

CELSTRAN® PA6-GF60-01 AF3001 Natural

PA6-GLF60

Celanese

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	20400	MPa	ISO 527
^[C] Stress at break	275	MPa	ISO 527
^[C] Strain at break	1.9	%	ISO 527
^[C] Charpy notched impact strength, +23°C	54	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	215	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1690	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Melt temperature	290 - 300	°C	-
Mold temperature	90 - 100	°C	-

Characteristics**Processing**

Injection Molding

Features

Long fiber reinforced

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific

Other text information**Injection molding**

PA6&PA66 drying requirements: 4 hrs. @80° C.

A dehumidifier or desiccant dryer is recommended.

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.