CELSTRAN® PA66-GF40-02-Natural

PA66-GLF40 Celanese

Mechanical properties	Value	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**13400**	MPa	ISO 527
[C] Stress at break	**225**	MPa	ISO 527
[C] Strain at break	**2.05**	%	ISO 527
[C] Charpy impact strength, +23°C	**95**	kJ/m²	ISO 179/1eU
[C] Charpy impact strength, -30°C	**46**	kJ/m²	ISO 179/1eU
[C] Charpy notched impact strength, +23°C	**39**	kJ/m²	ISO 179/1eA
[C] Charpy notched impact strength, -30°C	**26**	kJ/m²	ISO 179/1eA
[C] Puncture energy, +23°C	**18.3**	J	ISO 6603-2
[C] Puncture energy, -30°C	**17.8**	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	Value	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**261**	°C	ISO 11357-1/-3
[C] Temp. of deflection under load, 1.80 MPa	**255**	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 8.00 MPa	**240**	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
[C] Density	**1460**	kg/m³	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**4**	h	-
Melt temperature	**295 - 300**	°C	-
Mold temperature	**85 - 95**	°C	-

Characteristics

Processing
Injection Molding

Features
Long fiber reinforced

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific

Special Characteristics
Heat stabilized or stable to heat

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: 295-300°C.
Mold Temp: 85- 95°C.