

Celstran® PA6-GF40-01

Polyamide 6

Celanese Corporation

Message:

40% long strand glass fiber reinforced nylon 6 Natural

General Information			
UL YellowCard	E113269-237772		
Filler / Reinforcement	Long glass fiber, 40% filler by weight		
RoHS Compliance	Contact manufacturer		
Appearance	Natural color		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow	0.050 - 0.10	%	ASTM D955
Transverse flow	0.25 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-40°C	11800	MPa	ASTM D638
23°C	13400	MPa	ASTM D638
121°C	7310	MPa	ASTM D638
--	12400	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, -40°C	281	MPa	ASTM D638
Fracture, 23°C	237	MPa	ASTM D638
Fracture, 121°C	106	MPa	ASTM D638
Fracture	205	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, -40°C	2.6	%	ASTM D638
Fracture, 23°C	2.5	%	ASTM D638
Fracture, 121°C	3.0	%	ASTM D638
Fracture	2.1	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	11100	MPa	ISO 178
Flexural Stress (23°C)	335	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	32	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	210	°C	ASTM D648, 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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