



Celstran® PA6-GF30-01

Celanese Corporation - Polyamide 6

Monday, November 4, 2019

General Information

Product Description

30% long strand glass fiber reinforced nylon 6 Black

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Long Glass Fiber, 30% Filler by Weight
RoHS Compliance	• Contact Manufacturer
Appearance	• Black

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.38E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	22500	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.8	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.28E+6	psi	ISO 178
Flexural Stress	36300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	8.6	ft-lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	405	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	158 to 176	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.18	%
Hopper Temperature	158 to 176	°F
Rear Temperature	500 to 518	°F
Middle Temperature	509 to 527	°F
Front Temperature	518 to 536	°F
Nozzle Temperature	518 to 536	°F
Processing (Melt) Temp	518 to 536	°F
Mold Temperature	176 to 212	°F

Injection Notes

Feeding zone temperature: 20 to 50°C
Zone4 temperature: 270 to 280°C

Notes

¹ Typical properties: these are not to be construed as specifications.