Celanese
The chemistry inside innovation™

COOLPOLY® E3617 - PA6

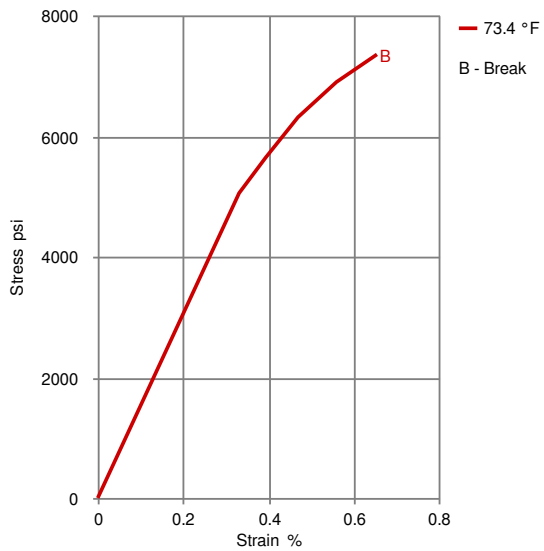
Physical properties	Value	Unit	Test Standard
Density	**101**	lb/ft³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**1.52E6**	psi	ISO 527-1, -2
Tensile stress at break, 5mm/min	**6820**	psi	ISO 527-1, -2
Tensile strain at break, 5mm/min	**0.6**	%	ISO 527-1, -2
Flexural modulus, 23°C	**1.81E6**	psi	ISO 178
Flexural strength, 23°C	**10900**	psi	ISO 178
Charpy impact strength, 23°C	**2.14**	ft-lb/in²	ISO 179/1eU

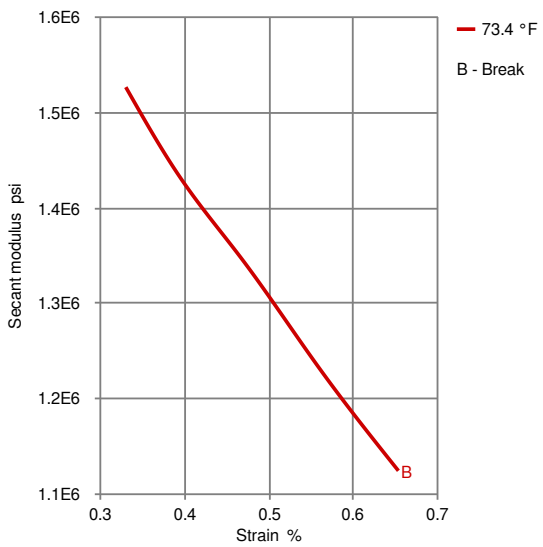
Thermal properties	Value	Unit	Test Standard
Thermal conductivity, flow	**31**	W/(m K)	ASTM E1461
Thermal conductivity, crossflow	**24**	W/(m K)	ASTM E1461
Thermal conductivity, thruplane	**4.5**	W/(m K)	ASTM E1461
Specific heat	**0.451**	BTU/(lb·F)	ASTM E1461

Diagrams

Stress-strain



Secant modulus-strain



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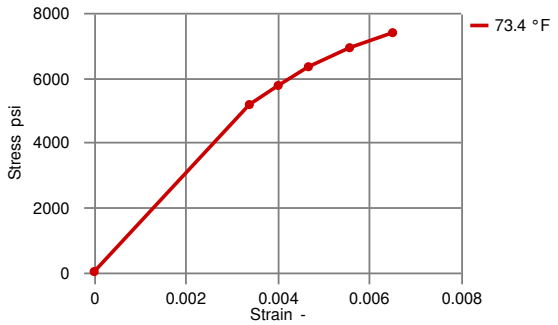
True Stress-strain



No yield

Typical injection moulding processing conditions

Pre Drying	Value	Unit
Drying time	**2 - 4**	h
Drying temperature	**176**	°F

Temperature	Value	Unit
Zone1 temperature	**428 - 482**	°F
Zone2 temperature	**437 - 527**	°F
Zone3 temperature	**455 - 536**	°F
Zone4 temperature	**455 - 536**	°F
Nozzle temperature	**455 - 536**	°F
Melt temperature	**450 - 540**	°F
Mold temperature	**100 - 199**	°F

Pressure	Value	Unit
Back pressure max.	**30**	bar

Speed	Value
Injection speed	**medium-fast**

Other text information

Pre-drying

- A low compression screw (less than 2.5:1) is recommended.
- Due to drool a reverse taper nozzle is suggested
- During startup raise nozzle temperature until process stabilizes to help prevent initial nozzle freeze-off
- Material should be dried to a moisture content level of .05% or less prior to injection molding.
- Material is moisture sensitive. During processing use of a preheated desiccant dryer 175F is advised to keep material dry.
- Immediately close and seal any bag or container of unused material.

Characteristics

Special Characteristics	Thermally conductive
Processing	Injection molding

General Disclaimer

NOTICE TO USERS: Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values. Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.To the best of our knowledge, the information contained in this publication is accurate; however, we do not assume any liability whatsoever for the accuracy and completeness of such information. The information contained in this publication should not be construed as a promise or guarantee of specific properties of our products. It is the sole responsibility of the users to investigate whether any existing patents are infringed by the use of the materials mentioned in this publication.Moreover, there is a need to reduce human exposure to many materials to the lowest practical limits in view of possible adverse effects. To the extent that any hazards may have been mentioned in this publication, we neither suggest nor guarantee that such hazards are the only ones that exist. We recommend that persons intending to rely on any recommendation or to use any equipment, processing technique or material mentioned in this publication should satisfy themselves that they can meet all applicable safety and health standards.We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products. The products mentioned herein are not intended for use in medical or dental implants.

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