

# CELSTRAN® PA66-GF40-02P11/15

## CELSTRAN PA66

Material code according to ISO 1043-1: PA66

Heat stabilized Nylon 66 reinforced by 40 weight percent long glass fibers. The pellets are cylindrical and normally as well as the embedded fibers 10 mm long.

Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection. The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly.

The very isotropic shrinkage in the molded parts minimizes the warpage.

Complex parts can be manufactured with high reproducibility by injection molding.

Can be used for substituting die cast metal with the advantage of Weight reduction, no corrosion problems, no post treatment.

## Rheological properties

Viscosity number	140 cm <sup>3</sup> /g	ISO 307, 1157, 1628
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## Typical mechanical properties

	dry/cond.		
Tensile Modulus	13700 / 10000	MPa	ISO 527-1/-2
Stress at break, 5mm/min	190 / 160	MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.6 / 2	%	ISO 527-1/-2
Flexural Modulus	12600 / 10000	MPa	ISO 178
Flexural Strength	260 / 250	MPa	ISO 178
Charpy impact strength, 23°C	40 / 45	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	41 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, 23°C	23 / 18	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	23 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23°C	24 / 18.5	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength, -30°C	35	kJ/m <sup>2</sup>	ISO 180/1A

## Thermal properties

Melting temperature, 10°C/min	261 °C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	255 °C	ISO 75-1/-2
Temp. of deflection under load, 8 MPa	240 °C	ISO 75-1/-2

## Other properties

Density	1460 kg/m <sup>3</sup>	ISO 1183
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## Injection

Drying Temperature	70 - 80 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	0.15 %
Screw tangential speed	0.1 m/s
Max. mould temperature	90 - 120 °C



# CELSTRAN® PA66-GF40-02P11/15

Back pressure  
Injection speed

3 MPa  
medium

## Additional information

Injection molding

During the processing of CELSTRAN it is important to watch and control melt shear, for excessive shear reduces fiber length and mechanical performance as well.

Processing recommendation:

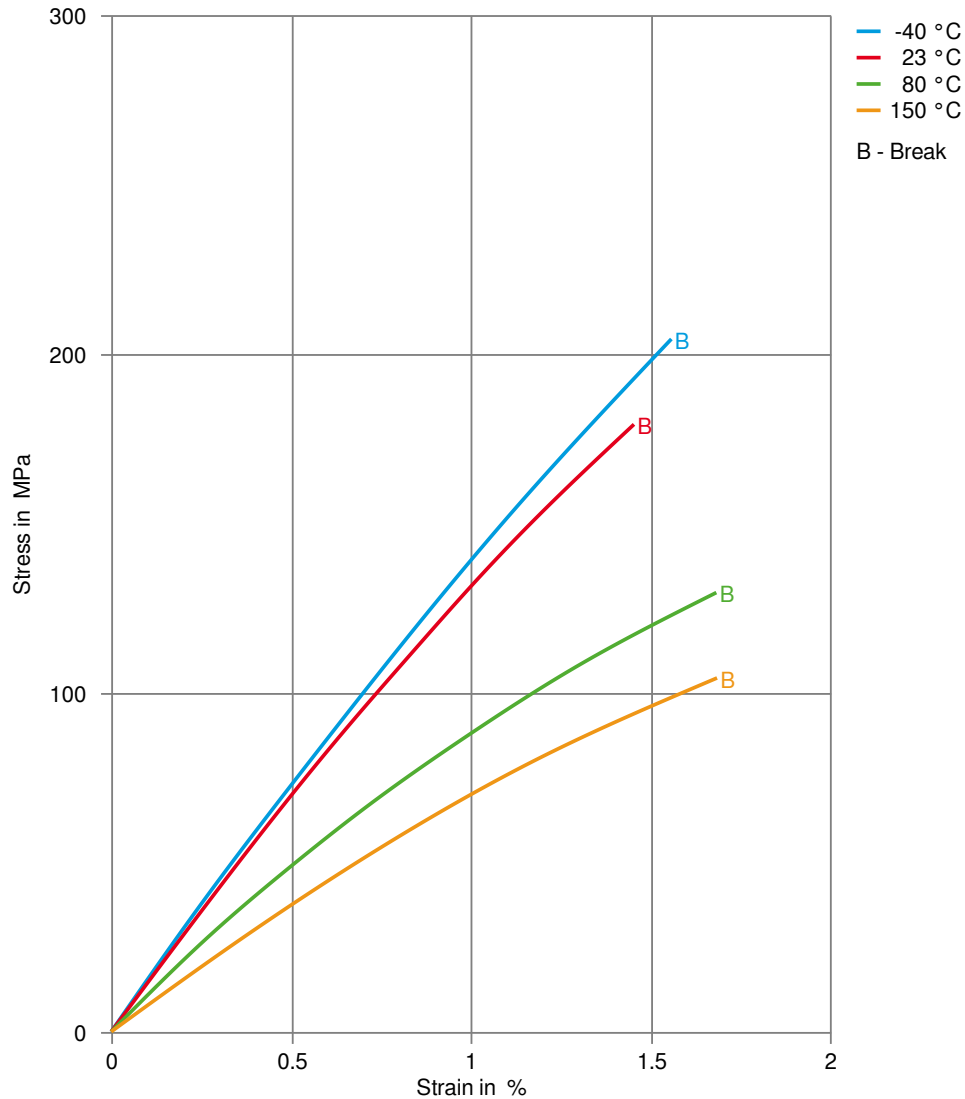
- Conventional 3 zone screw, screw diameter minimum 40 mm
- Design flow channels for low melt shear
- Back pressure and screw rotation to realize a continuous plastification performance and thus a homogeneous melt.
- Apply higher temperature settings than for short fiber compounds

Melt temperature (in the screw anteroom) 300-315 °C  
Mold surface temperature 90-120 °C



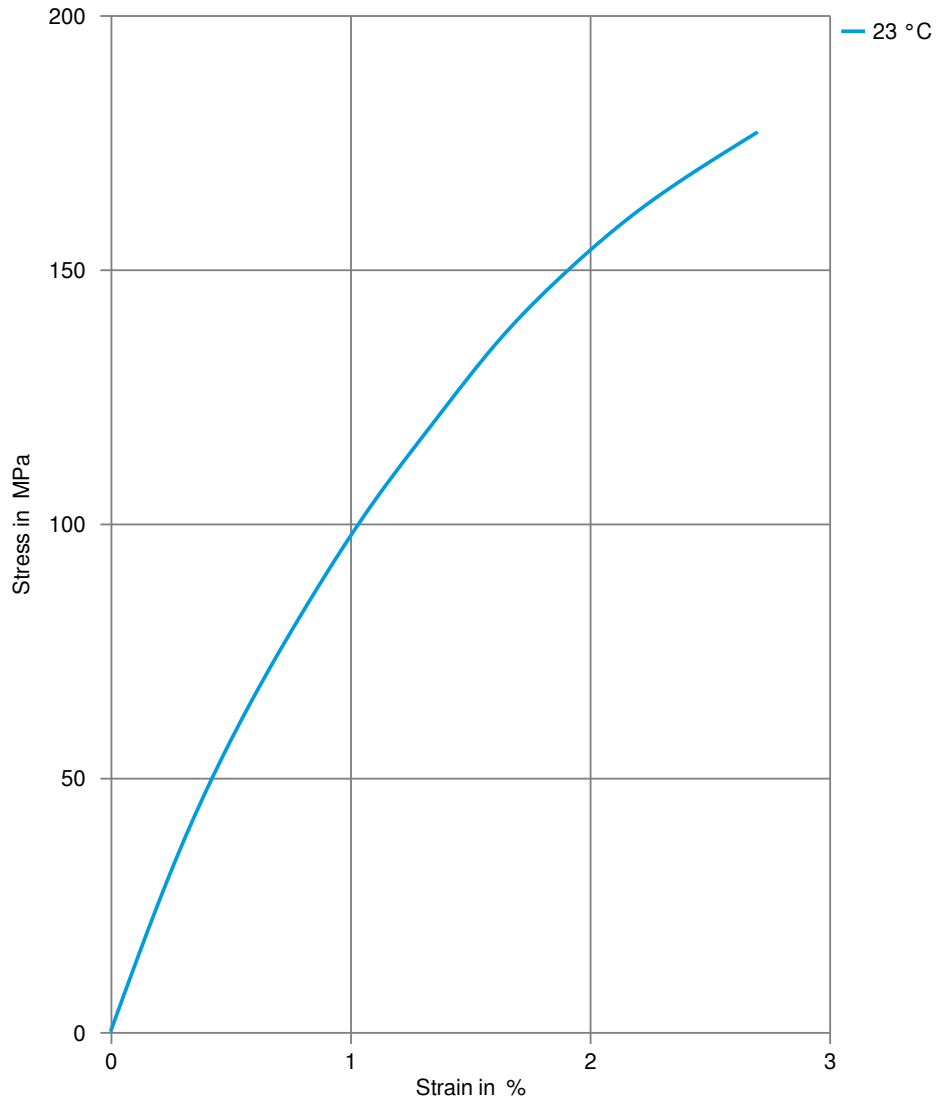
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## Stress-strain (dry)



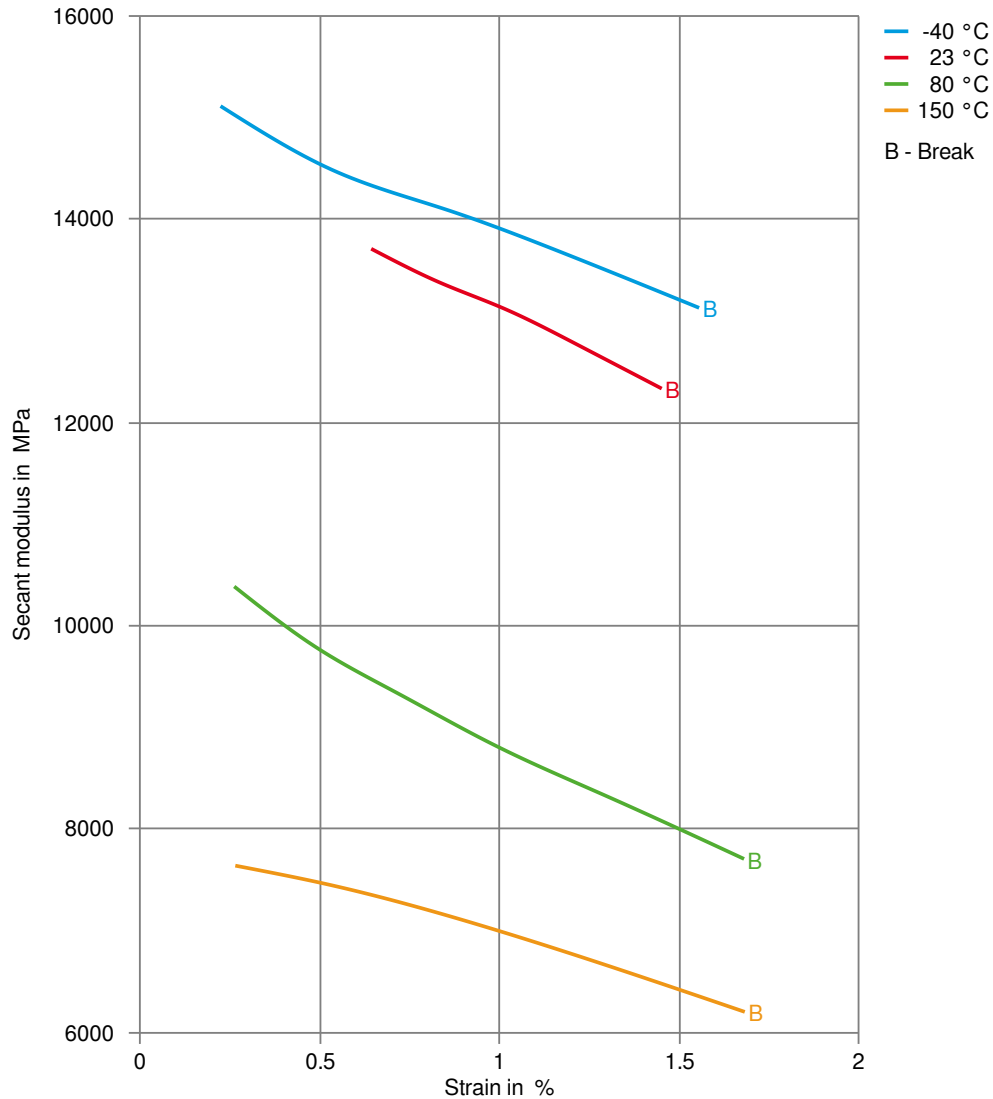
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## Stress-strain (cond.)



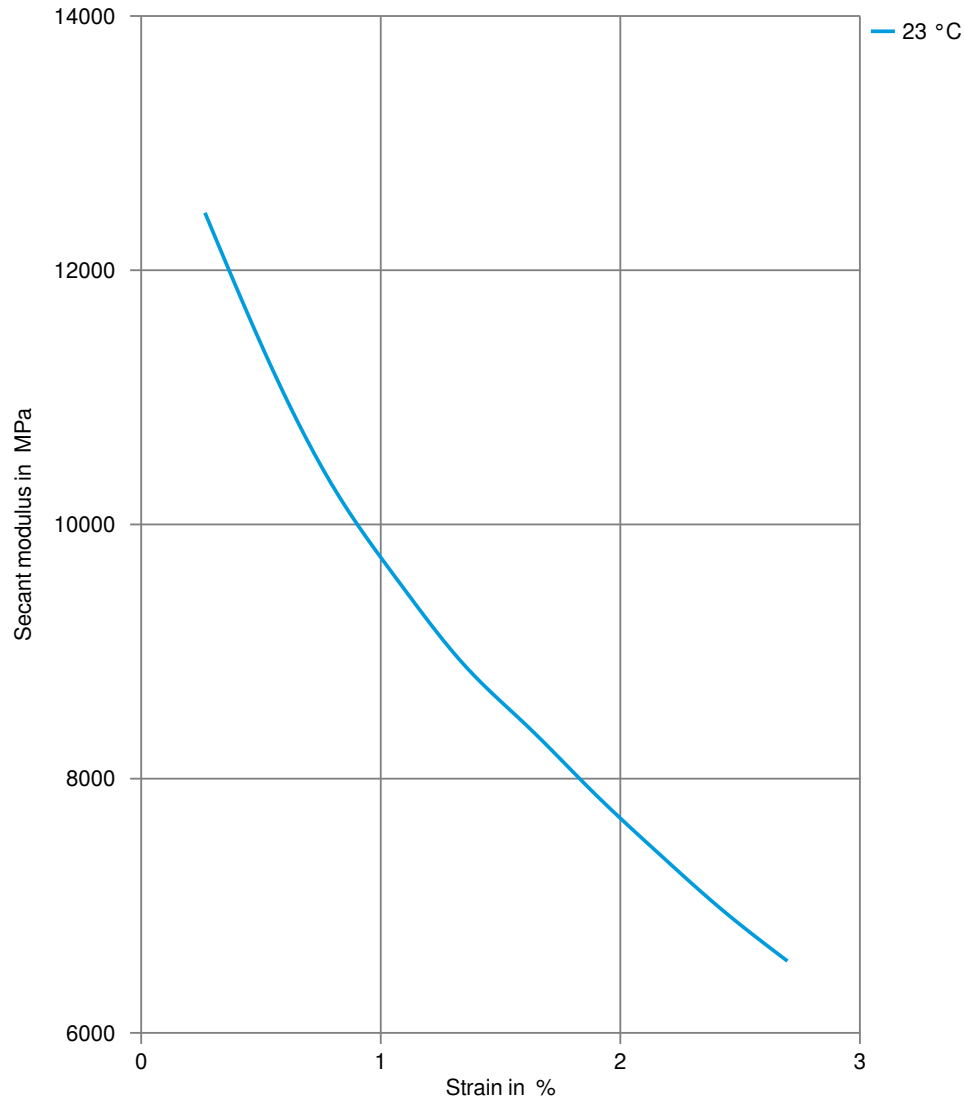
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## Secant modulus-strain (dry)



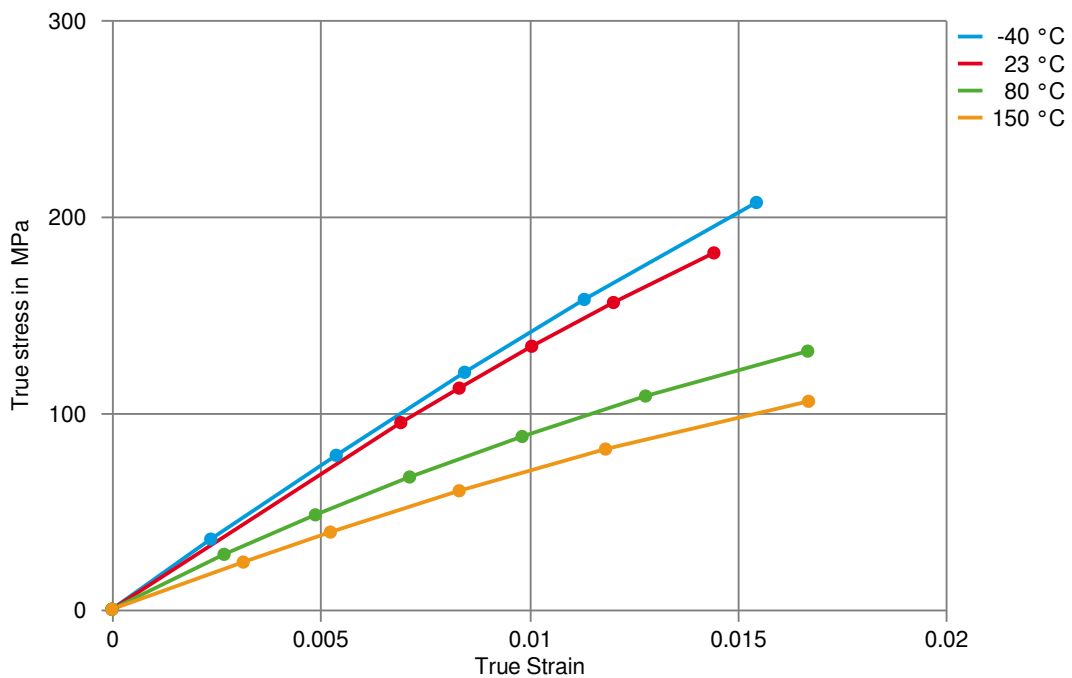
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## Secant modulus-strain (cond.)



# CELSTRAN® PA66-GF40-02P11/15

## True stress-strain



# CELSTRAN® PA66-GF40-02P11/15

## Processing Texts

### Pre-drying

CELSTRAN PA should in principle be predried. Because of the necessary low maximum residual moisture content the use of dry air dryers is recommended. The dew point should be  $\leq -30^{\circ}\text{C}$ . The time between drying and processing should be as short as possible.

### Injection molding

During the processing of CELSTRAN it is important to watch and control melt shear, for excessive shear reduces fiber length and mechanical performance as well.

Processing recommendation:

- Conventional 3 zone screw, screw diameter minimum 40 mm
- Design flow channels for low melt shear
- Back pressure and screw rotation to realize a continuous plastification performance and thus a homogeneous melt.
- Apply higher temperature settings than for short fiber compounds

Melt temperature (in the screw anteroom)  $300-315^{\circ}\text{C}$   
Mold surface temperature  $90-120^{\circ}\text{C}$

### Injection molding Preprocessing

It is recommended to dry in a dehumidifying dryer: 4 hours at  $80^{\circ}\text{C}$ .

