

CELSTRAN® PA66-GF60-02-Natural

PA66-GLF60

Celanese

Mechanical properties	Value	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	20500	MPa	ISO 527
^[C] Stress at break	285	MPa	ISO 527
^[C] Strain at break	1.8	%	ISO 527
^[C] Charpy notched impact strength, +23°C	64	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	263	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	Value	Unit	Test Standard
^[C] Density	1690	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	310 - 315	°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: 310-315°C.

Mold Temp: 90-100°C.