

Celstran® PA66-GF30-02

Polyamide 66

Celanese Corporation

Message:

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

General Information			
UL YellowCard	E113269-237776		
Filler / Reinforcement	Long glass fiber, 30% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow	0.10 - 0.20	%	ASTM D955
Transverse flow	0.30 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-40°C	9310	MPa	ASTM D638
23°C	10300	MPa	ASTM D638
121°C	5310	MPa	ASTM D638
--	9700	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, -40°C	228	MPa	ASTM D638
Fracture, 23°C	194	MPa	ASTM D638
Fracture, 121°C	110	MPa	ASTM D638
Fracture	170	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, -40°C	2.5	%	ASTM D638
Fracture, 23°C	2.4	%	ASTM D638
Fracture, 121°C	2.7	%	ASTM D638
Fracture	2.1	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	9000	MPa	ISO 178
Flexural Stress (23°C)	280	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	23	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	252	°C	ASTM D648, ISO 75-2/A

Injection	Nominal Value	Unit
Drying Temperature	70.0 - 80.0	°C
Drying Time	2.0 - 4.0	hr
Suggested Max Moisture	0.18	%
Hopper Temperature	70.0 - 80.0	°C
Rear Temperature	285 - 295	°C
Middle Temperature	290 - 300	°C
Front Temperature	300 - 310	°C
Nozzle Temperature	300 - 315	°C
Processing (Melt) Temp	300 - 315	°C
Mold Temperature	80.0 - 100	°C
Injection instructions		

Zone 4 Temperature: 300 to 315°C Feed Temperature: 20 to 50°C

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