CELSTRAN® PA66-GF60-02-Natural

60% long strand glass fiber reinforced heat stabilized Nylon 6/6
60% long glass fiber reinforced, heat stabilized, Nylon 6/6

Typical mechanical properties

Tensile Modulus	20500	MPa	ISO 527-1/-2
Stress at break, 5mm/min	285	MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.8	%	ISO 527-1/-2
Flexural Modulus	18700	MPa	ISO 178
Flexural Strength	470	MPa	ISO 178
Charpy notched impact strength, 23°C	64	kJ/m²	ISO 179/1eA

Thermal properties

Temp. of deflection under load, 1.8 MPa	263	°C	ISO 75-1/-2

Other properties

Density	1690	kg/m³	ISO 1183

Injection

Drying Temperature	70 - 80	°C
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	0.15	%
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: 310-315°C. Mold Temp: 90-100°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.
Longer pre-drying times/storage	Note: Material can be over dried and may discolor.
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	Melt Temp: 310-315°C. Mold Temp: 90-100°C.
Injection molding Preprocessing	PA6&PA66 drying requirements: 4 hrs. @80° C. A dehumidifier or desiccant dryer is recommended.