

Celstran® PA6-GF60-01

Polyamide 6

Celanese Corporation

Message:

60% long strand glass fiber reinforced nylon 6 Natural

General Information			
Filler / Reinforcement	Long glass fiber, 60% filler by weight		
RoHS Compliance	Contact manufacturer		
Appearance	Natural color		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.69	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow	0.050 - 0.10	%	ASTM D955
Transverse flow	0.10 - 0.20	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-40°C	21700	MPa	ASTM D638
23°C	22100	MPa	ASTM D638
121°C	13900	MPa	ASTM D638
--	20300	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, -40°C	329	MPa	ASTM D638
Fracture, 23°C	276	MPa	ASTM D638
Fracture, 121°C	134	MPa	ASTM D638
Fracture	250	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, -40°C	2.1	%	ASTM D638
Fracture, 23°C	1.9	%	ASTM D638
Fracture, 121°C	2.0	%	ASTM D638
Fracture	1.6	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	18200	MPa	ISO 178
Flexural Stress (23°C)	405	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	48	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, not annealed	213	°C	ASTM D648
1.8 MPa, not annealed	215	°C	ISO 75-2/A
Injection	Nominal Value	Unit	

Drying Temperature	70.0 - 80.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.18	%
Hopper Temperature	70.0 - 80.0	°C
Rear Temperature	265 - 275	°C
Middle Temperature	270 - 275	°C
Front Temperature	275 - 280	°C
Nozzle Temperature	275 - 280	°C
Processing (Melt) Temp	270 - 280	°C
Mold Temperature	80.0 - 100	°C

Injection instructions

Zone 4 Temperature: 275 to 280°C Feed Temperature: 20 to 50°C

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