

# CELSTRAN® PA6-GF60-01 P11/10

## CELSTRAN® Long Fibre

60% long strand glass fiber reinforced nylon 6 Natural

### Product information

Resin Identification	PA6-LGF60	ISO 1043
Part Marking Code	>PA6-LGF60<	ISO 11469

### Typical mechanical properties

Tensile modulus	21000 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	275 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.9 %	ISO 527-1/-2
Flexural modulus	19000 MPa	ISO 178
Flexural strength	450 MPa	ISO 178
Charpy impact strength, 23°C	100 kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	54 kJ/m <sup>2</sup>	ISO 179/1eA
Poisson's ratio	0.33 <sup>[C]</sup>	

[C]: Calculated

### Thermal properties

Temperature of deflection under load, 1.8 MPa	215 °C	ISO 75-1/-2
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### Physical/Other properties

Density	1690 kg/m <sup>3</sup>	ISO 1183
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### 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: 290-300°C.  
Mold Temp: 90- 100°C.

Processing Notes

### Pre-Drying

CELSTRAN PA should in principle be predried. Because of the necessary low

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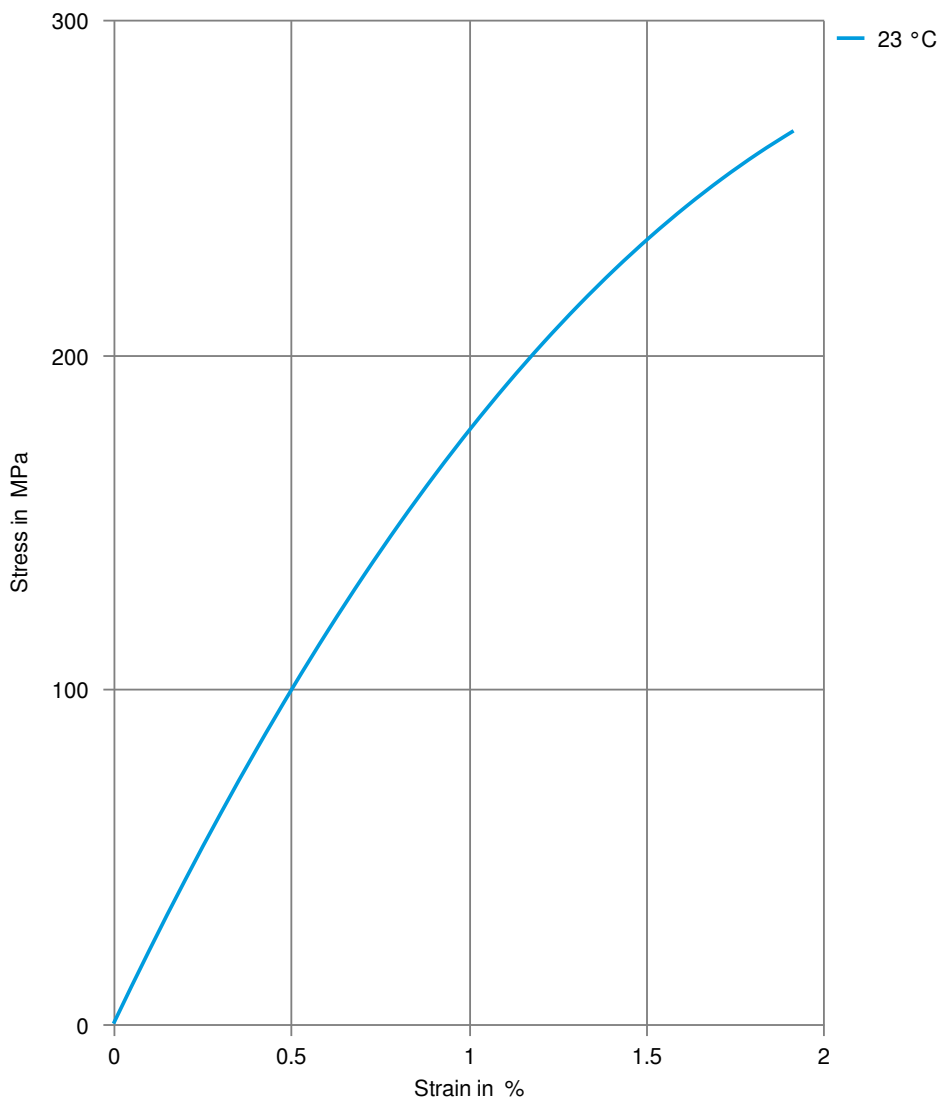
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maximum residual moisture content the use of dry air dryers is recommended. The dew point should be  $\leq -30^{\circ}\text{C}$ . The time between drying and processing should be as short as possible.

### Storage

Note: Material can be over dried and may discolor.

### Stress-strain



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## Secant modulus-strain

