

CELSTRAN® PA66-GF40-07

CELSTRAN® Long Fibre

40% long fiber glass reinforced, enhanced flow, Nylon 6/6

Product information

Resin Identification	PA66-LGF40	ISO 1043
Part Marking Code	>PA66-LGF40<	ISO 11469

Typical mechanical properties

Tensile modulus	13000 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	205 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	2 %	ISO 527-1/-2
Flexural modulus	12100 MPa	ISO 178
Flexural strength	320 MPa	ISO 178
Charpy notched impact strength, 23 °C	23 kJ/m ²	ISO 179/1eA
Poisson's ratio	0.33 ^[C]	

[C]: Calculated

Physical/Other properties

Density	1460 kg/m ³	ISO 1183
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Injection

Drying Recommended	yes
Drying Temperature	80 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	≤0.2 %
Melt Temperature Optimum	295 °C
Min. melt temperature	285 °C
Max. melt temperature	305 °C
Screw tangential speed	≤0.2 m/s
Mold Temperature Optimum	100 °C
Min. mould temperature	70 °C
Max. mould temperature	120 °C
Hold pressure range	50 - 100 MPa

Characteristics

Processing	Injection Moulding
Delivery form	Pellets
Special characteristics	Heat stabilised or stable to heat, High Flow

Additional information

Processing Notes

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.

Storage

Note: Material can be over dried and may discolor.