



Celstran® PA6-GF40-03

Celanese Corporation - Polyamide 6

Monday, November 4, 2019

General Information

Product Description

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

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Long Glass Fiber, 40% Filler by Weight
Additive	• Heat Stabilizer • UV Stabilizer
Features	• Heat Stabilized
RoHS Compliance	• Contact Manufacturer

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.81E+6	psi	ISO 527-2/1A/1
Tensile Stress (Break)	29700	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.2	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.74E+6	psi	ISO 178
Flexural Stress (73°F)	47100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	12	ft-lb/in ²	ISO 179/1eA

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	509 to 527	°F
Middle Temperature	518 to 527	°F
Front Temperature	527 to 536	°F
Nozzle Temperature	527 to 536	°F
Processing (Melt) Temp	518 to 536	°F
Mold Temperature	176 to 212	°F

Injection Notes

Zone 4 Temperature: 275 to 280°C

Feed Temperature: 20 to 50°C

Notes

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