CELSTRAN® PA6-GF50-03 AD3019 Black

50% glass reinforced, UV and Heat stabilized Nylon 6
Nylon 6 with 50% long glass reinforcement, heat stabilized

Typical mechanical properties

Tensile Modulus	17000	MPa	ISO 527-1/-2
Stress at break, 5mm/min	225	MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.6	%	ISO 527-1/-2
Flexural Modulus	15200	MPa	ISO 178
Flexural Strength	365	MPa	ISO 178
Charpy notched impact strength, 23°C	32	kJ/m²	ISO 179/1eA

Other properties

Density	1560	kg/m³	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: 285-295°C.
Mold Temp: 85- 95°C.

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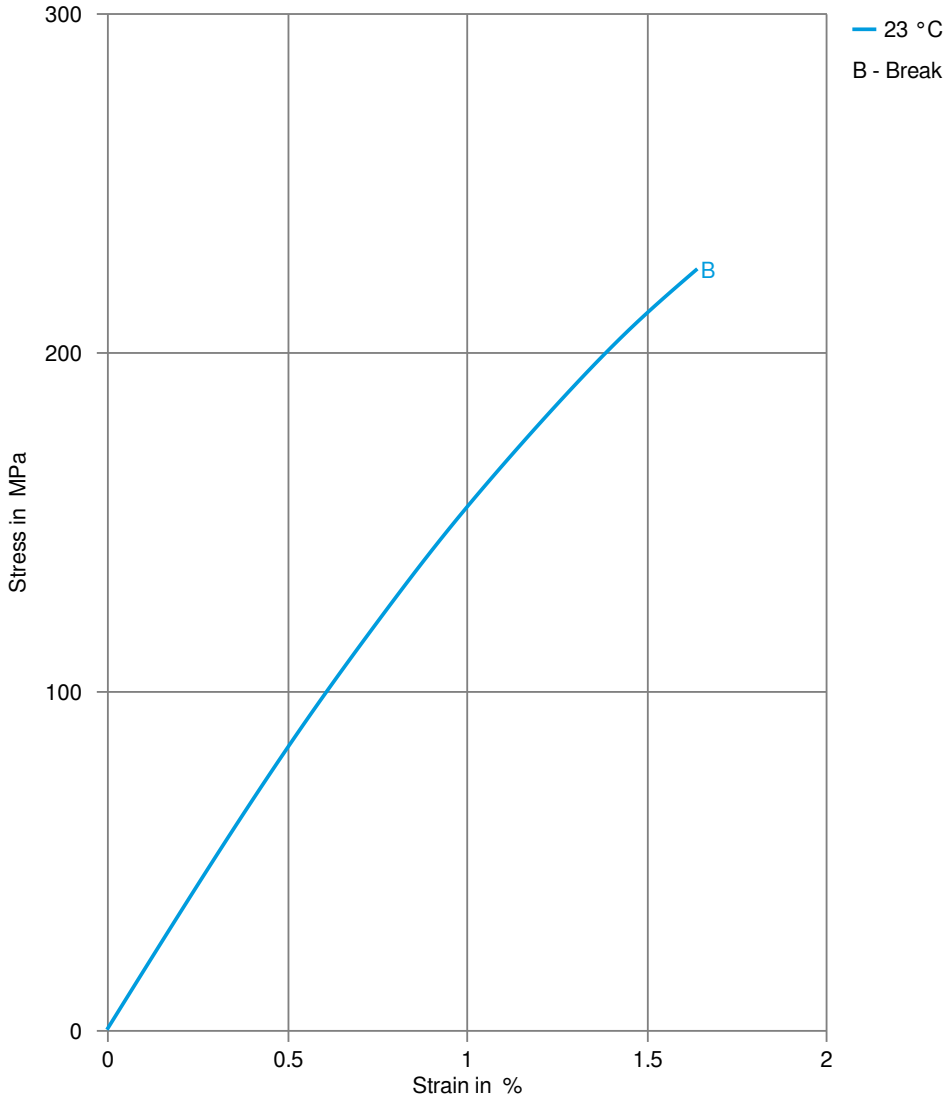
Stress-strain



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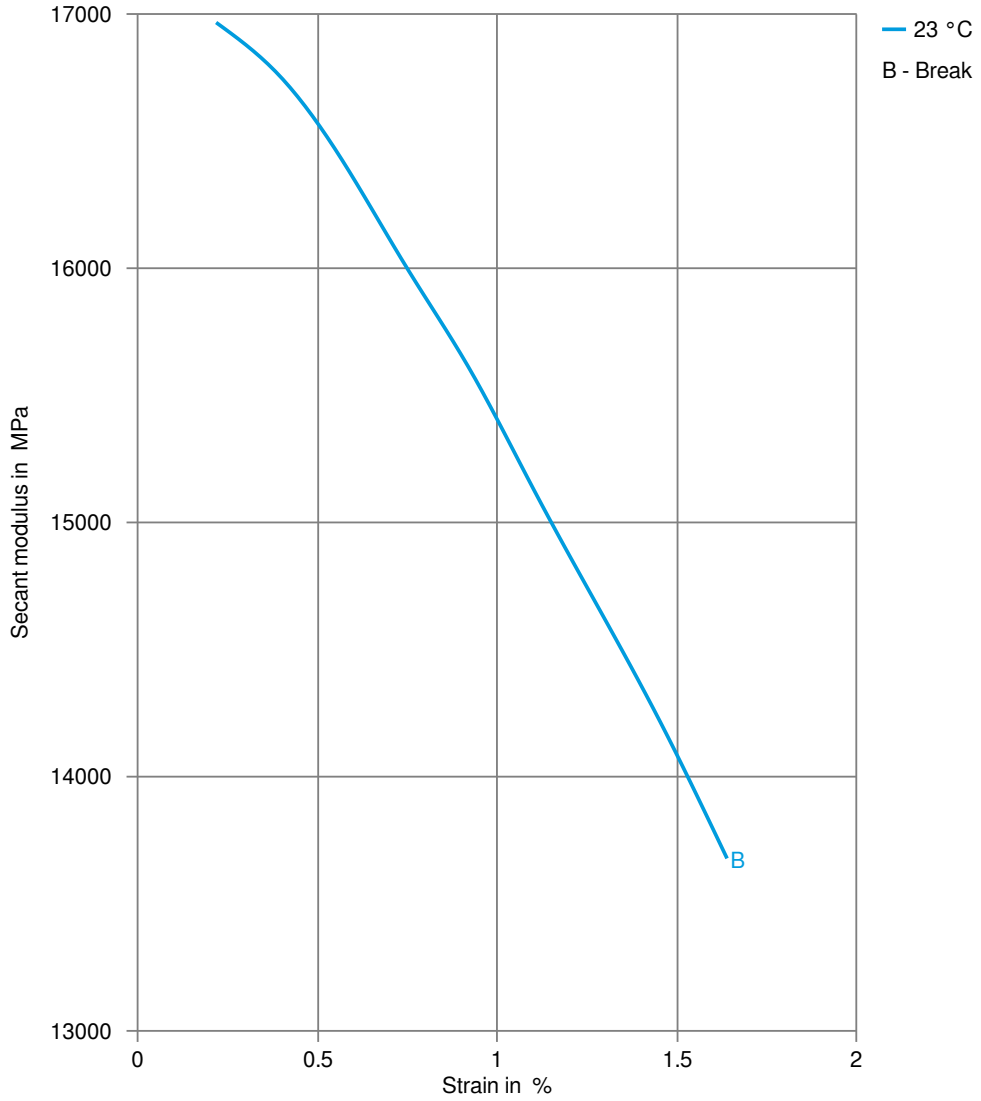
Secant modulus-strain



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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. Melt Temp: 285-295°C. Mold Temp: 85- 95°C.
Injection molding Preprocessing	PA6&PA66 drying requirements: 4 hrs. @80° C. A dehumidifier or desiccant dryer is recommended.