

# CELSTRAN® PA66-GF30-02 AD3002 BLACK

## CELSTRAN® Long Fibre

30% long glass fiber reinforced, heat stabilized, Nylon 6/6

### Product information

Resin Identification	PA66-LGF30	ISO 1043
Part Marking Code	>PA66-LGF30<	ISO 11469

### Typical mechanical properties

Tensile modulus	10200 MPa	ISO 527-1/-2
Tensile stress at break, 5mm/min	140 MPa	ISO 527-1/-2
Tensile strain at break, 5mm/min	1.6 %	ISO 527-1/-2
Flexural modulus	8900 MPa	ISO 178
Flexural strength	220 MPa	ISO 178
Charpy notched impact strength, 23°C	19 kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, 23°C	27 kJ/m <sup>2</sup>	ISO 180/1A
Izod impact strength, -40°C	29.9 kJ/m <sup>2</sup>	ISO 180/1U
Poisson's ratio	0.34 <sup>[C]</sup>	

[C]: Calculated

### Thermal properties

Temperature of deflection under load, 1.8 MPa	252 °C	ISO 75-1/-2
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### Physical/Other properties

Density	1360 kg/m <sup>3</sup>	ISO 1183
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### 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
Ejection temperature	226 °C

### Characteristics

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

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### Additional information

Injection molding

### Preprocessing

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: 290-295°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.

### Automotive

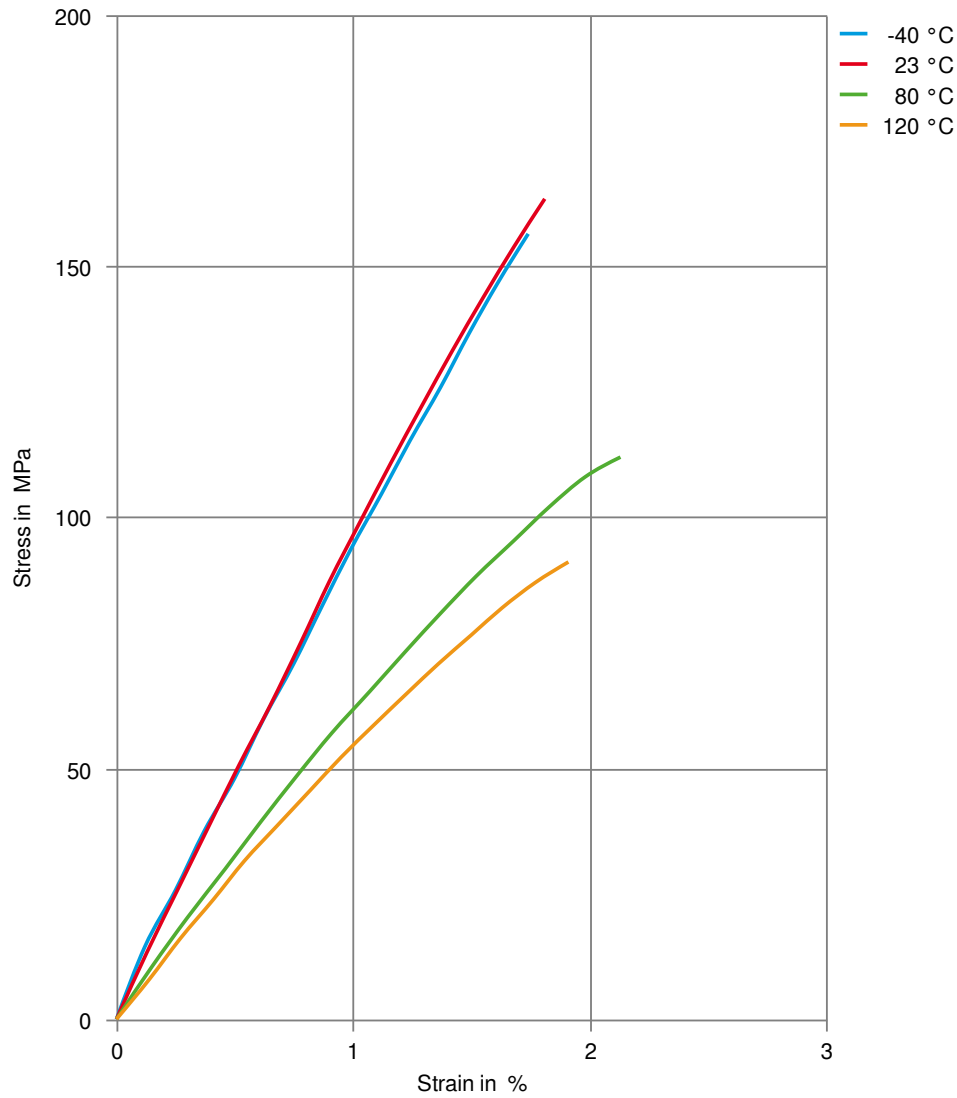
OEM  
Ford

STANDARD  
WSB-M4D677-A

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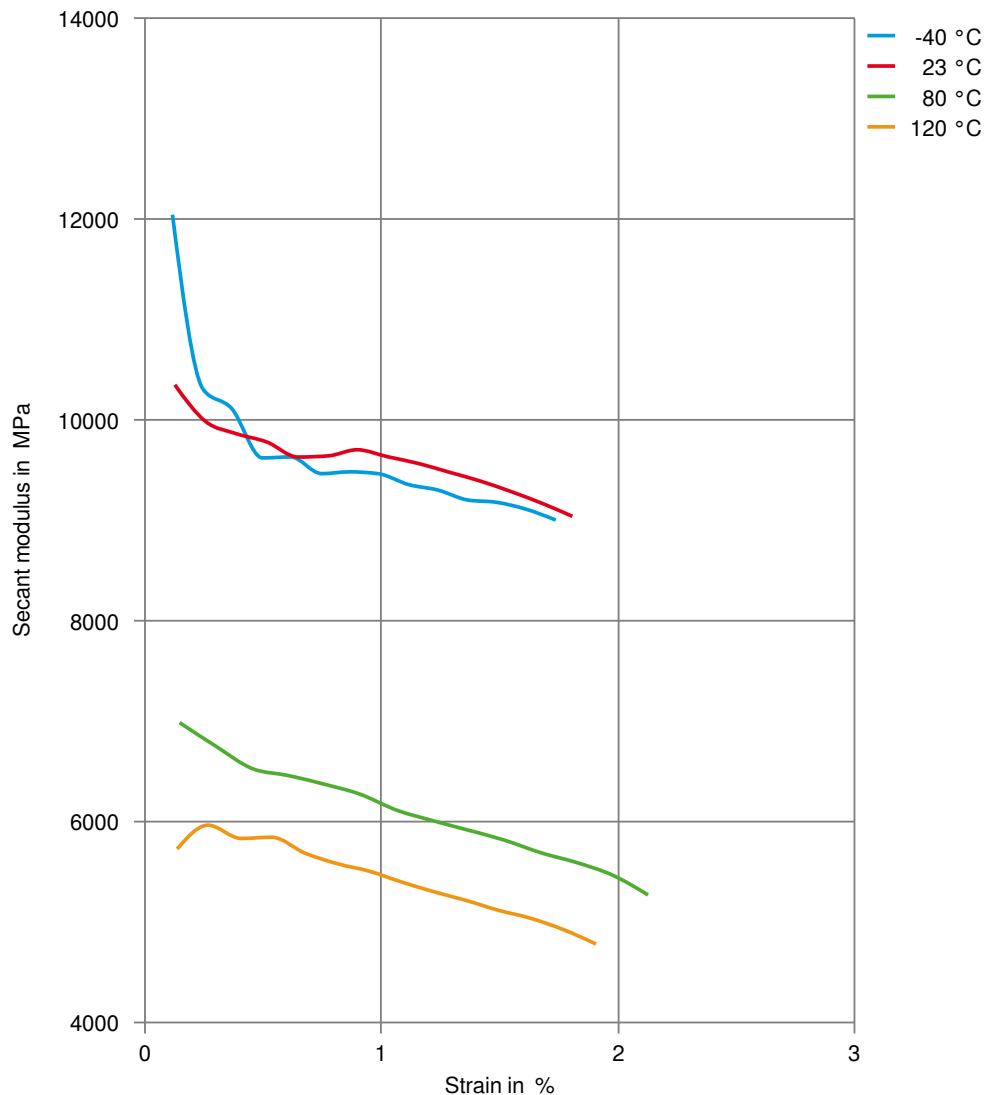
### Stress-strain



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### Secant modulus-strain



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