CELSTRAN® PA66-GF60-0101P10

CELSTRAN® Long Fibre

Material code according to ISO 1043-1: PA66 Nylon 66/6 copolymer reinforced by 60 weight percent long glass fibers. The pellets are cylindrical and normally as well as the embedded fibers 10 mm long. Parts molded of CELSTRAN have outstanding mechanical properties such as high strength and stiffness combined with high heat deflection. The notched impact strength is increased at elevated and low temperatures due to the fiber skeleton built in the parts. The long fiber reinforcement reduces creep significantly. The very isotropic shrinkage in the molded parts minimizes the warpage. Complex parts can be manufactured with high reproducibility by injection molding. Can be used for substituting die cast metal with the advantage of Weight reduction, no corrosion problems, no post treatment.

Product information

Resin Identification	PA666-LGF60		ISO 1043
Part Marking Code	>PA666-LGF60<		ISO 11469

Rheological properties

	dry/cond.		
Viscosity number	3320 / *	in³/lb	ISO 307, 1628

Typical mechanical properties

	dry/cond.		
Tensile modulus	3.02E6 / 1.93E6	psi	ISO 527-1/-2
Tensile stress at break, 5mm/min	43500 / 26800	psi	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.9 / 2.2	%	ISO 527-1/-2
Flexural modulus	2.61E6 / 1.89E6	psi	ISO 178
Flexural strength	65300 / 46400	psi	ISO 178
Flexural strain at failure	2.8 / 3.8	%	ISO 178
Charpy impact strength, 23°C	47.6 / 57.1	ftlb/in²	ISO 179/1eU
Charpy impact strength, -30°C	40 / 41.4	ftlb/in²	ISO 179/1eU
Charpy notched impact strength, 23°C	20.9 / 18.1	ftlb/in²	ISO 179/1eA
Charpy notched impact strength, -30°C	19 / 20.9	ftlb/in²	ISO 179/1eA
Izod impact strength, 23°C	45.2 / 47.6	ftlb/in²	ISO 180/1U
Izod impact strength, -30°C	36.2 / -	ftlb/in²	ISO 180/1U

Thermal properties

	dry/cond.		
Melting temperature, 10°C/min	464 / *	°F	ISO 11357-1/-3
Temperature of deflection under load, 1.8 MPa	455 / *	°F	ISO 75-1/-2
Temperature of deflection under load, 8 MPa	428 / *	°F	ISO 75-1/-2

Physical/Other properties

	dry/cond.		
Density	0.061 / -	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

Revised: 2025-07-10 Source: Celanese Materials Database

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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

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