Celstran® PA66-GF60-02 P11/14

Polyamide 66

Celanese Corporation

Message:

Material code according to ISO 1043-1: PA66
Heat stabilized Nylon 66 reinforced by 60 weight percent long glass fibers. The pellets are cylindrical and normally as well as the embedded fibers 11 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, 60% filler by weight		
Additive	heat stabilizer		
Features	Low warpage Rigidity, high High strength Impact resistance, good Good creep resistance Low temperature impact resistance Thermal Stability		
Uses	Metal substitution		
RoHS Compliance	Contact manufacturer		
Forms	Particle		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PA66		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.67	g/cm³	ISO 1183
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	20000	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	234	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	1.5	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	19000	MPa	ISO 178
Flexural Stress (23°C)	380	MPa	ISO 178
Thermal	**Nominal Value**	**Unit**	**Test Method**

Melting Temperature [1]	260	°C	ISO 11357-3

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

NOTE	
1.	10°C/min

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

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