

CELANYL® A3 K30 BK 9004

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Product information

Resin Identification	PA66-MD30	ISO 1043
Part Marking Code	>PA66-MD30<	ISO 11469

Rheological properties

	dry/cond.		
Melt volume-flow rate	4 / *	cm ³ /10min	ISO 1133
Temperature	270 / *	°C	
Load	5 / *	kg	

Typical mechanical properties

	dry/cond.		
Tensile modulus	3700 / -	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	65 / -	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	15 / -	%	ISO 527-1/-2
Charpy impact strength, 23 °C	120 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23 °C	10 / -	kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23 °C	9 / -	kJ/m ²	ISO 180/1A
Izod impact strength, 23 °C	135 / -	kJ/m ²	ISO 180/1U
Poisson's ratio	0.36 / - ^[C]		

[C]: Calculated

Injection

Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.15 %
Melt Temperature Optimum	295 °C
Min. melt temperature	285 °C
Max. melt temperature	305 °C
Screw tangential speed	≤0.2 m/s
Mold Temperature Optimum	100 °C
Min. mould temperature	70 °C
Max. mould temperature	120 °C

Additional 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%.

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Processing

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.

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.