

CELSTRAN® PA66-GF60-02 AD3004 BLACK

CELSTRAN® Long Fibre

Celstran PA66-GF60-02 AD3004 is a 60% long glass fiber, heat stabilized Polyamide. This material imparts excellent impact and modulus properties that exceed those of short fiber nylon. Celstran PA66 works extremely well in high temperature, thermally demanding applications.

Product information

Resin Identification	PA66-LGF60	ISO 1043
Part Marking Code	>PA66-LGF60<	ISO 11469

Typical mechanical properties

	dry/cond.		
Tensile modulus	20500 / 17200	MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	283 / 232	MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.8 / 2	%	ISO 527-1/-2
Flexural modulus	18500 / 15300	MPa	ISO 178
Flexural strength	480 / 350	MPa	ISO 178
Charpy impact strength, 23°C	106 / 117	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	98 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	72 / -	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	>60 / -	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	260 / *	°C	ISO 75-1/-2
Temperature of deflection under load, 0.45 MPa	250 / *	°C	ISO 75-1/-2
Coefficient of linear thermal expansion (CLTE), parallel	25 / *	E-6/K	ISO 11359-1/-2
Coefficient of linear thermal expansion (CLTE), normal	60 / *	E-6/K	ISO 11359-1/-2

Physical/Other properties

	dry/cond.		
Density	1700 / -	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

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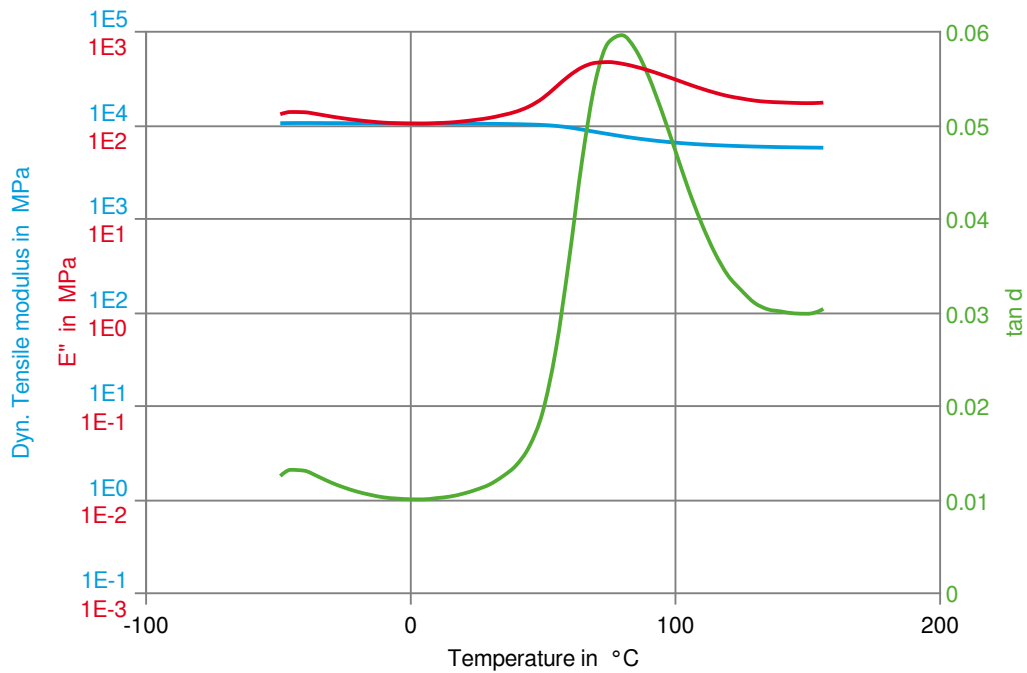
Characteristics

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

Automotive

OEM	STANDARD	ADDITIONAL INFORMATION
Stellantis - Chrysler	MS.50017 / CPN-4329	Technical Black

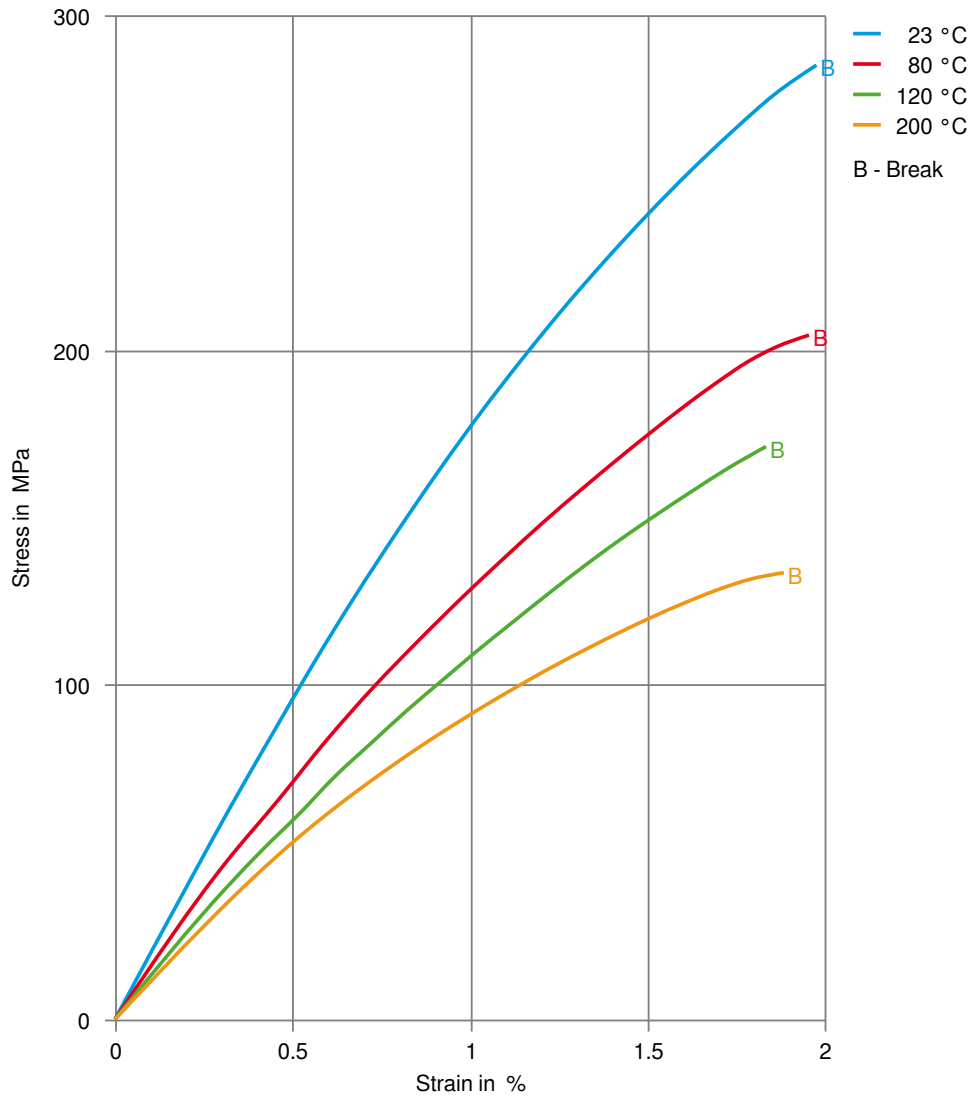
Dynamic Tensile modulus-temperature (dry)



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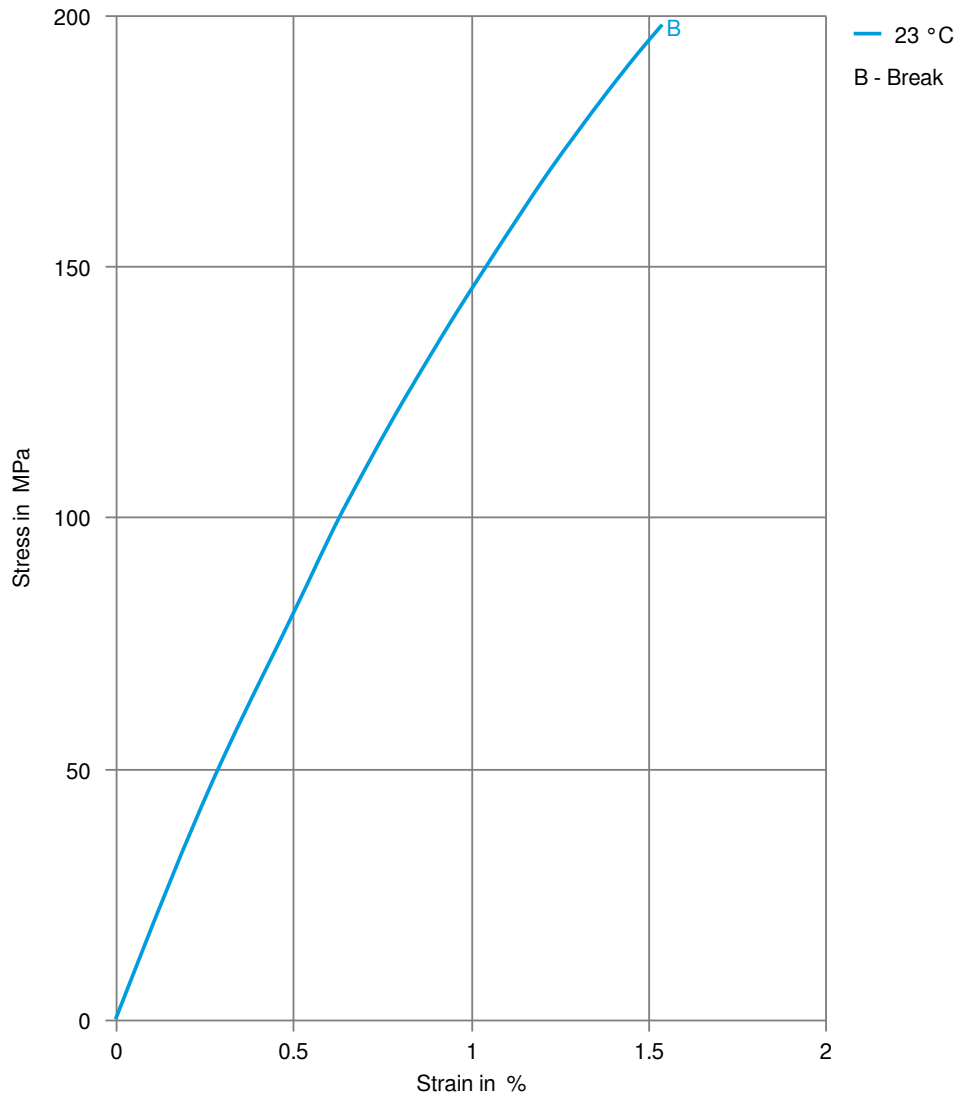
Stress-strain (dry)



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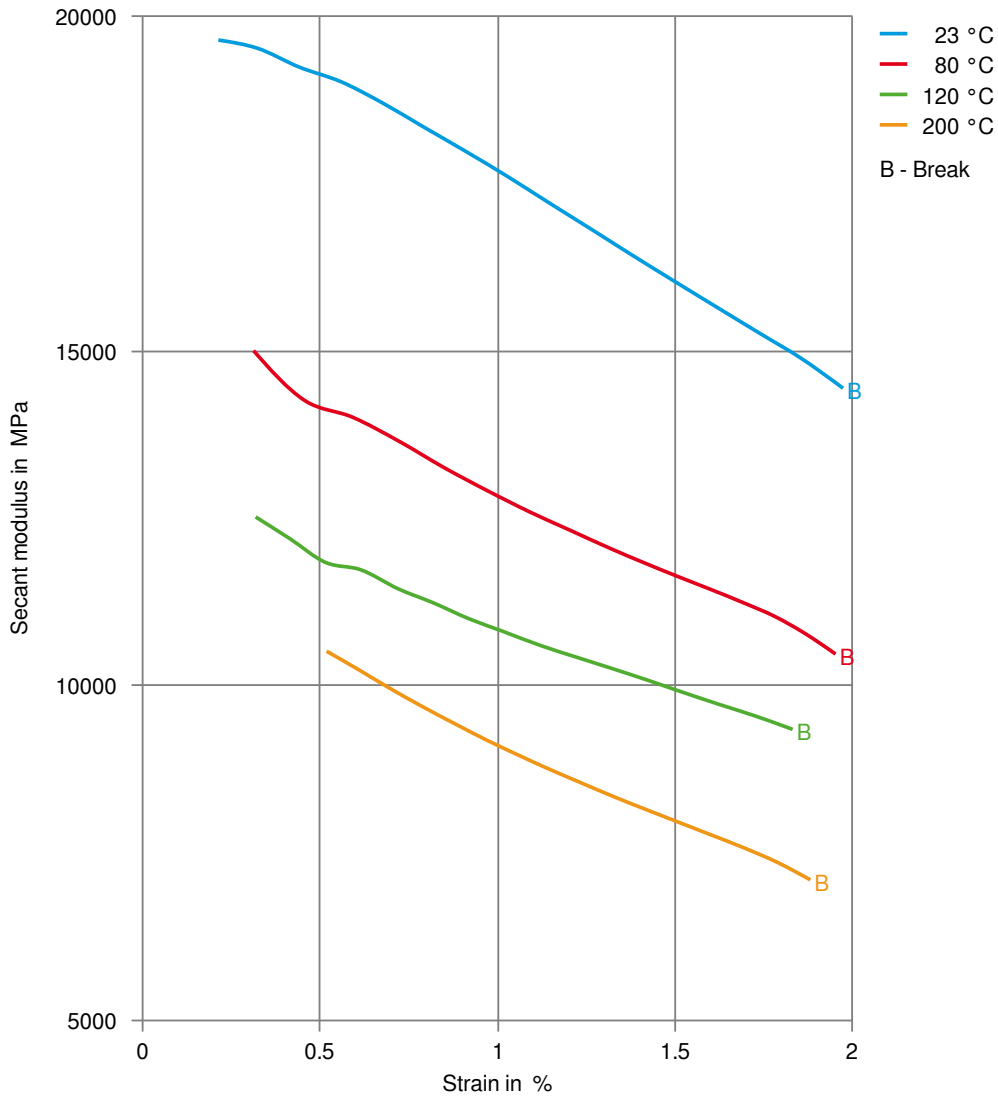
Stress-strain (cond.)



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Secant modulus-strain (dry)



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Secant modulus-strain (cond.)

