

Celstran® PA66-GF50-02-Natural

Polyamide 66

Celanese Corporation

Message:

50 % Long glass fiber reinforced, heat stabilized, Nylon 6/6

General Information			
UL YellowCard	E113269-237779		
Filler / Reinforcement	Long glass fiber, 50% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow	0.10 - 0.15	%	ASTM D955
Transverse flow	0.15 - 0.25	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-40°C	19800	MPa	ASTM D638
23°C	18300	MPa	ASTM D638
149°C	12400	MPa	ASTM D638
--	17000	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, -40°C	343	MPa	ASTM D638
Fracture, 23°C	299	MPa	ASTM D638
Fracture, 149°C	153	MPa	ASTM D638
Fracture	265	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, -40°C	2.1	%	ASTM D638
Fracture, 23°C	2.2	%	ASTM D638
Fracture, 149°C	2.4	%	ASTM D638
Fracture	2.0	%	ISO 527-2/1A/5
Flexural Modulus			
23°C	15000	MPa	ISO 178
80°C	9000	MPa	ISO 178
Flexural Stress (23°C)	415	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	34	kJ/m ²	ISO 179/1eA

23°C	47	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	80	kJ/m ²	ISO 179/1eU
23°C	95	kJ/m ²	ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, not annealed	260	°C	ASTM D648
1.8 MPa, not annealed	256	°C	ISO 75-2/A
8.0 MPa, not annealed	249	°C	ISO 75-2/C
Melting Temperature ¹	261	°C	ISO 11357-3
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			
NOTE			
1.	10°C/min		

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