CELSTRAN® PA6-GF30-01

PA6-GLF30 Celanese

Mechanical properties	Value	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**9510**	MPa	ISO 527
[C] Stress at break	**155**	MPa	ISO 527
[C] Strain at break	**1.78**	%	ISO 527
[C] Charpy notched impact strength, +23°C	**18**	kJ/m²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
[C] Temp. of deflection under load, 1.80 MPa	**207**	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Density	**1360**	kg/m³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**4**	h	-
Melt temperature	**270 - 280**	°C	-
Mold temperature	**85 - 95**	°C	-

Characteristics

Processing
Injection Molding

Features
Long fiber reinforced

Delivery form
Pellets

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: 270-280°C.
Mold Temp: 85- 95°C.