

Celstran® PA66-CF40-02 AF3004 Natural

Polyamide 66
Celanese Corporation

Message:
40% long carbon fiber reinforced Nylon 6/6

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Vertical flow direction	3.0E-3	%	ISO 294-4
Flow direction	5.0E-4	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	30900	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	294	MPa	ISO 527-2/1A/50
Tensile Strain (Break)	1.0	%	ISO 527-2/1A/50
Flexural Modulus (23°C)	26000	MPa	ISO 178
Flexural Stress (23°C)	455	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	23	kJ/m ²	ISO 179/1eA
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.18	%	
Rear Temperature	285 - 295	°C	
Middle Temperature	290 - 300	°C	
Front Temperature	300 - 310	°C	
Nozzle Temperature	300 - 315	°C	
Processing (Melt) Temp	300 - 315	°C	
Mold Temperature	80.0 - 100	°C	
Injection instructions			
Feed Temperature: 20 to 50°CZone 4 Temperature: 300 to 315°C			

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Recommended distributors for this material

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