CELSTRAN® PEHD-GF60-01 - PE-HD

Description

60% long strand glass fiber reinforced high density polyethylene
58% long strand glass fiber reinforced high density polyethylene

Physical properties	Value	Unit	Test Standard
Density	**93.6**	lb/ft^3	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**1.52E6**	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	**13200**	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	**1.38**	%	ISO 527-1, -2
Flexural modulus, 23°C	**1.7E6**	psi	ISO 178
Flexural strength, 23°C	**23200**	psi	ISO 178
Charpy notched impact strength, 23°C	**14.3**	ft-lb/in^2	ISO 179/1eA

Typical injection moulding processing conditions

Pre Drying	Value	Unit
Necessary low maximum residual moisture content	**0.2**	%
Drying time	**2**	h
Drying temperature	**194 - 212**	°F

Temperature	Value	Unit
Feeding zone temperature	**68 - 122**	°F
Zone1 temperature	**392 - 410**	°F
Zone2 temperature	**410 - 428**	°F
Zone3 temperature	**428 - 446**	°F
Zone4 temperature	**446 - 464**	°F
Nozzle temperature	**446 - 464**	°F
Melt temperature	**446 - 464**	°F
Mold temperature	**104 - 158**	°F

Other text information

Pre-drying

It is normally not necessary to dry CELSTRAN PP. However, should there be surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required.

Longer pre-drying times/storage

The product can then be stored in standard conditions until processed.

Characteristics

Special Characteristics	Chemical resistant, Fuel resistant
Product Categories	Glass reinforced, Tribological
Delivery Form	Pellets