

## CELANEX® 6400-2 | PBT | Mineral / Glass Reinforced

### Description

40% glass/mineral reinforced polyester, providing warp resistance and improved surface finish.

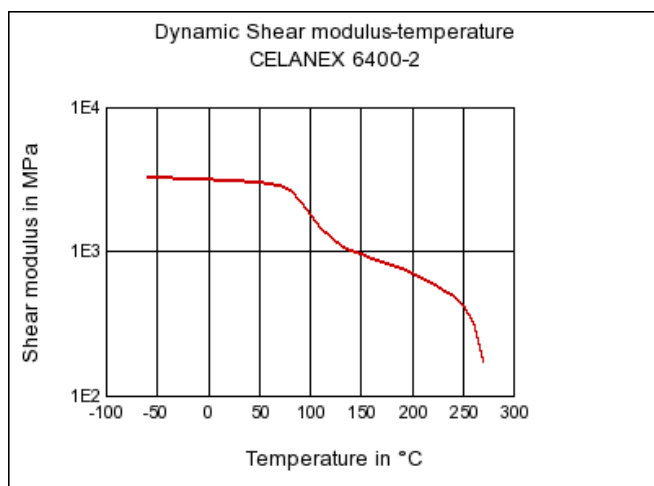
Physical properties	Value	Unit	Test Standard
Density	<b>1660</b>	kg/m <sup>3</sup>	ISO 1183
Mold shrinkage - parallel	<b>0.4 to 0.6</b>	%	ISO 294-4
Humidity absorption (23°C/50%RH)	<b>0.2</b>	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	<b>12000</b>	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	<b>110</b>	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	<b>2</b>	%	ISO 527-2/1A
Flexural modulus (23°C)	<b>11000</b>	MPa	ISO 178
Flexural strength (23°C)	<b>180</b>	MPa	ISO 178
Charpy notched impact strength @ 23°C	<b>6.8</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Notched impact strength (Izod) @ 23°C	<b>6</b>	kJ/m <sup>2</sup>	ISO 180/1A
Notched impact strength (Izod) @ -30°C	<b>6</b>	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
DTUL @ 1.8 MPa	<b>200</b>	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	<b>220</b>	°C	ISO 75-1/-2
Vicat softening temperature B50 (50°C/h 50N)	<b>220</b>	°C	ISO 306
Coeff.of linear therm. expansion (parallel)	<b>0.25</b>	E-4/°C	ISO 11359-2

Test specimen production	Value	Unit	Test Standard
Injection molding melt temperature	<b>250</b>	°C	ISO 294
Injection molding mold temperature	<b>80</b>	°C	ISO 294
Injection molding flow front velocity	<b>300</b>	mm/s	ISO 294

### Dynamic Shear modulus-temperature



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### Typical injection moulding processing conditions



#### Pre Drying:

##### Necessary low maximum residual moisture content: 0.02%

To avoid hydrolytic degradation during processing, CELANEX resins have to be dried to a moisture level equal to or less than 0.02%. Drying should be done in a dehumidifying hopper dryer capable of dewpoints <-40°F (-40°C) at 250°F (121°C) for 4 hours.

For subsequent storage of the material in the dryer until processed (<= 60 h) it is necessary to lower the temperature to 100° C.

#### Drying time: 4 h

#### Drying temperature: 120 - 130 °C

#### Temperature:

	ϑ <sub>Manifold</sub>	ϑ <sub>Mold</sub>	ϑ <sub>Melt</sub>	ϑ <sub>Nozzle</sub>	ϑ <sub>Zone4</sub>	ϑ <sub>Zone3</sub>	ϑ <sub>Zone2</sub>	ϑ <sub>Zone1</sub>	ϑ <sub>Feed</sub>	ϑ <sub>Hopper</sub>
min (°C)	250	65	235	250	240	235	235	230	230	20
max (°C)	260	93	260	260	260	255	255	250	250	50

#### Speed:

#### Injection speed: medium-fast

### Contact Information

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### General Disclaimer

**NOTICE TO USERS:** Values shown are based on testing of laboratory test specimens and represent data that fall within the standard range of properties for natural material. These values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes. Colorants or other additives may cause significant variations in data values.

Properties of molded parts can be influenced by a wide variety of factors including, but not limited to, material selection, additives, part design, processing conditions and environmental exposure. Any determination of the suitability of a particular material and part design for any use contemplated by the users and the manner of such use is the sole responsibility of the users, who must assure themselves that the material as subsequently processed meets the needs of their particular product or use.

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We strongly recommend that users seek and adhere to the manufacturer's current instructions for handling each material they use, and entrust the handling of such material to adequately trained personnel only. Please call the telephone numbers listed (+49 (0) 69 30516299 for Europe and +1 859-372-3244 for the Americas) for additional technical information. Call Customer Services for the appropriate Materials Safety Data Sheets (MSDS) before attempting to process our products.

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