
CELANEX® 4306UV - PBT

Description

Celanex 4306UV is a 30% glass reinforced, toughened, low warpage, UV stable thermoplastic polyester.

Physical properties	Value	Unit	Test Standard
Density	1500	kg/m ³	ISO 1183

Mechanical properties	Value	Unit	Test Standard
Tensile modulus	9200	MPa	ISO 527-2/1A
Tensile stress at break, 5mm/min	100	MPa	ISO 527-2/1A
Tensile strain at break, 5mm/min	1.9	%	ISO 527-2/1A
Charpy notched impact strength, 23 °C	7	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature, 10 °C/min	225	°C	ISO 11357-1/-3
DTUL at 1.8 MPa	121	°C	ISO 75-1, -2

Typical injection moulding processing conditions

Pre Drying	Value	Unit	Test Standard
Necessary low maximum residual moisture content	0.02	%	-
Drying time	4	h	-
Drying temperature	120 - 130	°C	-

Temperature	Value	Unit	Test Standard
Hopper temperature	20 - 50	°C	-
Feeding zone temperature	230 - 240	°C	-
Zone1 temperature	230 - 240	°C	-
Zone2 temperature	235 - 250	°C	-
Zone3 temperature	235 - 250	°C	-
Zone4 temperature	240 - 260	°C	-
Nozzle temperature	250 - 260	°C	-
Melt temperature	235 - 260	°C	-
Mold temperature	65 - 93	°C	-
Hot runner temperature	250 - 260	°C	-

Speed	Value	Unit	Test Standard
Injection speed	medium-fast	-	-

Other text information

Pre-drying

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.

Longer pre-drying times/storage

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

Characteristics

Special Characteristics	Delivery Form
UV resistant	Pellets
Product Categories	Additives
Glass reinforced, Impact modified	Lubricants
