

CELSTRAN® PA66-AF35-02 AF3003 Natural

35% aramid fiber reinforced nylon 6/6

Celstran® PA66-AF35-02 is a 35% long aramid fiber Polyamide. This material imparts excellent wear resistance along with impact and modulus properties that can only be achieved through the use of long fiber technology.

Typical mechanical properties

Tensile Modulus		10300	MPa	ISO 527-1/-2
Stress at break, 5mm/min		130	MPa	ISO 527-1/-2
Strain at break, 5mm/min		1.8	%	ISO 527-1/-2
Flexural Modulus		8700	MPa	ISO 178
Flexural Strength		195	MPa	ISO 178
Charpy notched impact strength, 23	3°C	15	kJ/m²	ISO 179/1eA
Thermal properties				
Temp. of deflection under load, 1.8 MPa		246	°C	ISO 75-1/-2
Other properties				
Density		1230	ka/m ³	ISO 1183
Density		1230	Kg/III	130 1163
Injection				
Drying Temperature		70 - 80	°C	
Drying Time, Dehumidified Dryer		2 - 4	h	
Processing Moisture Content		0.18	%	
Max. mould temperature		80 - 100	°C	
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.			
	Melt Temp: 305-310	°C.		
	Mold Temp: 85- 95°	C.		
Processing Texts				
Pre-drving	CELSTRAN PA shou	Ild in principle	he predried Recaus	e 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.			
Longer pre-drying times/storage	Note: Material can be over dried and may discolor.			
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Injection molding Preprocessing PA6&PA66 dr

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

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