



Celanex® 6443R

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

40% glass/mineral reinforced, low warp, general purpose

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	• General Purpose	• Low Warpage	
Uses	• General Purpose		
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties ¹

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1.35E+6	psi	ISO 527-2/1A
Tensile Stress (Break)	11600	psi	ISO 527-2/1A/5
Tensile Strain (Break)	2.5	%	ISO 527-2/1A/5
Flexural Modulus (73°F)	1.25E+6	psi	ISO 178
Flexural Stress (73°F)	19600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	3.6	ft-lb/in ²	ISO 179/1eA
Unnotched Izod Impact Strength (73°F)	3.8	ft-lb/in ²	ISO 180/1U
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.04 in)	HB		UL 94

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

Notes

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