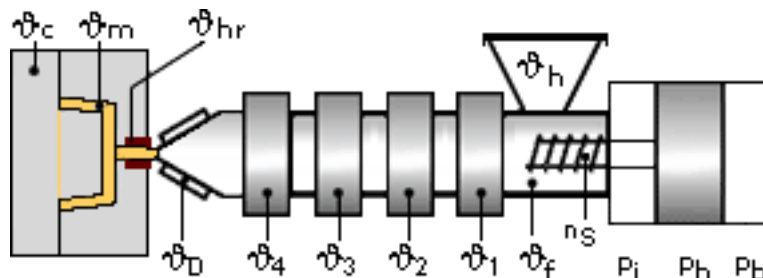


CELSTRAN® PA6-GF50-03 | PA6 | UV Resistant

Description

Nylon 6 with 50% long glass reinforcement, heat stabilized

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: 158 - 176 °F

Temperature:

	θMold	θMelt	θNozzle	θZone4	θZone3	θZone2	θZone1	θFeed	θHopper
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: 285-295°C.

Mold Temp: 85- 95°C.

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