

CELANYL® B3 W MGF2015 NC 1102/1 - PA6
Description

(OMNILON® PA6 GMR35 HS)
35% Glass/Mineral Reinforced, Heat Stabilized, PA6

Physical properties	Value	Unit	Test Standard
Density	86.2	lb/ft ³	ISO 1183
Mechanical properties	Value	Unit	Test Standard
Tensile stress at yield, 23°C	13500	psi	ASTM D638
Tensile strain at break, 23°C	4	%	ASTM D638
Flexural modulus, 23°C	670000	psi	ASTM D790
Flexural stress, 23°C	21000	psi	ASTM D790
Izod impact notched, 23°C	0.693	ft-lb/in	ASTM D256

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
Processing	Injection molding

General Disclaimer

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