

CELANEX® 6500 | PBT | Mineral / Glass Reinforced

Description

Celanex 6500 is a 30% glass/mineral polyester with improved surface finish and a good balance of mechanical properties and processability.

Physical properties	Value	Unit	Test Standard
Density	1550	kg/m ³	ISO 1183
Mold shrinkage - parallel	0-0.5	%	ISO 294-4
Mold shrinkage - normal	0.5-0.8	%	ISO 294-4
Humidity absorption (23°C/50%RH)	0.19	%	ISO 62

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	9700	MPa	ISO 527-2/1A
Tensile stress at break (5mm/min)	125	MPa	ISO 527-2/1A
Tensile strain at break (5mm/min)	2.2	%	ISO 527-2/1A
Flexural modulus (23°C)	9500	MPa	ISO 178
Flexural strength (23°C)	180	MPa	ISO 178
Charpy impact strength @ 23°C	30	kJ/m ²	ISO 179/1eU
Charpy impact strength @ -30°C	30	kJ/m ²	ISO 179/1eU
Charpy notched impact strength @ 23°C	7.1	kJ/m ²	ISO 179/1eA
Charpy notched impact strength @ -30°C	6.4	kJ/m ²	ISO 179/1eA
Unnotched impact str (Izod) @ 23°C	31	kJ/m ²	ISO 180/1U
Notched impact strength (Izod) @ 23°C	5.3	kJ/m ²	ISO 180/1A
Rockwell hardness	89	M-Scale	ISO 2039-2

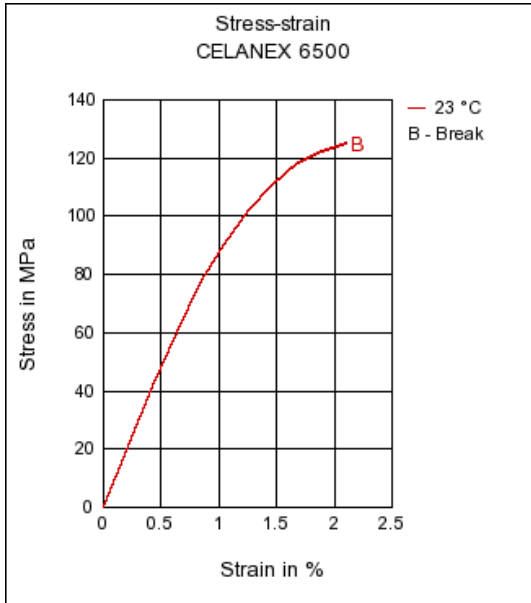
Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	225	°C	ISO 11357-1,-2,-3
Glass transition temperature (10°C/min)	54	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	202	°C	ISO 75-1/-2
DTUL @ 0.45 MPa	223	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	0.28	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	0.85	E-4/°C	ISO 11359-2

Electrical properties	Value	Unit	Test Standard
Relative permittivity - 100 Hz	3.5	-	IEC 60250
Relative permittivity - 1 MHz	3.8	-	IEC 60250
Dissipation factor - 1 MHz	400	E-4	IEC 60250
Volume resistivity	2E14	Ohm*m	IEC 60093
Surface resistivity	3E16	Ohm	IEC 60093
Electric strength	22	kV/mm	IEC 60243-1
Comparative tracking index CTI	325	-	IEC 60112

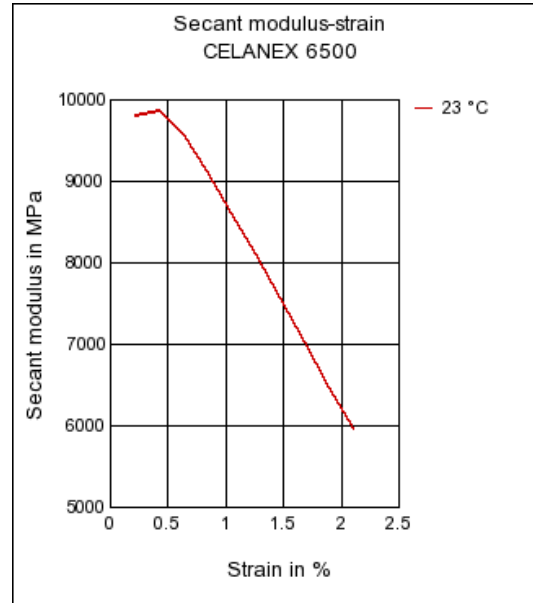
Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	7792-2	-	Internal
Injection molding melt temperature	260	°C	ISO 294
Injection molding mold temperature	82	°C	ISO 294
Injection molding flow front velocity	300	mm/s	ISO 294
Injection molding hold pressure	48	MPa	ISO 294

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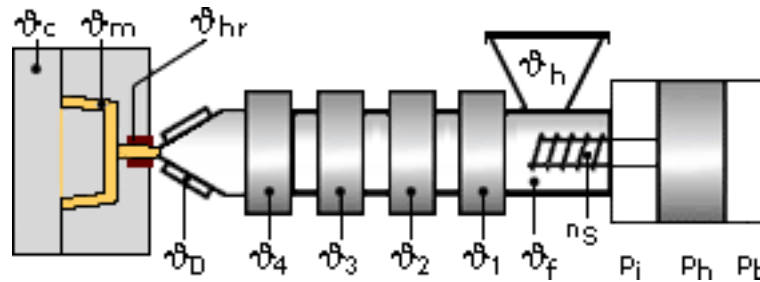
Stress-strain



Secant modulus-strain



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 <math><-40^{\circ}\text{F}</math> (-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

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Temperature:

	ϑ _{Manifold}	ϑ _{Mold}	ϑ _{Melt}	ϑ _{Nozzle}	ϑ _{Zone4}	ϑ _{Zone3}	ϑ _{Zone2}	ϑ _{Zone1}	ϑ _{Feed}	ϑ _{Hopper}
min (°C)	250	65	235	240	240	235	235	230	230	20
max (°C)	265	96	265	265	265	255	255	250	250	50

Speed:

Injection speed: medium-fast

Injection Molding

Rear Temperature	450-480 (230-250) deg F (deg C)
Center Temperature	460-490 (235-255) deg F (deg C)
Front Temperature	470-500 (240-260) deg F (deg C)
Nozzle Temperature	480-510 (250-265) deg F (deg C)
Melt Temperature	460-510 (235-265) deg F (deg C)
Mold Temperature	150-200 (65-93) deg F (deg C)
Back Pressure	0-50 psi
Screw Speed	Medium
Injection Speed	Fast

Injection speed, injection pressure and holding pressure have to be optimized to the individual article geometry. To avoid material degradation during processing low back pressure and minimum screw speed have to be used. Overheating of the material has to be avoided, in particular for flame retardant grades. Up to 25% clean and dry regrind may be used.

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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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