Celanese
The chemistry inside innovation™

CELSTRAN® PA6-GF30-01

CELSTRAN® Long Fibre

30% long strand glass fiber reinforced nylon 6 Black

Product information

Resin Identification	PA6-LGF30	ISO 1043
Part Marking Code	>PA6-LGF30<	ISO 11469

Typical mechanical properties

Tensile modulus	9510	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	155	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.8	%	ISO 527-1/-2
Flexural modulus	8830	MPa	ISO 178
Flexural strength	250	MPa	ISO 178
Charpy notched impact strength, 23°C	18	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C	26	kJ/m²	ISO 180/1A
Izod impact strength, -40°C	23.5	kJ/m²	ISO 180/1U
Poisson's ratio	0.34[C]		

[C]: Calculated

Thermal properties

Temperature of deflection under load, 1.8 MPa	207	°C	ISO 75-1/-2

Physical/Other properties

Density	1360	kg/m³	ISO 1183

Characteristics

Processing	Injection Moulding
Delivery form	Pellets

Additional information

Injection molding

Preprocessing

PA6&PA66 drying requirements: 4 hrs. @80° C.
A dehumidifier or desiccant dryer is recommended.

Processing

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.

Processing Notes

Pre-Drying

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CELSTRAN PA should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be =< -30 °C. The time between drying and processing should be as short as possible.

Storage

Note: Material can be over dried and may discolor.