

Celstran® PA66-GF40-02P11

Polyamide 66
Celanese Corporation

Message:

Material code according to ISO 1043-1: PA66
Nylon 66 reinforced by 40 weight percent long glass fibers. The pellets are cylindrical and normally as well as the embedded fibers 10 mm long.
Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection. The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly.
The very isotropic shrinkage in the molded parts minimizes the warpage.
Complex parts can be manufactured with high reproducibility by injection molding.
Can be used for substituting die cast metal with the advantage of Weight reduction, no corrosion problems, no post treatment.

General Information			
Filler / Reinforcement	Long glass fiber, 40% filler by weight		
Features	Low warpage		
	Rigidity, high		
	High strength		
	Impact resistance, good		
	Good creep resistance		
	Low temperature impact resistance		
Uses	Metal substitution		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PA66		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	215	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	8100	MPa	ISO 178
Flexural Stress (23°C)	200	MPa	ISO 178
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 80.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.15	%	
Hopper Temperature	70.0 - 80.0	°C	

Rear Temperature	280 - 285	°C
Middle Temperature	280 - 290	°C
Front Temperature	290 - 300	°C
Nozzle Temperature	310 - 320	°C
Processing (Melt) Temp	310 - 320	°C
Mold Temperature	90.0 - 120	°C
Injection Pressure	120 - 150	MPa
Injection Rate	Moderate	
Holding Pressure	50.0 - 80.0	MPa
Back Pressure	0.00 - 3.00	MPa

Injection instructions

Manifold Temperature: 300 to 315°CZone 4 Temperature: 300 to 310°CFeed Temperature: 20 to 50°C

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