

CELSTRAN® ABS-GF40-05 Natural

Celstran ABS

Celstran Long Fiber Reinforced ABS-GF40-05 Natural is a 40% long glass ABS, This material imparts excellent impact and modulus properties that exceed that of short fiber ABS.

Typical mechanical properties

	dry/cond.		
Tensile Modulus	10600 / -	MPa	ISO 527-1/-2
Stress at break, 5mm/min	98 / -	MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.15 / -	%	ISO 527-1/-2
Flexural Modulus	10900 / -	MPa	ISO 178
Flexural Strength	182	MPa	ISO 178
Charpy notched impact strength, 23°C	28 / -	kJ/m ²	ISO 179/1eA

Injection

Drying Temperature	80 - 85 °C
Drying Time, Dehumidified Dryer	4 h
Processing Moisture Content	0.02 %
Screw tangential speed	0.1 m/s
Max. mould temperature	70 - 90 °C
Back pressure	3 MPa
Injection speed	medium

Processing Texts

Pre-drying

CELSTAN PC/ABS 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 $\leq -30^{\circ}\text{C}$. The time between drying and processing should be as short as possible.

