



Celanex® 2404 MT

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

Celanex 2404MT is an unreinforced, tribologically-modified and nucleated, medium flow PBT grade for injection molding processing.

Celanex 2404MT is a special grade developed for medical industry applications and complies with:

- CFR 21 (177.1660) of the Food and Drug Administration (FDA) and is listed in the Drug Master File (DMF 10047 (US) / 10033 (EU)) and the Device Master File (MAF 443 (US) / 1078 (EU))
- the corresponding EU and national registry regulatory requirements
- biocompatibility in tests corresponding to USP 23 Class VI/ISO 10993
- low residual monomers
- no animal products

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Additive	• Nucleating Agent		
Features	• No Animal Derived Components • Nucleated		
Uses	• Medical/Healthcare Applications		
Agency Ratings	• DMF 10033 • DMF 10047 • FDA 21 CFR 177.1660	• ISO 10993 • MAF 1078 • MAF 443	• USP XXIII, Class VI
RoHS Compliance	• Contact Manufacturer		
Processing Method	• Injection Molding		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.34	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (250°C/2.16 kg)	21	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.6 to 1.9	%	
Flow	1.7 to 2.1	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	377000	psi	ISO 527-2/1A
Tensile Stress (Yield)	8120	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	7.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	19	%	ISO 527-2/1A/50
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	1.6	ft-lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	131	°F	ISO 75-2/A
Glass Transition Temperature ²	140	°F	ISO 11357-2
Vicat Softening Temperature	374	°F	ISO 306/B50
Melting Temperature ²	437	°F	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index	600	V	IEC 60112

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	248 to 266	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Suggested Max Regrind	25	%
Hopper Temperature	68 to 122	°F
Rear Temperature	446 to 464	°F
Middle Temperature	455 to 482	°F
Front Temperature	455 to 482	°F
Nozzle Temperature	482 to 500	°F
Processing (Melt) Temp	455 to 500	°F
Mold Temperature	149 to 199	°F
Injection Rate	Moderate-Fast	
Back Pressure	0.00 to 50.0	psi

Injection Notes

Die Temperature: 250 to 260°C
Feed Temperature: 230 to 240°C
Zone 4 Temperature: 240 to 260°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 10°C/min