



Celanex® 6400-2

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

40% glass/mineral reinforced polyester, providing warp resistance and improved surface finish.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass\Mineral, 40% Filler by Weight		
Features	• Good Surface Finish	• Warp Resistant	
RoHS Compliance	• Contact Manufacturer		
Automotive Specifications	• FORD WSK-M4D625-A	• GM GMW15702-120013	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.66	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	17	g/10 min	ISO 1133
Molding Shrinkage - Flow	0.40 to 0.60	%	ISO 294-4
Water Absorption (Saturation, 73°F)	0.50	%	ISO 62
Water Absorption (Equilibrium, 73°F, 50% RH)	0.20	%	ISO 62

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.74E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	16000	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.0	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.60E+6	psi	ISO 178
Flexural Stress (73°F)	26100	psi	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	3.2	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact Strength			ISO 180/1A
-22°F	2.9	ft-lb/in ²	
73°F	2.9	ft-lb/in ²	

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (66 psi, Unannealed)	428	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	392	°F	ISO 75-2/A
Vicat Softening Temperature	428	°F	ISO 306/B50
CLTE - Flow	1.4E-5	in/in/°F	ISO 11359-2

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

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Injection	Nominal Value	Unit
Front Temperature	455 to 491	°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 250°C
Zone 4 Temperature: 240 to 260°C

Notes

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