

CELSTRAN® PA66-GF50-02 AD3002 BLACK

CELSTRAN® Long Fibre

Product information

Resin Identification	PA66-LGF50	ISO 1043
Part Marking Code	>PA66-LGF50<	ISO 11469

Typical mechanical properties

	dry/cond.		
Tensile modulus	16800 / 14000	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	240 / 183	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.6 / 1.8	%	ISO 527-1/-2
Flexural modulus	14800 / 12200	MPa	ISO 178
Flexural strength	380 / 290	MPa	ISO 178
Charpy impact strength, 23°C	74 / 81	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	76 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	40 / 32	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	47 / -	kJ/m ²	ISO 179/1eA
Poisson's ratio	0.33 / - ^[C]		

[C]: Calculated

Thermal properties

	dry/cond.		
Temperature of deflection under load, 1.8 MPa	261 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	245 / *	°C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	18 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	71 / *	E-6/K	ISO 11359-1/-2

Physical/Other properties

	dry/cond.		
Density	1570 / -	kg/m ³	ISO 1183

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
Back pressure	3 MPa
Ejection temperature	225 °C

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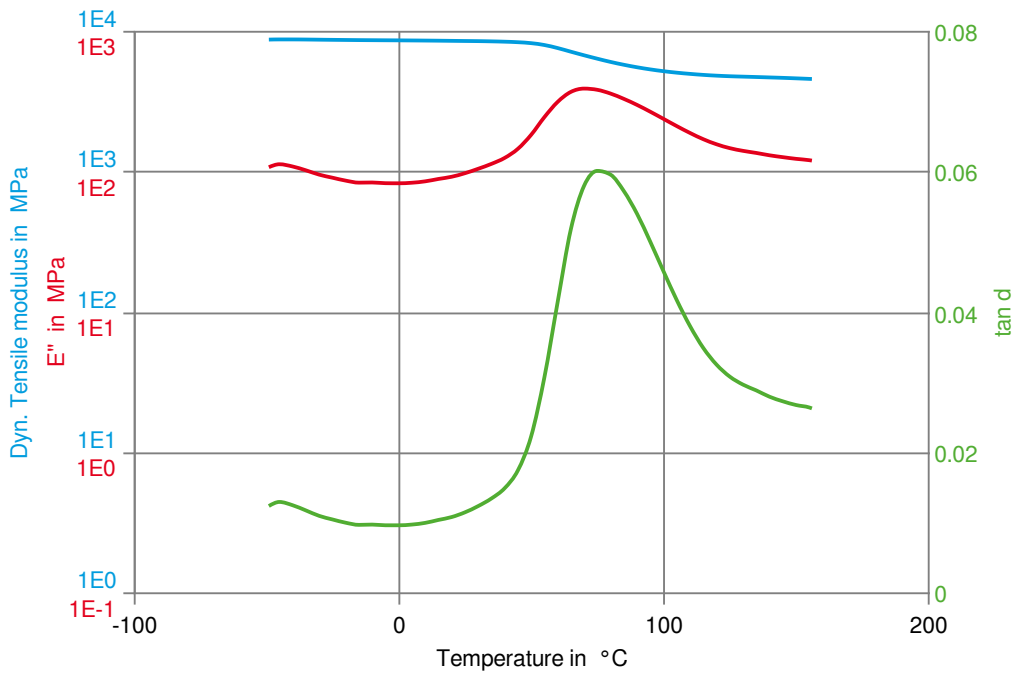
Characteristics

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

Automotive

OEM	STANDARD
Ford	WSB-M4D679-A

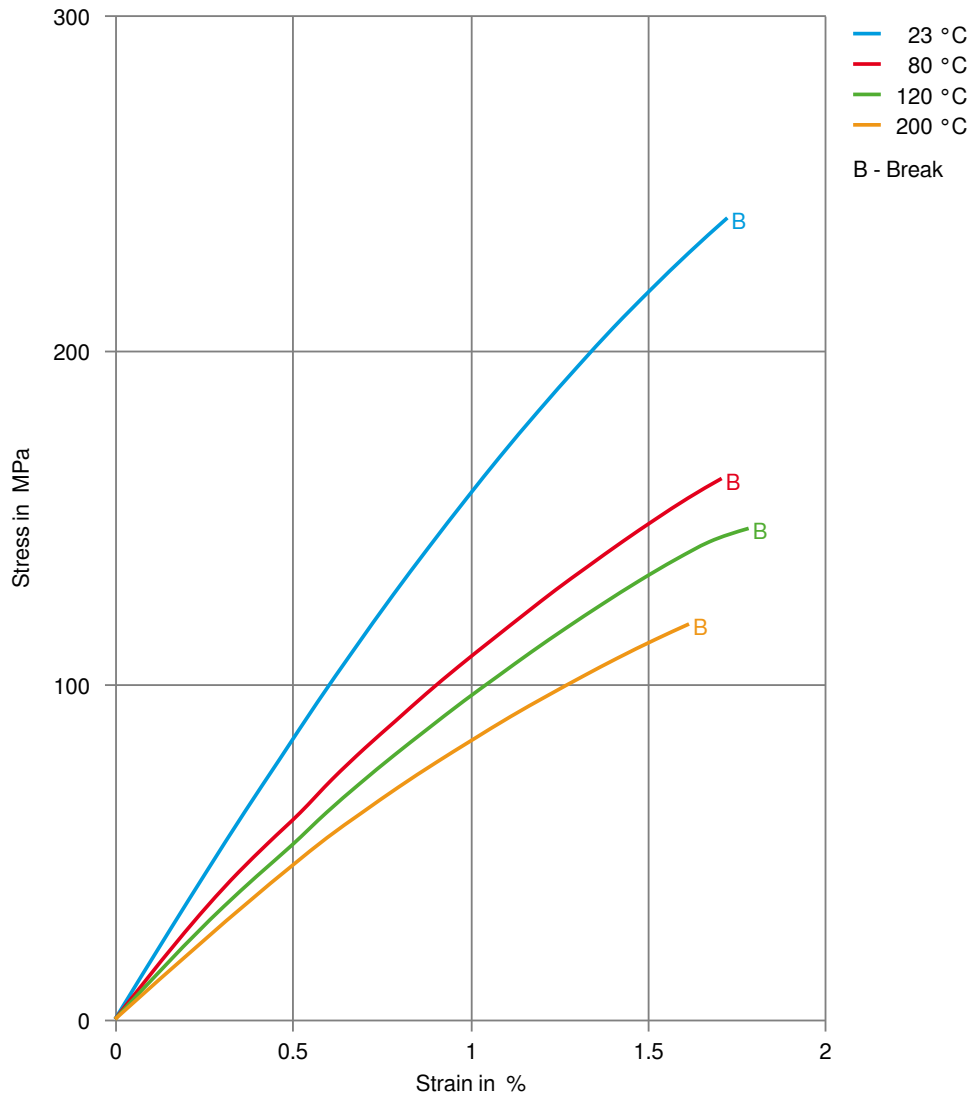
Dynamic Tensile modulus-temperature (dry)



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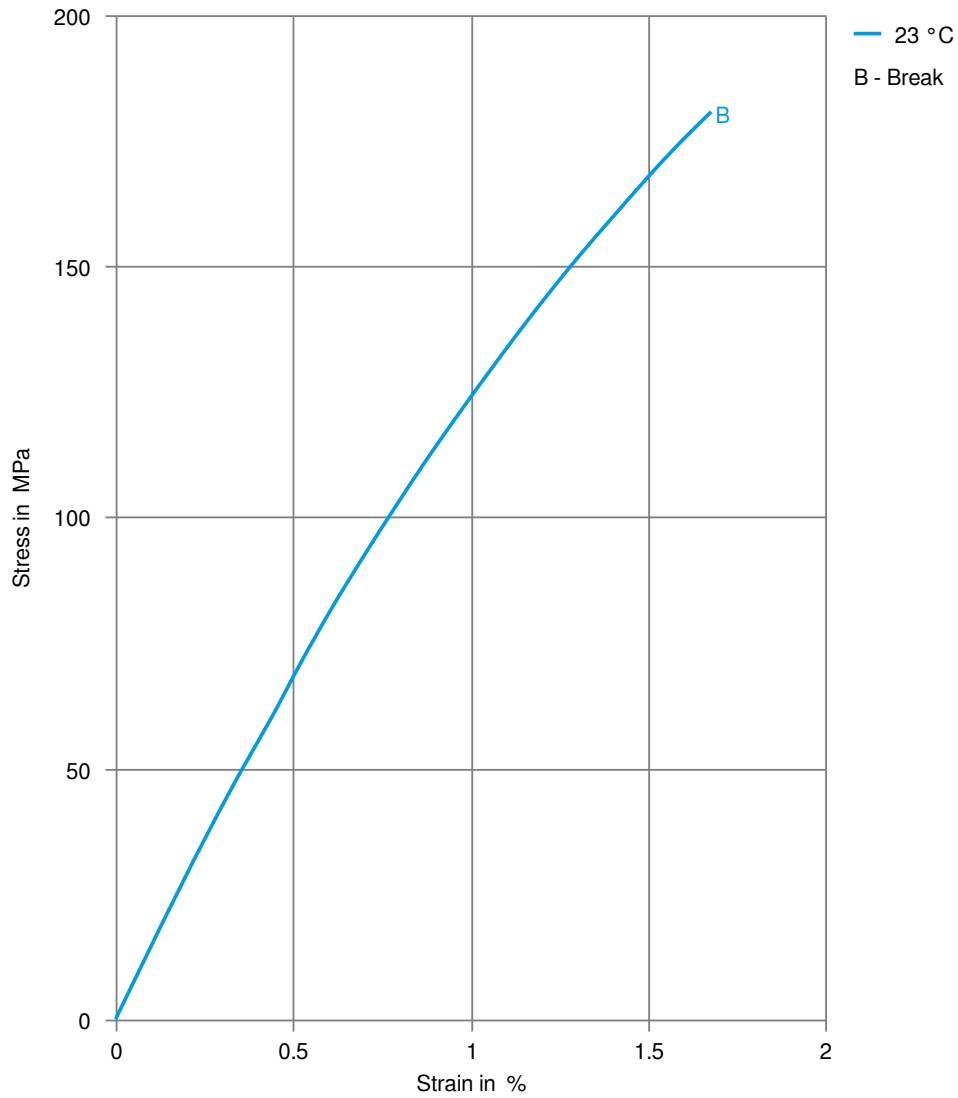
Stress-strain (dry)



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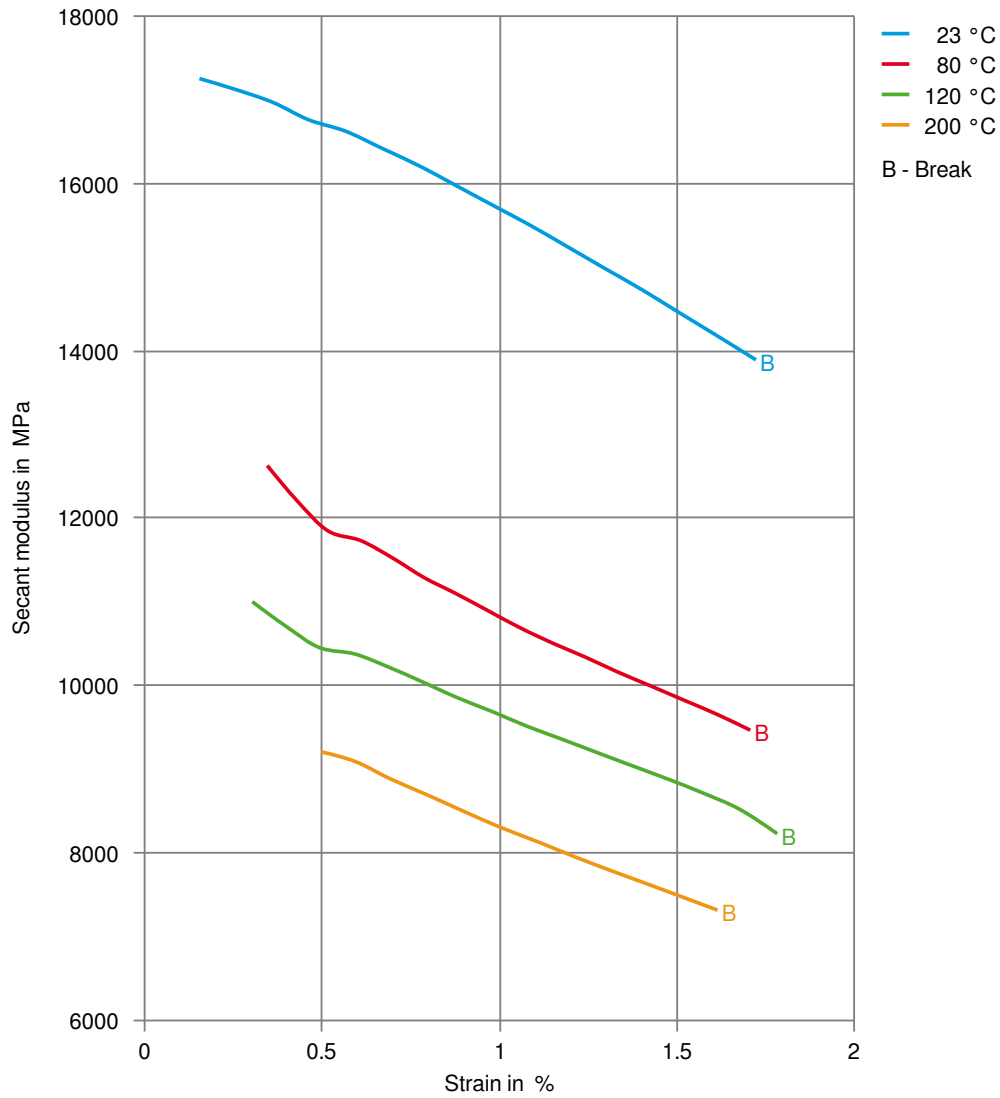
Stress-strain (cond.)



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Secant modulus-strain (dry)



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Secant modulus-strain (cond.)

