

CELANEX® 6407

30% glass-fiber / mineral filled PBT+PET blend; improved impact resistant; low warp grade
 Celanex 6407 is a 30% glass/mineral reinforced resin particularly suited for large exterior automotive components, where extended flow, flatness and good surface appearance is essential.

Product information

Part Marking Code	(PBT-I+PET)-GF30	ISO 11469
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Rheological properties

Melt mass-flow rate	21 g/10min	ISO 1133
Melt mass-flow rate, Temperature	265 °C	
Melt mass-flow rate, Load	2.16 kg	
Moulding shrinkage range, parallel	0.3 - 0.6 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.0 %	ISO 294-4, 2577

Typical mechanical properties

Tensile Modulus	8000 MPa	ISO 527-1/-2
Stress at break, 5mm/min	85 MPa	ISO 527-1/-2
Strain at break, 5mm/min	2.1 %	ISO 527-1/-2
Flexural Modulus	8000 MPa	ISO 178
Flexural Strength	140 MPa	ISO 178
Charpy notched impact strength, 23°C	6 kJ/m ²	ISO 179/1eA
Izod notched impact strength, 23°C	6.2 kJ/m ²	ISO 180/1A

Thermal properties

Temp. of deflection under load, 1.8 MPa	172 °C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	209 °C	ISO 75-1/-2
Coeff. of linear therm. expansion, parallel	19 E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	70 E-6/K	ISO 11359-1/-2

Other properties

Water absorption, 2mm	0.1 %	Sim. to ISO 62
Density	1510 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 - 96 °C
Injection speed	medium-fast

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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.

Other Approvals

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OEM	Specification	Additional Information
Stellantis - Chrysler	CPN 3669	Black
GM	GMW17448P-PBT+PET-GF15M15	