

Celanex® 6035GB20

Polybutylene Terephthalate

Celanese Corporation

Message:

20% glass bead filled PBT.

General Information			
Filler / Reinforcement	Glass beads, 20% filler by weight		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.46	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Transverse flow	1.5	%	ISO 294-4
Flow	1.5	%	ISO 294-4
Water Absorption (Equilibrium, 23°C, 50% RH)	0.19	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3300	MPa	ISO 527-2/1A/1
Tensile Stress (Break)	46.0	MPa	ISO 527-2/1A/5
Tensile Strain (Break)	8.5	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	3300	MPa	ISO 178
Flexural Stress (23°C)	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	2.8	kJ/m ²	ISO 179/1eA
23°C	1.7	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	19	kJ/m ²	ISO 179/1eU
23°C	22	kJ/m ²	ISO 179/1eU
Notched Izod Impact (23°C)	3.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	15	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	168	°C	ISO 75-2/B
1.8 MPa, not annealed	72.0	°C	ISO 75-2/A
Glass Transition Temperature	50.0	°C	ISO 11357-2
Melting Temperature ¹	225	°C	ISO 11357-3
Linear thermal expansion coefficient			ISO 11359-2
Flow	7.7E-5	cm/cm/°C	ISO 11359-2

Lateral	7.7E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+17	ohms	IEC 60093
Volume Resistivity	3.0E+16	ohms·cm	IEC 60093
Dielectric Strength	30	kV/mm	IEC 60243-1
Relative Permittivity			IEC 60250
100 Hz	3.70		IEC 60250
1 MHz	3.50		IEC 60250
Dissipation Factor (1 MHz)	0.017		IEC 60250
Comparative Tracking Index	275	V	IEC 60112
Injection	Nominal Value	Unit	
Suggested Max Regrind	25	%	
Hopper Temperature	20 - 50	°C	
Rear Temperature	230 - 240	°C	
Middle Temperature	235 - 250	°C	
Front Temperature	235 - 250	°C	
Nozzle Temperature	250 - 260	°C	
Processing (Melt) Temp	235 - 260	°C	
Mold Temperature	65 - 93	°C	
Injection Rate	Fast		
Back Pressure	0.00 - 0.345	MPa	
Injection instructions			
Manifold Temperature: 250 to 260°CZone 4 Temperature: 240 to 260°CFeed Temperature: 230 to 240°C			
NOTE			
1.	10°C/min		

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