

CELANEX® DEV 5600-2 (PRELIMINARY)

CELANEX® DEV 5600-2 is a developmental 55% fiber glass reinforced polyester with excellent dimensional stability and mechanical properties.

Rheological properties

Melt mass-flow rate	7.7 g/10min	ISO 1133
Melt mass-flow rate, Temperature	265 °C	
Melt mass-flow rate, Load	2.16 kg	

Typical mechanical properties

Tensile Modulus	20600 MPa	ISO 527-1/-2
Stress at break, 5mm/min	172 MPa	ISO 527-1/-2
Strain at break, 5mm/min	1.4 %	ISO 527-1/-2
Flexural Modulus	20500 MPa	ISO 178
Flexural Strength	266 MPa	ISO 178
Charpy notched impact strength, 23°C	10.9 kJ/m ²	ISO 179/1eA

Thermal properties

Temp. of deflection under load, 1.8 MPa	210 °C	ISO 75-1/-2
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Other properties

Density	1820 kg/m ³	ISO 1183
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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

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.