Celanese
The chemistry inside innovation™

CELSTRAN® PA66-GF40-10 - PA66

Experimental Grade. Please contact your Celanese representative for further information.

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	**14800**	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	**180**	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	**1.55**	%	ISO 527-2/1A
Flexural modulus, 23°C	**13600**	MPa	ISO 178
Flexural strength, 23°C	**290**	MPa	ISO 178
Charpy notched impact strength, 23°C	**20**	kJ/m²	ISO 179/1eA

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	**0.18**	%	-
Drying time	**2 - 4**	h	-
Drying temperature	**70 - 80**	°C	-
Temperature	**Value**	**Unit**	**Test Standard**
Hopper temperature	**70 - 80**	°C	-
Feeding zone temperature	**20 - 50**	°C	-
Zone1 temperature	**285 - 295**	°C	-
Zone2 temperature	**290 - 300**	°C	-
Zone3 temperature	**300 - 310**	°C	-
Zone4 temperature	**300 - 315**	°C	-
Nozzle temperature	**300 - 315**	°C	-
Melt temperature	**300 - 315**	°C	-
Mold temperature	**80 - 100**	°C	-

Other text information

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.

Characteristics

Special Characteristics	Delivery Form
Flame retardant	Pellets
Product Categories	**Regional Availability**
Glass reinforced	North America, Europe, Asia Pacific

Processing

Injection molding