Celstran® PA66-GF40-10

Celanese Corporation - Polyamide 66

Monday, November 4, 2019

General Information

General			
Material Status	• Experimental: Active		
Availability	• Asia Pacific	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight		

ASTM & ISO Properties [1]

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2.15E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	26100	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.6	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.97E+6	psi	ISO 178
Flexural Stress (73°F)	42100	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (73°F)	9.5	ft·lb/in²	ISO 179/1eA

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.