

CELSTRAN® PA6-GF30-01

30% long strand glass fiber reinforced nylon 6
 30% long strand glass fiber reinforced nylon 6 Black

Typical mechanical properties

Tensile Modulus	9510 MPa	ISO 527-1/-2
Stress at break, 5mm/min	155 MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.78 %	ISO 527-1/-2
Flexural Modulus	8830 MPa	ISO 178
Flexural Strength	250 MPa	ISO 178
Charpy notched impact strength, 23°C	18 kJ/m ²	ISO 179/1eA

Thermal properties

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

Other properties

Density	1360 kg/m ³	ISO 1183
---------	------------------------	----------

Injection

Drying Temperature	70 - 80 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	0.18 %
Max. mould temperature	80 - 100 °C

Additional information

Injection molding 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 Texts

Pre-drying 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.

Longer pre-drying times/storage Note: Material can be over dried and may discolor.

Injection molding 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.



CELSTRAN® PA6-GF30-01

Melt Temp: 270-280°C.
Mold Temp: 85- 95°C.

Injection molding Preprocessing

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

