



Celanex® 6402R

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

Celanex 6402R is a 40% Glass/ mineral filled polyester with 25% Post Consumer Recycled content. It is available in natural, black and various colors including metallic colors.

General

Material Status	• Commercial: Active
Availability	• Europe • Latin America • North America
Filler / Reinforcement	• Glass\Mineral, 40% Filler by Weight
Recycled Content	• Yes, 25%
RoHS Compliance	• Contact Manufacturer
Appearance	• Black • Metallized - Colors • Colors Available • Natural Color

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)	22	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	0.50	%	
Flow	0.10	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.96E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	21300	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.1	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.81E+6	psi	ISO 178
Flexural Stress (73°F)	31900	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	3.6	ft·lb/in ²	ISO 179/1eA
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (264 psi, Unannealed)	401	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	250	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Suggested Max Re grind	25	%
Rear Temperature	455 to 491	°F
Middle Temperature	464 to 500	°F
Front Temperature	464 to 500	°F
Processing (Melt) Temp	482 to 509	°F
Mold Temperature	149 to 199	°F
Injection Rate	Fast	
Back Pressure	< 49.3	psi

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Injection Notes

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

Notes

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