Celanese
The chemistry inside innovation™

CELANEX® 6020GF35

35% glass fiber and glass bead PBT reinforced; low warp grade
Celanex 6020GF35 is a 35% glass fibre / glass bead filled PBT.

Product information

Part Marking Code	PBT-(GF+GB)35		ISO 11469

Rheological properties

Melt volume-flow rate	13	cm^3/10min	ISO 1133
Temperature	250	°C	
Load	2.16	kg	

Typical mechanical properties

Tensile Modulus	9500	MPa	ISO 527-1/-2
Stress at break, 5mm/min	125	MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.8	%	ISO 527-1/-2
Charpy notched impact strength, 23°C	7	kJ/m^2	ISO 179/1eA

Thermal properties

Melting temperature, 10°C/min	225	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.8 MPa	200	°C	ISO 75-1/-2

Other properties

Density	1600	kg/m^3	ISO 1183

Injection

Max. mould temperature	65 - 93	°C

Additional information

Injection molding

Rear Temperature 450-470(230-240) deg F (deg C)
Center Temperature 460-480(235-250) deg F (deg C)
Front Temperature 470-500(240-260) deg F (deg C)
Nozzle Temperature 480-500(250-260) deg F (deg C)
Melt Temperature 460-500(235-260) 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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Processing Texts

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Injection molding Preprocessing	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 <-30°F (-34°C) at 250°F (121°C) for 4 hours.