

CELSTRAN® PA66-GF40-10 - PA66

Experimental Grade. Please contact your Celanese representative for further information.

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	14800	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	180	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1.55	%	ISO 527-2/1A
Flexural modulus, 23°C	13600	MPa	ISO 178
Flexural strength, 23°C	290	MPa	ISO 178
Charpy notched impact strength, 23°C	20	kJ/m ²	ISO 179/1eA

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.18	%	-
Drying time	2 - 4	h	-
Drying temperature	70 - 80	°C	-
Temperature	Value	Unit	Test Standard
Hopper temperature	70 - 80	°C	-
Feeding zone temperature	20 - 50	°C	-
Zone1 temperature	285 - 295	°C	-
Zone2 temperature	290 - 300	°C	-
Zone3 temperature	300 - 310	°C	-
Zone4 temperature	300 - 315	°C	-
Nozzle temperature	300 - 315	°C	-
Melt temperature	300 - 315	°C	-
Mold temperature	80 - 100	°C	-

Other text information
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.

Longer pre-drying times/storage

Note: Material can be over dried and may discolor.

Characteristics

Special Characteristics	Delivery Form
Flame retardant	Pellets
Product Categories	Regional Availability
Glass reinforced	North America, Europe, Asia Pacific
Processing	
Injection molding	

