

Celanex® 6407

Polybutylene Terephthalate

Celanese Corporation

Message:

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.

General Information			
Filler / Reinforcement	Glass \mineral, 30% filler by weight		
Features	Low warpage		
	Impact resistance, good		
	Good liquidity		
	Excellent appearance		
RoHS Compliance	Contact manufacturer		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.52	g/cm ³	ASTM D792
--	1.51	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)	12 - 30	g/10 min	ASTM D1238
Molding Shrinkage			
Flow	0.30 - 0.40	%	ASTM D955
Vertical flow direction	0.98	%	ISO 294-4
Flow direction	0.30 - 0.60	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8000	MPa	ISO 527-2/1A/1
Tensile Strength			
Fracture, 23°C	86.2	MPa	ASTM D638
Fracture	85.0	MPa	ISO 527-2/1A/5
Tensile Elongation			
Fracture, 23°C	3.0	%	ASTM D638
Fracture	2.1	%	ISO 527-2/1A/5
Flexural Modulus (23°C)	8000	MPa	ISO 178
Flexural Stress (23°C)	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C)	6.2	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	209	°C	ISO 75-2/B

0.45 MPa, annealed	212	°C	ASTM D648
1.8 MPa, not annealed	175	°C	ASTM D648
1.8 MPa, not annealed	172	°C	ISO 75-2/A
Peak Melting Temperature	225	°C	ASTM D3418
Linear thermal expansion coefficient			ISO 11359-2
Flow	1.9E-5	cm/cm/°C	ISO 11359-2
Lateral	7.0E-5	cm/cm/°C	ISO 11359-2
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	120 - 130	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Hopper Temperature	20.0 - 50.0	°C	
Rear Temperature	230 - 250	°C	
Middle Temperature	235 - 255	°C	
Front Temperature	235 - 255	°C	
Nozzle Temperature	240 - 265	°C	
Processing (Melt) Temp	235 - 265	°C	
Mold Temperature	65.0 - 96.0	°C	
Injection Rate	Moderate-Fast		
Injection instructions			

Manifold Temperature: 250 to 265°C Zone 4 Temperature: 240 to 265°C Feed Temperature: 230 to 250°C

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



WECHAT