

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	10300	MPa	ISO 527
^[C] Stress at break	130	MPa	ISO 527
^[C] Strain at break	1.8	%	ISO 527
^[C] Charpy notched impact strength, +23°C	15	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	246	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1230	kg/m ³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Melt temperature	305 - 310	°C	-
Mold temperature	85 - 95	°C	-

Characteristics

Processing

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color

Other text information

Injection molding

PA6&PA66 drying requirements: 4 hrs. @80° C.
 A dehumidifier or desiccant dryer is recommended.
 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: 305-310°C.

Mold Temp: 85- 95°C.