



Vandar® 2500

Celanese Corporation - Polybutylene Terephthalate

Monday, November 4, 2019

General Information

Product Description

Vandar 2500 is an unfilled polyester alloy which exhibits excellent toughness and impact strength. It is specially designed to offer excellent chemical resistance, good colorability and dimensional stability.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Chemical Resistant • Good Colorability	• Good Dimensional Stability • Good Impact Resistance	• Good Toughness
RoHS Compliance	• Contact Manufacturer		

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	13	g/10 min	ISO 1133
Molding Shrinkage			ISO 294-4
Across Flow	1.7 to 2.2	%	
Flow	1.7 to 2.2	%	
Water Absorption (Saturation, 73°F)	0.45	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	210000	psi	ISO 527-2/1A
Tensile Stress (Yield)	5080	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	5.0	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	> 50	%	ISO 527-2/1A/50
Flexural Modulus (73°F)	218000	psi	ISO 178
Flexural Stress (73°F)	7250	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-22°F	4.3	ft·lb/in ²	
73°F	42	ft·lb/in ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-22°F	80	ft·lb/in ²	
73°F	97	ft·lb/in ²	
Notched Izod Impact Strength (73°F)	No Break		ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	104		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (66 psi, Unannealed)	257	°F	ISO 75-2/B
Heat Deflection Temperature (264 psi, Unannealed)	122	°F	ISO 75-2/A
Glass Transition Temperature ²	158	°F	ISO 11357-2
Melting Temperature ²	437	°F	ISO 11357-3
CLTE - Flow	7.2E-5	in/in/°F	ISO 11359-2
CLTE - Transverse	7.4E-5	in/in/°F	ISO 11359-2

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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	464 to 500	°F
Processing (Melt) Temp	455 to 500	°F
Mold Temperature	149 to 205	°F
Injection Rate	Moderate-Fast	

Injection Notes

Feeding zone temperature: 230 to 240°C

Zone4 temperature: 240 to 260°C

Hot runner temperature: 250 to 260°C

Notes

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

² 10°C/min