

CELANYL® B2 GF15 BK 9005/1 - PA6
Description

(OMNILON® PA6 GR15 BK1000)
 15% Glass Reinforced, PA6

Physical properties	Value	Unit	Test Standard
Density	1230	kg/m ³	ISO 1183
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	7000	MPa	ISO 527-1, -2
Tensile stress at break, 5mm/min	130	MPa	ISO 527-1, -2
Tensile strain at break, 5mm/min	2.5	%	ISO 527-1, -2
Flexural modulus, 23 °C	6700	MPa	ISO 178
Flexural strength, 23 °C	220	MPa	ISO 178
Charpy notched impact strength, 23 °C	5.5	kJ/m ²	ISO 179/1eA

Typical injection molding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	0.15	%
Drying time	4 - 8	h
Drying temperature	80 - 90	°C
Temperature	Value	Unit
Zone1 temperature	220 - 230	°C
Zone2 temperature	225 - 235	°C
Zone3 temperature	235 - 245	°C
Zone4 temperature	245 - 255	°C
Nozzle temperature	255 - 270	°C
Melt temperature	250 - 270	°C
Mold temperature	60 - 80	°C
Hot runner temperature	255 - 270	°C