



## CELSTRAN<sup>®</sup> PA66-AF35-02 AF3003 NATURAL CELSTRAN® Long Fibre

Celstran® PA66-AF35-02 is a 35% long aramid fiber Polyamide. This material imparts excellent wear resistance along with impact and modulus properties that can only be achieved through the use of long fiber technology.

Product information Resin Identification Part Marking Code	PA66-LAF35 >PA66-LAF35<		ISO 1043 ISO 11469
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Typical mechanical properties	(0000		
Tensile modulus	10300		ISO 527-1/-2
Tensile stress at break, 5mm/min Tensile strain at break, 5mm/min	1.8	MPa %	ISO 527-1/-2 ISO 527-1/-2
Flexural modulus	8700		ISO 178
Flexural strength		MPa	ISO 178
Charpy notched impact strength, 23°	C 15	kJ/m²	ISO 179/1eA
Izod notched impact strength, 23°C		kJ/m²	ISO 180/1A
Poisson's ratio	0.34 <sup>[C]</sup>		
[C]: Calculated			
Thermal properties			
Temperature of deflection under load,	1.8 MPa 246	°C	ISO 75-1/-2
Physical/Other properties			
Density	1220	kg/m <sup>3</sup>	ISO 1183
Injection			
Drying Recommended	yes		
Drying Temperature		°C	
Drying Time, Dehumidified Dryer	2 - 4	h	
Processing Moisture Content	≤0.2		
Melt Temperature Optimum	290	-	
Min. melt temperature Max. melt temperature	280 305	-	
Screw tangential speed			
Mold Temperature Optimum	110		
Min. mould temperature		°C	
Max. mould temperature	120	°C	
Hold pressure range	50 - 100	MPa	
Characteristics			
Processing	Injection Moulding		
Delivery form	Pellets		

Special characteristics

Heat stabilised or stable to heat, Low wear / Low friction





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Additional information	Preprocessing
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	PA6&PA66 drying requirements: 4 hrs. @80° C. A dehumidifier or desiccant dryer is recommended.
	Processing
	Celstran can be processed on a standard injection molding unit. A general purpose metering screw is recommended with a zone distribution of 40% feed, 40% transition, and 20% metering. A free flowing check ring assembly is recommended.
	Melt Temp: 305-310°C. Mold Temp: 85- 95°C.
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

Note: Material can be over dried and may discolor.

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Page: 2 of 2

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