

Celstran® PA66-GF40-02-Natural

Polyamide 66

Celanese Corporation

Message:

40% Long glass fiber reinforced, heat stabilized, Nylon 6/6

General Information			
UL YellowCard	E113269-237778		
Filler / Reinforcement	Long glass fiber, 40% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow	0.10 - 0.20	%	ASTM D955
Transverse flow	0.20 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-40°C	14500	MPa	ASTM D638
23°C	14200	MPa	ASTM D638
121°C	7310	MPa	ASTM D638
--	13300	MPa	ISO 527-2/1A/1
80°C	7500	MPa	ISO 527-2/1A
Tensile Strength			
Fracture, -40°C	270	MPa	ASTM D638
Fracture, 23°C	253	MPa	ASTM D638
Fracture, 121°C	134	MPa	ASTM D638
Fracture	215	MPa	ISO 527-2/1A/5
80°C	120	MPa	ISO 527-2/1A
Tensile Elongation			
Fracture, -40°C	2.2	%	ASTM D638
Fracture, 23°C	2.3	%	ASTM D638
Fracture, 121°C	2.5	%	ASTM D638
Fracture	2.0	%	ISO 527-2/1A/5
Fracture, 80°C	2.9	%	ISO 527-2/1A
Flexural Modulus			
23°C	13500	MPa	ISO 178
80°C	6800	MPa	ISO 178
Flexural Stress			
			ISO 178

23°C	355	MPa	ISO 178
80°C	210	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	26	kJ/m ²	ISO 179/1eA
23°C	35	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	46	kJ/m ²	ISO 179/1eU
23°C	95	kJ/m ²	ISO 179/1eU
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	43	kJ/m ²	ISO 180/1U
23°C	47	kJ/m ²	ISO 180/1U
Multi-Axial Instrumented Impact Energy (-30°C)	17.8	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, not annealed	254	°C	ASTM D648
1.8 MPa, not annealed	255	°C	ISO 75-2/A
8.0 MPa, not annealed	240	°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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