

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	16500	MPa	ISO 527
^[C] Stress at break	260	MPa	ISO 527
^[C] Strain at break	2	%	ISO 527
^[C] Charpy impact strength, +23°C	95	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	80	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	49	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	34	kJ/m ²	ISO 179/1eA

[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	256	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 8.00 MPa	249	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1560	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	300 - 310	°C	-
Mold temperature	90 - 100	°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: 300-310°C.

Mold Temp: 90-100°C.