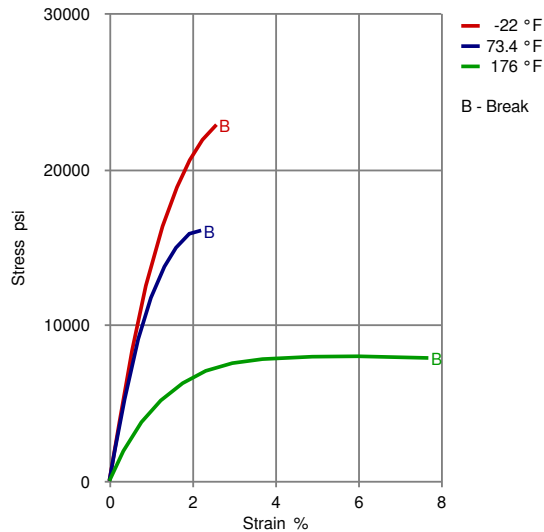
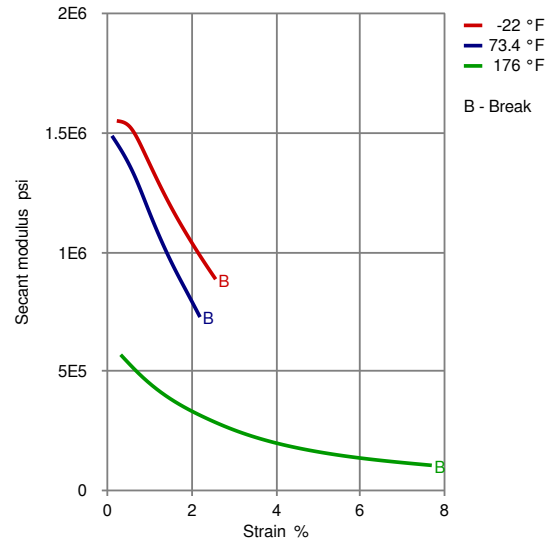


CELANYL® B3 HH MGF2515 BK 9005/1A - PA6
Description

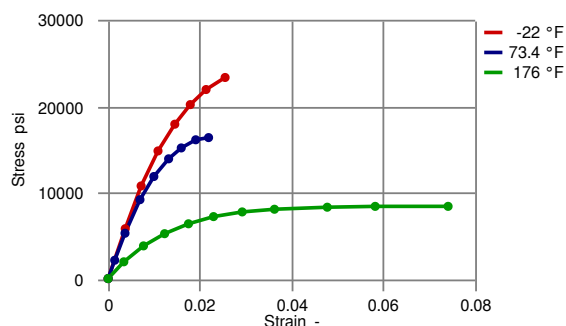
(OMNILON® PA6 GMR40 BK1000)
 40% Glass/Mineral Reinforced, Heat Stabilized, PA6

Physical properties	Value	Unit	Test Standard
Density	92.4	lb/ft ³	ISO 1183
Mechanical properties	Value	Unit	Test Standard
Tensile modulus	1.49E6/-	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	17400/-	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	2.2/-	%	ISO 527-1, -2
Poissons ratio	0.4	-	ISO 527-1, -2
Flexural modulus, 23°C	1.42E6/-	psi	ISO 178
Flexural strength, 23°C	27600/-	psi	ISO 178
Charpy impact strength, 23°C	20/-	ft-lb/in ²	ISO 179/1eU
Charpy notched impact strength, 23°C	2.85/-	ft-lb/in ²	ISO 179/1eA

Diagrams
Stress-strain (dry)

Secant modulus-strain (dry)


CELANYL® B3 HH MGF2515 BK 9005/1A - PA6

True Stress-strain (dry)



Dry samples are dry as molded
No yield at -30 or 23 °C
80 °C yield at 0.05835 strain, 57.720 stress
Poisson's ratio used is 0.40

Typical injection molding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	0.15	%
Drying time	4 - 8	h
Drying temperature	176 - 194	°F

Temperature	Value	Unit
Zone1 temperature	428 - 446	°F
Zone2 temperature	437 - 455	°F
Zone3 temperature	455 - 473	°F
Zone4 temperature	473 - 491	°F
Nozzle temperature	491 - 518	°F
Melt temperature	482 - 518	°F
Mold temperature	140 - 176	°F
Hot runner temperature	491 - 518	°F

Characteristics

Special Characteristics	Heat resistant, Low warpage
Product Categories	Mineral/Glass reinforced
Processing	Injection molding

Other Approvals

OEM	Specification	Additional Information
VW Group*	VW50125	* best fitting grade to PA6-13, not officially approved
VW Group*	VW50134	* best fitting grade to PA6-5-A, not officially approved