

Celstran® PA66-AF35-02-US

Polyamide 66

Celanese Corporation

Message:

PA66 with 35% aramid fiber by weight

General Information			
Filler / Reinforcement	Aramid fiber, 35% filler by weight		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow	0.30	%	ASTM D955
Transverse flow	0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	9030	MPa	ASTM D638
--	9200	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, 23°C	119	MPa	ASTM D638
Fracture	120	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, 23°C	1.6	%	ASTM D638
Fracture	1.9	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	7800	MPa	ISO 178
Flexural Stress (23°C)	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	15	kJ/m ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	246	°C	ASTM D648, ISO 75-2/A
Injection	Nominal Value	Unit	Test Method
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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Recommended distributors for this material

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