

CELANEX® 4307

30% glass-fiber reinforced; hydrolysis resistant; impact modified PBT grade; for use in nano molding technology (NMT)
 Celanex® 4307 is a 30% glass fiber reinforced PBT resin. It offers excellent physical properties and good adhesion to metal with surface treatment.

Product information

Part Marking Code	PBT-I-GF30	ISO 11469
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Rheological properties

Melt mass-flow rate	10 g/10min	ISO 1133
Melt mass-flow rate, Temperature	250 °C	
Melt mass-flow rate, Load	5 kg	
Moulding shrinkage range, parallel	0.2 - 0.4 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.9 - 1.2 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	8800 MPa	ISO 527-1/-2
Stress at break, 5mm/min	120 MPa	ISO 527-1/-2
Strain at break, 5mm/min	3.5 %	ISO 527-1/-2
Flexural Modulus	8200 MPa	ISO 178
Flexural Strength	188 MPa	ISO 178
Charpy impact strength, 23°C	70 kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	17 kJ/m ²	ISO 179/1eA

Thermal properties

Temp. of deflection under load, 1.8 MPa	190 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	20 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	180 E-6/K	ISO 11359-1/-2

Other properties

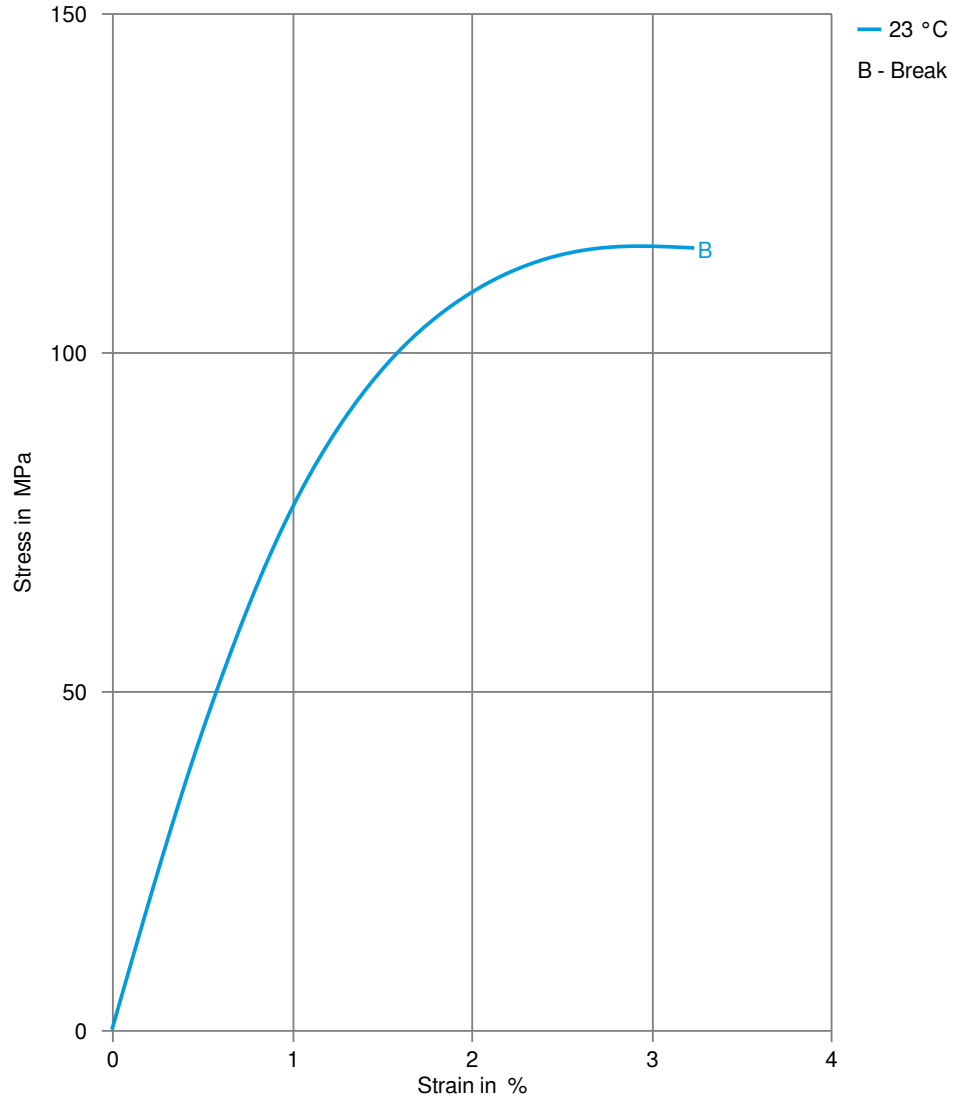
Density	1470 kg/m ³	ISO 1183
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Injection

Drying Temperature	120 °C
Drying Time, Dehumidified Dryer	4 - 6 h
Max. mould temperature	120 - 150 °C
Hold pressure range	50 - 100 MPa
Injection speed	medium

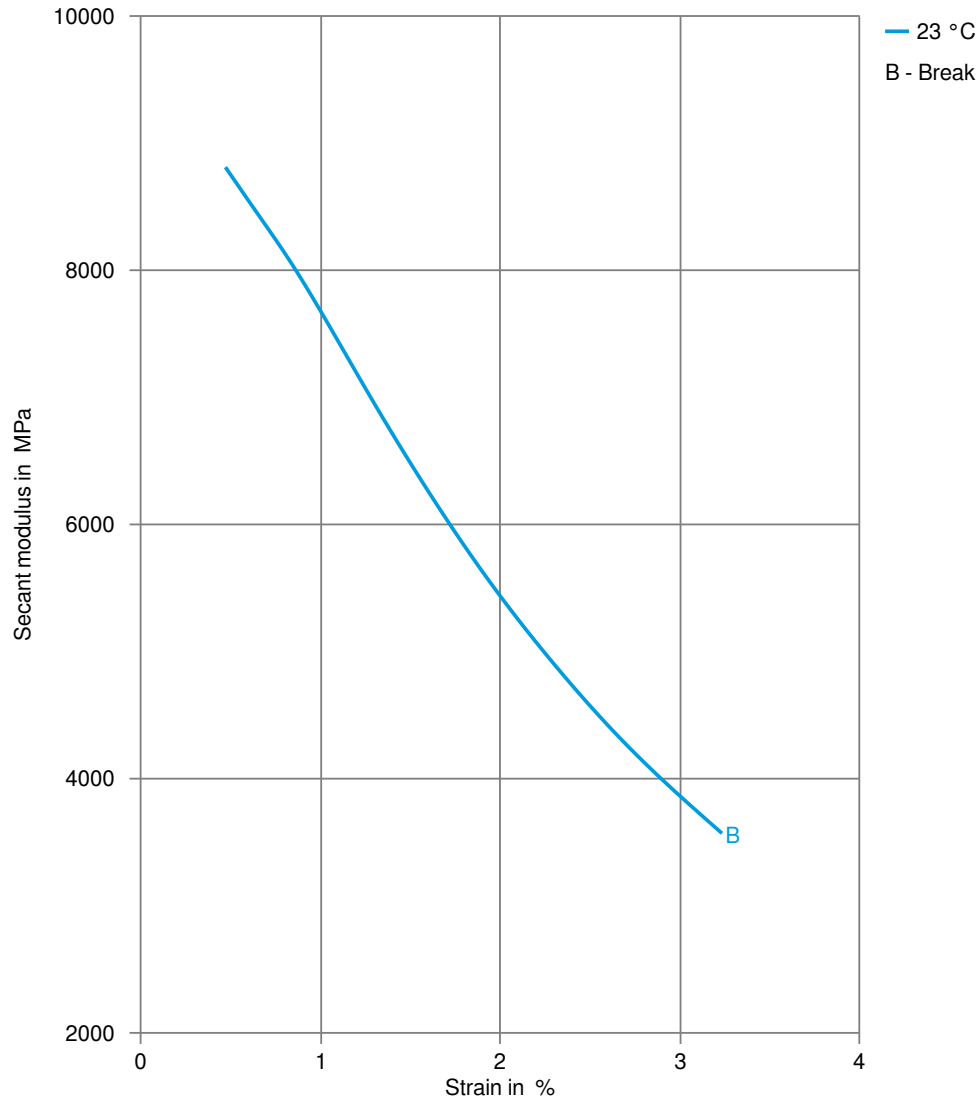
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Stress-strain



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Secant modulus-strain



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Other Approvals

Other Approvals

OEM	Specification	Additional Information
Li Auto	Q/LiA5310038	2021 (V2)