

CELANYL® A3 J06 NC 1102

PA66, unfilled, low temperature impact resistant
 Car industry, Household appliances, Electrical devices.

Product information

Part Marking Code	PA66-I	ISO 11469
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Rheological properties

Viscosity number	145 cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage range, parallel	1.5 - 1.8 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.5 - 1.8 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.	
Tensile Modulus	2500/-	MPa
Yield stress, 50mm/min	65/-	MPa
Strain at break, 50mm/min	40/-	%
Charpy notched impact strength, 23°C	7.5/-	kJ/m ²

Thermal properties

Melting temperature, 10°C/min	260 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	60 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	180 °C	ISO 75-1/-2

Other properties

Humidity absorption, 2mm	1.9 %	Sim. to ISO 62
Water absorption, 2mm	8 %	Sim. to ISO 62
Density	1110 kg/m ³	ISO 1183

Additional information

Injection molding

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.



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Processing Texts

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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 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%.

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 moulding, in favourable 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 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.

