°C	7.61 / -	ftlb/in²	ISO 180/1A
Izod impact strength, 23°C	35.7 / -	ftlb/in²	ISO 180/1U

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	500 / *	°F	ISO 11357-1/-3

Flammability

	dry/cond.		
Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.0157 / *	in	IEC 60695-11-10

Physical/Other properties

	dry/cond.		
Density	0.0614 / -	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	176	°F
Drying Time, Dehumidified Dryer	4 - 6	h
Processing Moisture Content	≤0.1	%
Melt Temperature Optimum	554	°F
Min. melt temperature	518	°F
Max. melt temperature	581	°F
Max. screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	176	°F
Min. mold temperature	140	°F
Max. mold temperature	212	°F

Revised: 2026-06-12 Source: Celanese Materials Database

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Characteristics

Processing	Injection Molding
Special characteristics	Heat stabilized or stable to heat, High Gloss, Low Warpage, Improved creep

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