

Celstran® PA66-GF60-02-Natural

Polyamide 66

Celanese Corporation

Message:

60% long glass fiber reinforced, heat stabilized, Nylon 6/6

General Information			
UL YellowCard	E113269-237780		
Filler / Reinforcement	Long glass fiber, 60% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.69	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow	0.050 - 0.10	%	ASTM D955
Transverse flow	0.10 - 0.20	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-40°C	20800	MPa	ASTM D638
23°C	23200	MPa	ASTM D638
121°C	13300	MPa	ASTM D638
--	21600	MPa	ISO 527-2/1A/1
80°C	11900	MPa	ISO 527-2/1A
Tensile Strength			
Fracture, -40°C	354	MPa	ASTM D638
Fracture, 23°C	318	MPa	ASTM D638
Fracture, 121°C	173	MPa	ASTM D638
Fracture	280	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, -40°C	1.9	%	ASTM D638
Fracture, 23°C	1.8	%	ASTM D638
Fracture, 121°C	2.2	%	ASTM D638
Fracture	1.7	%	ISO 527-2/1A/5
Fracture, 80°C	2.0	%	ISO 527-2/1A
Flexural Modulus (23°C)	19400	MPa	ISO 178
Flexural Stress (23°C)	460	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	54	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method

Deflection Temperature Under Load (1.8 MPa, Unannealed)	263	°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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