

CELANYL® A3 GB30 BK 9005/U - PA66

Description

Polyamide 66 compound, 30% glass bead reinforced, heat stabilized

This compound is intended for injection molding. It is primarily designed for the Automotive Industry but also suitable for Electrical and Electronic or Industrial & Consumer applications.

Preliminary Technical Datasheet

Physical properties	Value	Unit	Test Standard
Density	84.3	lb/ft ³	ISO 1183
Molding shrinkage, parallel (flow)	1.0 - 1.3	%	ISO 294-4, 2577
Molding shrinkage, transverse normal	1.0 - 1.3	%	ISO 294-4, 2577
Water absorption, 23°C-sat	7	%	Sim. to ISO 62
Humidity absorption, 23°C/50%RH	1.5	%	ISO 62
Viscosity number (PA), H ₂ SO ₄	145	ml/g	ISO 307 (PA)

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	609160/-	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	10900/-	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	5/-	%	ISO 527-1, -2
Charpy impact strength, 23°C	14.3/-	ft-lb/in ²	ISO 179/1eU
Charpy notched impact strength, 23°C	1.43/-	ft-lb/in ²	ISO 179/1eA
Ball indentation hardness, 30s	26800	psi	ISO 2039-1

Thermal properties	Value	Unit	Test Standard
Melting temperature, 20°C/min	500	°F	ISO 11357-1/-3
DTUL at 1.8 MPa	392	°F	ISO 75-1, -2
DTUL at 0.45 MPa	428	°F	ISO 75-1, -2

Other text information

Injection Molding Preprocessing

PA materials, stocked in a moisture-proof packaging, can be processed without drying; however, it is always recommended drying the product that comes from a large package (e.g. Octabin). The moisture content suggested for the injection molding process should be lower than 0.15%, according to the grade and to the molded 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 80-90°C using dehumidified air (dew point of -20°C) are suitable conditions for a starting moisture content of 0.20%-0.40%.

Injection molding

The following conditions apply to a standard injection molding process. Machine temperatures: barrel 265-290°C (PA66), 235-270°C (PA6), nozzle and hot runners up to 300°C (up to 290°C products with flame retardants). Mold temperatures: 60-80°C, (80-100°C highly reinforced grades). Back pressure: typically, 5-10 bar (hydraulic pressure). Temperatures exceeding 300°C 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 molded part characteristics. For further details, please refer to the document 'Instructions for injection molding' or contact our technical support team.

Injection Molding 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 molding, in favorable environmental conditions, a part can quickly absorb 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 molded parts. Conditioning is usually carried out in hot and humid environment (for example 50°C, 100% RH), inside climatic chambers. Slight dimensional variations (increase in volume due to the water absorbed) must be considered, especially in unfilled grades. Post-treatments of parts may also include the annealing (60-80°C in oven, up to four hours). This procedure can be useful to relax any internal stresses.



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Characteristics

Special Characteristics	Heat resistant, High flow
Processing	Injection molding

