Celstran® PA6-GF60-01

Celanese Corporation - Polyamide 6

Monday, November 4, 2019

General Information

Product Description			
60% long strand glass fiber reinforced nylon 6 Natural			
General			
Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Long Glass Fiber, 60% Filler by Weight		
RoHS Compliance	• Contact Manufacturer		
Appearance	• Natural Color		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.69	g/cm³	ISO 1183
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2.96E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	39900	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	2.67E+6	psi	ISO 178
Flexural Stress (73°F)	66000	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	26	ft·lb/in²	ISO 179/1eA
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	419	°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	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

Feeding zone temperature: 20 to 50°C

Zone4 temperature: 275 to 280°C

Notes

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