CELSTRAN® PA66-GF50-28 AD3020

CELSTRAN® Long Fibre

Product information

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

Typical mechanical properties

Tensile modulus	2.34E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	34100	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.8	%	ISO 527-1/-2
Flexural modulus	2.07E6	psi	ISO 178
Flexural strength	54400	psi	ISO 178
Charpy notched impact strength, 23 °C	17.6	ftlb/in^2	ISO 179/1eA

Physical/Other properties

Density	0.0563	lb/in^3	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)	h^2+2	s
Back pressure	435	psi

Characteristics

Processing	Injection Molding
Special characteristics	Heat stabilized or stable to heat

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