

# Celstran® PA66-GF30-07

Polyamide 66  
Celanese Corporation

Message:  
30% Long Glass Reinforced, Flow Enhanced, Nylon 66

| General Information                   |                                        |                   |                     |
|---------------------------------------|----------------------------------------|-------------------|---------------------|
| Filler / Reinforcement                | Long glass fiber, 30% filler by weight |                   |                     |
| Features                              | Good liquidity                         |                   |                     |
| RoHS Compliance                       | Contact manufacturer                   |                   |                     |
| Physical                              | Nominal Value                          | Unit              | Test Method         |
| Specific Gravity                      | 1.36                                   | g/cm <sup>3</sup> | ASTM D792, ISO 1183 |
| Mechanical                            | Nominal Value                          | Unit              | Test Method         |
| Tensile Modulus                       | 9500                                   | MPa               | ISO 527-2/1A/1      |
| Tensile Stress (Break)                | 160                                    | MPa               | ISO 527-2/1A/5      |
| Tensile Strain (Break)                | 1.9                                    | %                 | ISO 527-2/1A/5      |
| Flexural Modulus (23°C)               | 9000                                   | MPa               | ISO 178             |
| Flexural Stress (23°C)                | 242                                    | MPa               | ISO 178             |
| Impact                                | Nominal Value                          | Unit              | Test Method         |
| Charpy Notched Impact Strength (23°C) | 15                                     | kJ/m <sup>2</sup> | ISO 179/1eA         |
| 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°CFeed Temperature: 20 to 50°C

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