

CELSTRAN® PA6-GF40-03 | PA6 | Glass Reinforced

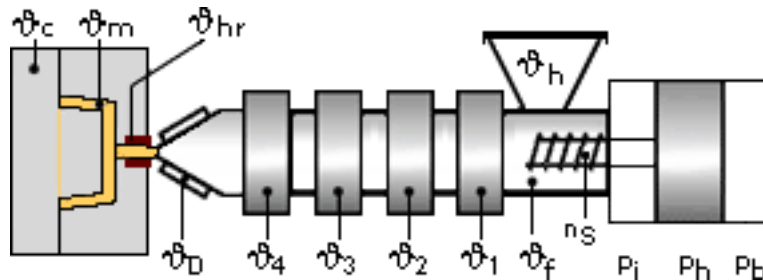
Description

40% long fiber glass reinforced, heat and UV stabilized, Nylon 6

Physical properties	Value	Unit	Test Standard
Density	1450	kg/m ³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	12500	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	205	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	2.2	%	ISO 527-2/1A
Flexural modulus (23°C)	12000	MPa	ISO 178
Flexural strength (23°C)	325	MPa	ISO 178
Charpy notched impact strength @ 23°C	26	kJ/m ²	ISO 179/1eA

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 $\leq -30^{\circ}\text{C}$. 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: 70 - 80 °C

Temperature:

	θ_{Mold}	θ_{Melt}	θ_{Nozzle}	θ_{Zone4}	θ_{Zone3}	θ_{Zone2}	θ_{Zone1}	θ_{Feed}	θ_{Hopper}
min (°C)	80	270	275	275	275	270	265	20	70
max (°C)	100	280	280	280	280	275	275	50	80

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