

CELANEX® 6400-2

40% glass-fiber / mineral filled PBT+PET blend; lubricated; reduced warpage
 40% glass/mineral reinforced polyester, providing warp resistance and improved surface finish.

Product information

Part Marking Code (PBT+PET)-(GF+MD)40 ISO 11469

Rheological properties

Melt mass-flow rate	17 g/10min	ISO 1133
Melt mass-flow rate, Temperature	265 °C	
Melt mass-flow rate, Load	2.16 kg	
Viscosity number	70 cm ³ /g	ISO 307, 1157, 1628
Moulding shrinkage range, parallel	0.1 - 0.2 %	ISO 294-4, 2577
Moulding shrinkage range, normal	0.4 - 0.6 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	12000 MPa	ISO 527-1/-2
Stress at break, 5mm/min	110 MPa	ISO 527-1/-2
Strain at break, 5mm/min	2 %	ISO 527-1/-2
Flexural Modulus	11000 MPa	ISO 178
Flexural Strength	180 MPa	ISO 178
Charpy notched impact strength, 23°C	6.8 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	6 kJ/m ²	ISO 180/1A
Izod notched impact strength, -30°C	6 kJ/m ²	ISO 180/1A

Thermal properties

Temp. of deflection under load, 1.8 MPa	200 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220 °C	ISO 75-1/-2
Vicat softening temperature, 50°C/h, 50N	220 °C	ISO 306
Coeff. of linear therm. expansion, parallel	25 E-6/K	ISO 11359-1/-2

Other properties

Humidity absorption, 2mm	0.2 %	Sim. to ISO 62
Water absorption, 2mm	0.5 %	Sim. to ISO 62
Density	1660 kg/m ³	ISO 1183

Injection

Drying Temperature	120 - 130 °C
Drying Time, Dehumidified Dryer	4 h
Processing Moisture Content	0.02 %
Max. mould temperature	65 - 93 °C
Injection speed	medium-fast

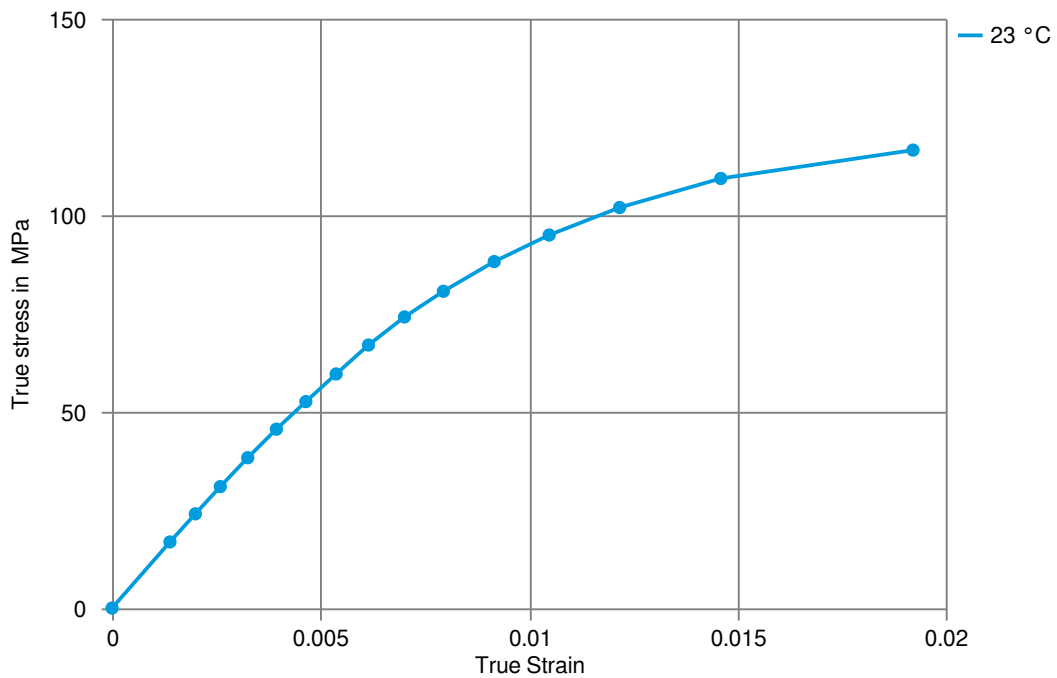
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Characteristics

Additives

Release agent

True stress-strain



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Processing Texts

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.