



Celanex® 401AC

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

Celanex 401AC is an unreinforced polybutylene terephthalate designed for automotive connector applications. Celanex 401AC exhibits improved heat aging property retention over standard unreinforced grades.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Heat Aging Resistant		
Uses	• Automotive Applications	• Connectors	
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	40	g/10 min	ISO 1133
Molding Shrinkage - Flow	1.8 to 2.0	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	7830	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	8.0	%	ISO 527-2/1A/50
Tensile Strain (Break)	35	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	37	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	334000	psi	ISO 178
Flexural Stress (73°F)	10000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	2.2	ft-lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	81		ISO 2039-2

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	248 to 266	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Hopper Temperature	68 to 122	°F
Rear Temperature	446 to 482	°F
Middle Temperature	455 to 491	°F
Front Temperature	455 to 491	°F
Nozzle Temperature	482 to 509	°F
Processing (Melt) Temp	455 to 509	°F
Mold Temperature	149 to 205	°F
Injection Rate	Moderate-Fast	

Injection Notes

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

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Notes

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