

CELSTRAN® PA6-GF60-01 | PA6 | Glass Reinforced

Description

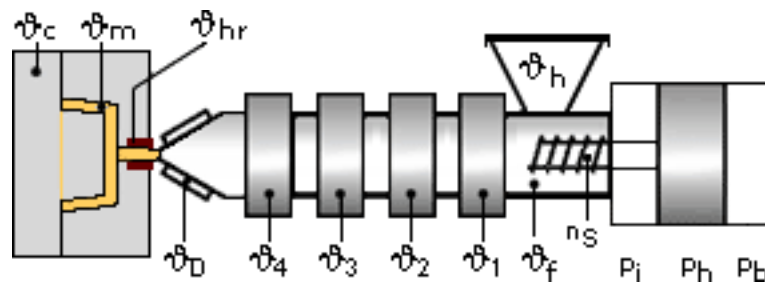
60% long strand glass fiber reinforced nylon 6 Natural

Physical properties	Value	Unit	Test Standard
Specific gravity	1.69	-	ASTM D792
Mold shrinkage - flow direction	.0005-.001	in/in	ASTM D955
Mold shrinkage - transverse direction	.001-.002	in/in	ASTM D955

Mechanical properties	Value	Unit	Test Standard
Elongation @ break (250°F)	2	%	ASTM D638
Elongation @ break (-40°F)	2.1	%	ASTM D638
Elongation @ break (73°F)	1.9	%	ASTM D638
Tensile modulus (-40°F)	3.15E6	psi	ASTM D638
Tensile modulus (73°F)	3.20E6	psi	ASTM D638
Tensile modulus (250°F)	2.02E6	psi	ASTM D638
Tensile strength @ break (-40°F)	47700	psi	ASTM D638
Tensile strength @ break (73°F)	40000	psi	ASTM D638
Tensile strength @ break (250°F)	19500	psi	ASTM D638

Thermal properties	Value	Unit	Test Standard
Heat deflection temperature @264 psi	415	°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 $\leq -30^{\circ}\text{C}$. 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

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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: 290-300°C.
Mold Temp: 90- 100°C.

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