



Celstran® PA66-GF30-02

Celanese Corporation - Polyamide 66

Monday, November 4, 2019

General Information

Product Description

30% long glass fiber reinforced, heat stabilized, Nylon 6/6

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • North America
Filler / Reinforcement	• Long Glass Fiber, 30% Filler by Weight
Additive	• Heat Stabilizer
Features	• Heat Stabilized
RoHS Compliance	• Contact Manufacturer

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.48E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	20300	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.6	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.29E+6	psi	ISO 178
Flexural Stress (73°F)	32600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	9.0	ft-lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	486	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	158 to 176	°F
Drying Time	2.0 to 4.0	hr
Suggested Max Moisture	0.18	%
Hopper Temperature	158 to 176	°F
Rear Temperature	545 to 563	°F
Middle Temperature	554 to 572	°F
Front Temperature	572 to 590	°F
Nozzle Temperature	572 to 599	°F
Processing (Melt) Temp	572 to 599	°F
Mold Temperature	176 to 212	°F

Injection Notes

Feeding zone temperature: 20 to 50°C

Zone4 temperature: 300 to 315°C

Notes

¹ Typical properties: these are not to be construed as specifications.