CELSTRAN® PA6-GF40-01 | PA6 | Glass Reinforced

Description

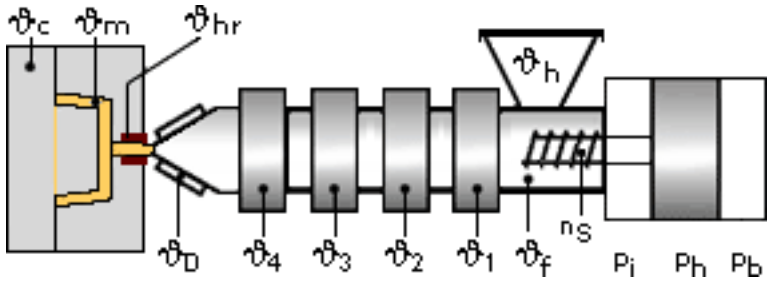
40% long strand glass fiber reinforced nylon 6 Natural

Physical properties	Value	Unit	Test Standard
Specific gravity	**1.45**	-	ASTM D792
Mold shrinkage - flow direction	**.0005-.001**	in/in	ASTM D955
Mold shrinkage - transverse direction	**.0025-.003**	in/in	ASTM D955

Mechanical properties	Value	Unit	Test Standard
Elongation @ break (250°F)	**3**	%	ASTM D638
Elongation @ break (-40°F)	**2.6**	%	ASTM D638
Elongation @ break (73°F)	**2.5**	%	ASTM D638
Tensile modulus (-40°F)	**1.71E6**	psi	ASTM D638
Tensile modulus (73°F)	**1.95E6**	psi	ASTM D638
Tensile modulus (250°F)	**1.06E6**	psi	ASTM D638
Tensile strength @ break (-40°F)	**40800**	psi	ASTM D638
Tensile strength @ break (73°F)	**34400**	psi	ASTM D638
Tensile strength @ break (250°F)	**15400**	psi	ASTM D638

Thermal properties	Value	Unit	Test Standard
Heat deflection temperature @264 psi	**410**	°F	ASTM D648

Typical injection moulding processing conditions



Pre Drying:

Necessary low maximum residual moisture content: 0.18%

CELSTRAN PA should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be =< -30°C. The time between drying and processing should be as short as possible.

Note: Material can be over dried and may discolor.

Drying time: 2 - 4 h

Drying temperature: 158 - 176 °F

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Temperature:

	Mold	Melt	Nozzle	Zone4	Zone3	Zone2	Zone1	Feed	Hopper
min (°F)	176	518	527	527	527	518	509	68	158
max (°F)	212	536	536	536	536	527	527	122	176

Injection Molding

Celstran can be processed on a standard injection molding unit.
A general purpose metering screw is recommended with a zone
distribution of 40% feed, 40% transition, and 20% metering.
A free flowing check ring assembly is recommended.

Melt Temp: 275-285°C.
Mold Temp: 85- 95°C.

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