



Celanex® 4306UV

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

Celanex 4306UV is a 30% glass reinforced, toughened, low warpage, UV stable thermoplastic polyester.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Features	• Low Warpage	• UV Resistant	
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.33E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	14500	psi	ISO 527-2/1A/5
Tensile Strain (Break)	1.9	%	ISO 527-2/1A/5
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	3.3	ft-lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	250	°F	ISO 75-2/A
Melting Temperature ²	437	°F	ISO 11357-3

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 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	

Injection Notes

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

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Notes

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

² 10°C/min
