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	1.89E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	29700	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	2	%	ISO 527-1/-2
Flexural modulus	1.75E6	psi	ISO 178
Flexural strength	46400	psi	ISO 178
Charpy notched impact strength, 23 °C	10.9	ftlb/in²	ISO 179/1eA

Physical/Other properties

Density	0.0527	lb/in³	ISO 1183

Injection

Drying Recommended	yes	
Drying Temperature	176	°F
Drying Time, Dehumidified Dryer	2 - 4	h
Processing Moisture Content	≤0.2	%
Melt Temperature Optimum	563	°F
Min. melt temperature	545	°F
Max. melt temperature	581	°F
Max. screw tangential speed	≤0.2	m/s
Mold Temperature Optimum	212	°F
Min. mold temperature	158	°F
Max. mold temperature	248	°F
Hold pressure range	7250 - 14500	psi
Hold Pressure Time (h is the max. wall thickness of the part in mm)	h²+2	s

Characteristics

Processing	Injection Molding
Special characteristics	Heat stabilized 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

Revised: 2024-01-23 Source: Celanese Materials Database

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Note: Material can be over dried and may discolor.

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