

**CELSTRAN® PP-GF60-04 Black - PP**
**Description**

Material code according to ISO 1043-1: PP Polypropylene with 60 weight percent fiber content, long glass fibers reinforced concentrate. Black. The fibers are chemically coupled to the polypropylene matrix. The pellets are cylindrical and normally as well as the embedded fibers 11 mm long. Concentrate (-0403 = heat stabilized, -0453 = low emission) Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection. The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly. The very isotropic shrinkage in the molded parts minimizes the warpage. Complex parts can be manufactured with high reproducibility by injection molding. Application field: Functional/structural parts for automotive

Physical properties	Value	Unit	Test Standard
Density	1430	kg/m <sup>3</sup>	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	15000	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	145	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1.5	%	ISO 527-2/1A
Flexural modulus, 23°C	16000	MPa	ISO 178
Flexural modulus, 80°C	11000	MPa	ISO 178
Flexural strength, 23°C	240	MPa	ISO 178
Flexural strength, 80°C	136	MPa	ISO 178
Charpy impact strength, 23°C	68	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	70	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	33	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	38	kJ/m <sup>2</sup>	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10°C/min	168	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	160	°C	ISO 75-1, -2

**Typical injection moulding processing conditions**

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.2	%	-
Drying time	2	h	-
Drying temperature	90 - 100	°C	-
Temperature	Value	Unit	Test Standard
Feeding zone temperature	20 - 50	°C	-
Zone1 temperature	220 - 240	°C	-
Zone2 temperature	230 - 240	°C	-
Zone3 temperature	240 - 250	°C	-
Zone4 temperature	240 - 260	°C	-
Nozzle temperature	240 - 260	°C	-
Melt temperature	230 - 260	°C	-
Mold temperature	30 - 70	°C	-
Hot runner temperature	230 - 270	°C	-
Pressure	Value	Unit	Test Standard
Back pressure max.	30	bar	-
Speed	Value	Unit	Test Standard
Injection speed	slow	-	-
Screw Speed	Value	Unit	Test Standard
Screw speed diameter, 40mm	50	RPM	-
Screw speed diameter, 55mm	35	RPM	-
Screw speed diameter, 75mm	25	RPM	-

**Other text information**

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### **Pre-drying**

It is normally not necessary to dry CELSTRAN PP. However, should there be surface moisture (condensate) on the molding compound as a result of incorrect storage, drying is required.

### **Longer pre-drying times/storage**

The product can then be stored in standard conditions until processed.

### **Characteristics**

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<b>Product Categories</b>	<b>Delivery Form</b>
Glass reinforced	Pellets