Celstran® PA66-GF40-02-Natural

Celanese Corporation - Polyamide 66

Monday, November 4, 2019

General Information

Product Description			
40% 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, 40% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Heat Stabilized		
RoHS Compliance	• Contact Manufacturer		
Appearance	• Natural Color		

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm³	ISO 1183
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.94E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	32600	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.1	%	ISO 527-2/1A/5
Flexural Modulus			ISO 178
73°F	1.68E+6	psi	
176°F	986000	psi	
Flexural Stress			ISO 178
73°F	52900	psi	
176°F	30500	psi	
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	12	ft·lb/in²	
73°F	19	ft·lb/in²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	22	ft·lb/in²	
73°F	45	ft·lb/in²	
Unnotched Izod Impact Strength			ISO 180/1U
-22°F	20	ft·lb/in²	
73°F	22	ft·lb/in²	
Multi-Axial Instrumented Impact Energy			ISO 6603-2
-22°F	13.1	ft·lb	
73°F	13.5	ft·lb	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature (264 psi, Unannealed)	491	°F	ISO 75-2/A
Heat Deflection Temperature (1160 psi, Unannealed)	464	°F	ISO 75-2/C
Melting Temperature [2]	502	°F	ISO 11357-3

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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.

[2] 10°C/min

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