

CELSTRAN® PA66-GF30-07

Nylon 66 with 30% long glass fiber reinforcement
 30% Long Glass Reinforced, High Gloss, Nylon 66

Typical mechanical properties

Tensile Modulus	9500 MPa	ISO 527-1/-2
Stress at break, 5mm/min	160 MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.91 %	ISO 527-1/-2
Flexural Modulus	9000 MPa	ISO 178
Flexural Strength	242 MPa	ISO 178
Charpy notched impact strength, 23°C	15 kJ/m ²	ISO 179/1eA

Other properties

Density	1360 kg/m ³	ISO 1183
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Injection

Drying Temperature	70 - 80 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	0.18 %
Max. mould temperature	80 - 100 °C

Characteristics

Additives	Nucleated
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Additional information

Injection molding	Celstran can be processed on a standard injection molding unit. A general purpose metering screw is recommended with a zone distribution of 40% feed, 40% transition, and 20% metering. A free flowing check ring assembly is recommended.
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Melt Temp: 275-285 °C.
 Mold Temp: 85- 95 °C.

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 =< -30 °C. The time between drying and processing should be as short as possible.
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Longer pre-drying times/storage	Note: Material can be over dried and may discolor.
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A free flowing check ring assembly is recommended.

Melt Temp: 275-285°C.

Mold Temp: 85- 95°C.

Injection molding Preprocessing

PA6&PA66 drying requirements: 4 hrs. @80° C.
A dehumidifier or desiccant dryer is recommended.

