



## CELSTRAN<sup>®</sup> PA66-GF60-02-NATURAL CELSTRAN® Long Fibre

60% long glass fiber reinforced, heat stabilized, Nylon 6/6

Product information	Prod	uct	infoi	rmati	ion
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Resin Identification Part Marking Code	PA66-LGF60 >PA66-LGF60<		ISO 1043 ISO 11469
Typical mechanical properties			
Tensile modulus Tensile stress at break, 5mm/min Tensile strain at break, 5mm/min Flexural modulus Flexural strength Charpy notched impact strength, 23°C Izod notched impact strength, 23°C Izod impact strength, -40°C Poisson's ratio [C]: Calculated	1.8 18700 470 C 64 66	MPa %	ISO 527-1/-2 ISO 527-1/-2 ISO 527-1/-2 ISO 178 ISO 179/1eA ISO 180/1A ISO 180/1U
Thermal properties			
Temperature of deflection under load,	1.8 MPa 263	°C	ISO 75-1/-2
Physical/Other properties			
Density	1690	kg/m <sup>3</sup>	ISO 1183
Injection			
Drying Recommended Drying Temperature Drying Time, Dehumidified Dryer Processing Moisture Content Melt Temperature Optimum Min. melt temperature Max. melt temperature Screw tangential speed Mold Temperature Optimum Min. mould temperature Max. mould temperature Hold pressure range	2 - 4 ≤0.2 295 285 305 ≤0.2 100	% °C °C °C m/s °C °C °C	
Characteristics			
Processing	Injection Moulding		
Delivery form	Pellets		

Special characteristics Heat stabilised or stable to heat

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(+) **18816996168** Ponciplastics.com



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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: 310-315°C. Mold Temp: 90-100°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 Stellantis - Chrysler	STANDARD MS.50017 / CPN-4329	ADDITIONAL INFORMATION Natural			

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